

Rakoll® supermelt Plus

Type of Product Unfilled edgebanding hot melt adhesive.

Product Characteristics

- long open time
- good tack and high initial strength
- good working and adhesion properties
- can be used at extreme low coat weights

Typical Applications Developed for the bonding of edge materials. It has been thoroughly tested on most application systems on straight edges and soft forming applications.

Suitable substrates Plastic edges (PVC, ABS, PP ...), melamine, HPL, wooden edges, etc. to chipboard or MDF panels.

Typical Properties

Property	Value
Base	Ethylene Vinyl Acetate Copolymer (EVA)
Colour	yellowish, transparent
Viscosity (Brookfield HB, at 204°C)	approx. 54 000 mPa.s
Shelf life	12 months

Application Instructions

Set up the machine in accordance with the manufacturer's instructions.

Recommended working conditions:

- Room, material and adhesive temperature: 18°C – 20°C
- Moisture content of material: 8 – 10%
- Relative humidity: 40 – 60%
- Processing temperature at the applicator roll: 180°C – 200°C
- Feed speed: at least 12 m/min

Edges strips can have very different adhesion properties, even if the base material is the same. For this reason, it is advisable to make trials if the edges are of an unknown type in order to test the suitability of the adhesive. The recommendations given by the edge strip manufacturers should be followed.

The heat resistance of this product is adequate for all normal requirements for home, used in cold, moderate, dry warm and humid climates.

Heat resistance measured using the method in a test involving increasing temperatures and using 3 melamine edges, 1 PVC edge, 1 veneer edge and 2 extruded PVC-ABS edges: approx. 100°C.

During long stops the adhesive temperature should be lowered to 160°C to avoid premature degradation of the hot-melt adhesive characteristics.

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company ("H.B. Fuller") or one of its affiliated entities.

NOTE TO USER: by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.



Cleaning Instructions Please contact your local Sales Office for available cleaning solutions.

Typical Packaging Please contact your local Sales Office for available packaging options.

Storage Conditions In original sealed packaging in a clean and dry conditions at room temperature.

Disposal Advice Please refer to the MSDS for disposal instructions.

Safety Advice At the recommended working temperature, the hot melt will cause burns in contact with skin. Do not inhale fumes that are released at the working temperature. In any case, a suitable exhausting system shall be installed in the working area.
For additional information, please refer to the MSDS for safety advices.

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company ("H.B. Fuller") or one of its affiliated entities.

NOTE TO USER: *by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.*

