

PU S 9654 B

Polyurethane Hot Melt Adhesive for Profile Wrapping and Straight edgebanding

Properties

RAKOLL®-PU S 9654 B is a polyurethane-based hot melt adhesive with a short open time which can be processed at relatively low temperatures. As with all hot melts the adhesive sets on cooling and shows good initial strength. Crosslinking takes place during storage with ambient water or humidity from substrates, which therefore have to be permeable to moisture. After total crosslink the bonding is no longer reversible. The bonding achieved is usually highly elastic, cool flexible and highly resistant to heat and water.

Melting temperature	100 °C... 130 °C
Processing temperature (at the roller)	100 °C ... 130 °C
Feed speed	
- wrapping:	up to 80 m/min
- edge banding:	12 ... 20 m/min
Coat weight	
- wrapping:	30 ... 80 g/m ²
- edge banding:	100 ... 120 g/m ²

Applications

- RAKOLL®-PU S 9654 B is suitable for most types of edge materials which have been tested and approved by the substrate manufacturers for use with hot melt adhesive procedures.
- However we strongly advise customers and potential customers to test RAKOLL®-PU S 9654 B to ensure the product is suitable for their applications and their end users use.
- RAKOLL®-PU S 9654 B is suitable for all types of wrapping machines and straight line edgebanding machines (not to exceed 25 m/min).

Instructions for use

Set up the machine in accordance with the instructions of the machine manufacturer. As polyurethane adhesives can react with moisture from the environment, they must be melted under the exclusion of humidity. Avoid excess heating or temperature peaks as this may deteriorate the adhesive. The molten adhesive is applied using rollers or nozzles.

Cleaning

The melting pots should be cleaned at regular intervals. Crosslinked (cured) adhesive can only be removed by mechanical means. Teflon® or ChemCoat® coatings of the equipment have proved beneficial.

Chemical-technical data

RAKOLL®-PU S 9654 B

Basis:	Polyurethane
Colour:	white
Density:	approx. 1,10 g/cm ³
Viscosity:	approx. 35.000 mPa.s (Brookfield RV, Spindle SC 4-29, at +120 °C)

Heat resistance

Heat resistance as measured with RAKOLL®-PU S 9654 B test method, Raising Temperature results in values greater than 120 °C. As with all polyurethanes the thermal stability of the polymer is limited to 170 °C to 180 °C. Prolonged storage at higher temperature levels will cause decomposition of the adhesive.

Water resistance

Substrates bonded with RAKOLL®-PU S 9654 B passed the water Resistance Test with immersion in water for several days. However the bond must be tightly closed and must cover the entire mat surface.

The melter may be cleaned using Ipatherm® Cleaner 13.

Information on hazardous substances

RAKOLL®-PU S 9654 B contains small amounts of isocyanate. For this reason, please observe the information in our EC Safety Data Sheet! (Please request!)

Vapours emitted must always be removed by extraction!

Storage

Store RAKOLL®-PU S 9654 B in a cool and dry place. The shelf life is at least 6 months.

Technical stage of development: January 2009

The data of former leaflets which differ from this version are no longer valid.



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OBSERVATIONS

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