

## Rakoll® 4020

- Type of Product** Polyurethane based reactive hotmelt
- Product Characteristics**
- No hazardous material (no hazard pictograms requested)
  - good flow properties
  - fast melting
  - high initial strength
  - good cold- and heat resistance (Rakoll® method)
- Typical Applications** It is suitable for all types of edge banding machines and various kinds of edge banding materials via roller- and nozzle application.
- Suitable substrates** Veneer-, solid wood- and plastic edges (ABS, PP, PVC) as well as strong and decorative papers.

### Typical Properties

Property	Value
Base	polyurethane
Colour	natur
Density	approx. 1.10 g/cm <sup>3</sup>
Viscosity at 160 °C (Brookfield HB; Sp29; 10 rpm)	approx. 45.000 mPa.s
Shelf life	9 months

<b>Application Instructions</b>	<p>Roller- and nozzle application units. Application temperature: 120 °C – 150 °C</p> <p>Open time: very short (depending on temperature, amount and substrate)</p> <p>Good results will be achieved if the following conditions are observed:</p> <ul style="list-style-type: none"><li>- Room-, material- and adhesive temperature: 18 – 20 °C</li><li>- Moisture content of wood: 8 – 10 %</li><li>- Relative humidity: 40 – 60 %</li><li>- Feed speed: up to 40 m/min</li></ul> <p>The surfaces of the substrates must be clean, dry and free from oil and grease. The processing temperature during coating should be at 15 °C – 35 °C. Final strength is achieved after approx. 5 - 7 days depending on availability of moisture and temperature.</p> <p>Due to the great variety of materials, proper tests must be done, to determine the suitability of our product.</p>
<b>Cleaning Instructions</b>	<p>For cleaning we recommend Ipatherm Cleaner 13. Cured adhesive can only be removed mechanically. Please contact your local Sales Office.</p>
<b>Typical Packaging</b>	<p>Please contact your local Sales Office for available packaging options.</p>
<b>Storage Conditions</b>	<p>In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above -25 °C and below +35 °C.</p>
<b>Disposal Advice</b>	<p>Please refer to the SDS for disposal instructions.</p>
<b>Safety Advice</b>	<p>Please refer to the SDS for safety advice.</p>

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