

Schmelzkleber K2/486 C

Edgebanding hot melt with high heat resistance

Properties

RAKOLL®-Schmelzkleber K2/486 C is an EVA-based synthetic resin adhesive with high heat resistance, short open time and good working properties.

Application

RAKOLL®-Schmelzkleber K2/486 C is suitable for most types of edge materials which have been tested and approved by the substrate manufacturers for use with hot melt adhesive procedures.

However we advise customers to test RAKOLL®-Schmelzkleber K2/486 C to ensure this product is suitable for their application and the final destination.

Instructions for use

Set up the machine in accordance with the instructions of the machine manufacturer. According to our experience good results will be achieved under the following conditions:

Ambient and substrate temperature	18 ... 20°C
Wood moisture content	8 ... 10%
Application temperature of the adhesive	190 ... 210°C
Feeding speed	at least 20 m/min.

Heat resistance

The heat resistance of RAKOLL®-Schmelzkleber K2/486 C is adequate for all standard requirements of home furniture used in cold, moderate, dry-warm and moist-warm climates.

Heat resistance measured using the RAKOLL®-test method. In a test involving increasing temperatures results in approximately +101°C.

Cleaning

The melting pots should be cleaned at regular intervals and not allowed to go down to much.

Substrates

Edge strips can have very different adhesion properties, even across a certain group of material. Appropriate tests must therefore be carried out, in order to check the suitability of the adhesive.

The recommendations of the substrate manufacturer must also be observed.

Chemical-technical Data

RAKOLL®-Schmelzkleber K2/486

Base: Ethylene-vinyl acetate copolymer (EVA)

Viscosity: approx. 87.000 mPa.s (Brookfield RV, Spindle SC 4-29, at 204°C)

Softening point approx. 115°C (ring + ball, to ASTM E 28)

Labeling

RAKOLL®-Schmelzkleber K2/486 C is not subject to marking regulations pursuant to the German Dangerous Goods Act.

Precautions

Hot melt adhesives release vapours even when the recommended processing temperature is observed. These can irritate the respiratory system. Measures should therefore be taken for the removal of vapours, e.g. by means of an extracting system.

Storage

Store RAKOLL®-Schmelzkleber K2/486 C in a cool and dry place.

Technical stage of development: March 2002

The data of former leaflets which differ from this version are no longer valid.