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TECHNICAL DATA SHEET

RAKOLL SK PO 5413

CHARACTERISTICS AND APPLICATIONS:

RAKOLL SK PO 5413 is an APAO based hot-melt adhesive suitable for wrapping MDF, chipboard or solid wood profiles with veneer and continuous laminate (CPL) on a profile wrapping machine.

RAKOLL SK PO 5413 presents good spreading properties and a high heat resistance.

PHYSICAL PROPERTIES:

Characteristics	Value	Unit	Internal Method	Adapted Standard
Viscosity (Brookfield HB; 204 °C)	Approx. 54 000	mPa.s	IPRO 00 04	ASTM D 3226
Softening point (Ring and ball)	Approx. 155	°C	IPRO 00 02	ASTM E 28

INSTRUCTIONS FOR USE:

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

The materials should be free from dust and grease.

The material and the operation conditions can influence significantly the bonding results.

WORKING CONDITIONS

Room and material temperature	Ⓐ	18-20 °C
Temperature at the applicator roll	Ⓐ	200 - 210 °C
Glue spread	Ⓐ	120 -180 g/m ²
Feed speed	Ⓐ	at least 15 m/min

Considering the sort of materials and the differences stated on the adhesion proprieties, it is advisable to make preliminary trials so that the good working conditions can be determined.

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.

HAZARDOUS INFORMATIONS:

At the recommended working temperature the hot-melt will give off fumes, which can irritate the respiratory organs. If the working temperature is exceeded over a long period, harmful decomposition products will form.

In any case an appropriate exhausting system shall be installed in the working area.

STORAGE:

RAKOLL SK PO 5413 should be stored in closed original containers and at room temperature. In these conditions the glue can be conserved for, at least, 12 months without changing its properties.

All information in this technical data sheet is given in good faith, based on our research and practical experience. Whilst we guarantee the constant quality of our products we cannot be responsible for the results obtained in their use, since the conditions of use and working methods are beyond our control.

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