

Rakoll® Supermelt Professional

Type of Product Hot melt adhesive.

Product Characteristics

- medium open time
- high green strength
- good adhesion properties and high tack
- high heat resistance

Typical Applications

Suitable for most types of edge materials which have been tested and approved by the substrate manufacturers for use with hot melt adhesive procedures. Especially suited for edge banding with veneer and solid wood edges.

Also suitable for soft forming application and processing centre.

Suitable substrates

Edges of veneer and solid wood, melamine, HPL and thick plastic edges (PVC, ABS, PP ...), etc. to chipboard or MDF.

Typical Properties

Property	Value
Base	Ethylene-vinyl acetate copolymer (EVA)
Colour	pale yellow
Density at 20°C	1.3 g/cm ³
Viscosity (Brookfield HB, Sp27, 20rpm, at 204°C)	approx. 115 000 mPa.s
Shelf life	12 months

Application Instructions

The machine should be adjusted according to the recommendations of the machine manufacturers.

Substrates should perfectly clean and free of dust and grease.

Recommended working conditions:

- Ambient and substrate temperature: 18°C – 20°C
- Wood moisture content: 8 – 10%
- Application temperature of the adhesive: 170°C – 190°C
- Feeding speed: at least 15 m/min

Heat Resistance (according to Rakoll® method): approx. +90°C

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.

During long stops, the adhesive temperature should be lowered to a temperature of 160°C to avoid degradation of the characteristics.

Cleaning Instructions

All residual encrustations of adhesive must be completely cleaned from the melting tank from time to time as they conduct heat poorly and cause a lowering of the adhesive temperature.

Typical Packaging

Please contact your local Sales Office for available packaging options.

Storage Conditions

In original sealed packaging protected from sun, dust, moisture and high temperatures in clean and dry conditions.

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.

Please refer to the MSDS for additional safety advices.

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