
RAKOLL^â PUS 3500

TYPE OF PRODUCT:	Polyurethane-based reactive hotmelt
AREAS OF APPLICATION:	Bonding of wooden material, metal, glass, textiles, PUR-foams, plastics like PVC, ABS, PC,.. aluminium and metallfoils,....
SPECIAL PROPERTIES:	High initial strength, long open time. Excellent adhesion on various plastics. High thermal stability and good flexibility after complete curing.

PRODUCT SPECIFICATION

DENSITY:	approx. 1.2 g/cm ³ (20°C)
VISCOSITIES:	approx. 25 000 mPas (110°C)
COLOUR:	yellowish
HAZARDOUS GOODS CLASSIFICATION:	see Material Safety Data Sheet / label
SHELF LIFE:	Minimum 6 months from date of production – see label

INSTRUCTIONS FOR USE

OPEN TIME:	Up to 6 minutes, depending on application procedure, application thickness and substrate
WORKING TEMPERATURE:	Application temperature approx. 90 -130°C
APPLICATION PROCEDURE AND TYPE OF APPLICATOR:	Drum, pail and bag unloaders in combination with nozzle-, coating roller- and/or screen printing systems.
COVERAGE:	Dependent on application, 40-100g/m ² depending on application system and substrate.
CLEANING AGENT:	IPATHERM [®] -Cleaner 12 for uncured adhesive. Cured adhesive can only be removed mechanically.

WORKING INSTRUCTIONS

PRETREATMENT OF BONDING SURFACES

Bonding surfaces have to be clean, dry and free of grease and oil.
Polyolefin materials have to be corona-pretreated or flame-treated.

PREPARATION

Drum unloader, heating plate, conveyor pump and applicator gun can, as a rule, be set to different temperatures. Excessive heat may cause decomposition of the adhesive. Depending on the construction of the equipment, a temperature of 110°C is sufficient for the heating plate and the conveyor pump. Due to the short operation time, the application equipment may be run at temperatures of up to 140°C. For tank melters only protective gases with < 5ppm humidity should be used. Positive results have been achieved with nitrogen.

Please take care of that packages are used immediately after opening in order to prevent possible reactions with moisture

ADHESIVE APPLICATION

RAKOLL^â PUS 3500 is either applied in beads or tapes or as a sheet onto one of the bonding surfaces. Bonding is carried out immediately upon application.

SPECIAL ATTENTION

Final cure is achieved by reaction with ambient moisture or moisture from the substrate. Curing time depends on the access of humidity to the bonding seam, i.e. the humidity of the substrate, substrate permeability, adhesive film thickness, relative air humidity and ambient temperature. Average curing time for bonding onto wooden materials at a temperature of 20°C and relative humidity of 65% amounts to up to 3-4 days. If large surfaces and/or impermeable materials are bonded under unfavorable climatic conditions, the curing time may be considerably longer.

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Please note:

The information, specified in this Product Information, is based on careful laboratory tests and prevailing practical experience.

The information is not binding, which is also generally true for our practical customer service, given verbally, in writing and by tests, since, on account of the versatility of applications and use, also including possible industrial property rights of third parties, we cannot assume any responsibility.

Analysis results and all information regarding state and suitability of our products are only guidelines with no obligation on our part, unless they have been guaranteed expressly in writing, and above all do not represent a guarantee for specific properties.

We advise determining the suitability of our products with respect to their suitability for the intended use and application technology by adequate further testing.

In addition to the above, our General Sales and Delivery Conditions are applicable.

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