Schmelzkleber K4/570

Hot melt adhesive with high heat resistance for edgebanding machines and pre-coating

Properties

RAKOLL®-Schmelzkleber K4/570 is an EVA-based synthetic resin adhesive which is particularly well suited to the pre-coating of edges. Because of its short open time, pre-coating lines can be run at a relatively high feed speed.

Application

RAKOLL®-Schmelzkleber K4/570 is suitable for the pre-coating of edging materials that have been approved by the manufacturers for use with hot melt adhesive procedures.

Instructions for use

Set up the machine in accordance with the instructions of the machine manufacturer.

Good results will be achieved if the following conditions are observed:

Room, material and adhesive temperature	18 … 20°C
Processing temperature at the roller	170°C
Feed speed	at least 10 m/min

Heat resistance

The heat resistance of RAKOLL®-Schmelzkleber K4/570 is adequate for all normal requirements for furniture for use in homes as met in cold, moderate, dry-warm and moist-warm climates.

Heat resistance measured using the RAKOLL® method Test increasing temperatures: approx. +85°C.

Cleaning

The pre-melter and the spreading tools should be cleaned at regular intervals.

Chemical-technical data

RAKOLL®-Schmelzkleber K4/570

Basis:	Ethylene-Vinylacetate copolymer (EVA)
Viscosity: (Brookfield RV, Spindle SC 4-29, +204°C)	approx. 65.000 mPas
Softening point: (ring + ball method based on ASTM E 28)'	approx. +102°C

Labelling

RAKOLL®-Schmelzkleber K4/570 is not subject to marking regulations pursuant to the Dangerous Goods Act in its present version.

Precaution

Hot melt adhesives emit vapours even when the prescribed working temperatures are observed. These can irritate the respiratory organs. Accordingly, measures should be taken to remove vapours, e.g. by the use of a suitable extraction system.

Storage

Store RAKOLL®-Schmelzkleber K4/570 in a cool and dry place.

Technical stage of development: March 2002
The data in former leaflets which differ from this version are no longer valid.