

Surewrap Plus

Unfilled Wrapping Hotmelt Adhesive based on Polyolefine

Properties

RAKOLL®-Surewrap Plus is an APAO based hotmelt adhesive suitable for wrapping MDF, chipboard or solid wood profiles with paper foil and veneer on a profile wrapping machine. RAKOLL®-Surewrap Plus presents good spreading properties, a high heat resistance and good adhesion properties.

Application

- Wrapping of chipboard, MDF and solid wood profile cores with decorative finishing films and veneers.

RAKOLL®-Surewrap Plus is suitable for most types of wrapping substrates, e. g. paper and veneer that have been tested and approved by the manufacturers.

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.

Good results will be achieved under the following conditions:

Room, material and adhesive temperature	18 ... 20 °C
Moisture content of wood	8 ... 10 %

Processing temperature at the application roller	190 ... 200 °C
Application quantity	60 ... 120 g/m ²
Feed speed (when using slower machines, the coat weight has to be increased)	at least 15 m/min

Cleaning

The melting pots should be cleaned at regular intervals and not allowed to go down too much.

Chemical-technical data

RAKOLL®-Surewrap Plus

Basis:	Polyolefine (PO)
Density:	approx. 0,95 g/m ³
Viscosity: (Brookfield HB, Spindle SC 4-27, at +204 °C)	approx. 5.300 mPa.s
Softening point: (ring + ball method based on ASTM E 28)	approx. +140 °C

Heat resistance

The heat resistance of wrapped profiles depends amongst other factors on the sub-strates, the shape of the profile and on the quality of gluing. No general statement can therefore be made regarding the heat re-sistance.

In tests with increasing temperature, measurements taken in practice on profiles wrapped with decorative finishing films were found to reach average values of approx. 120 °C.

Labelling

RAKOLL®-Surewrap Plus is not subject to marking regulations pursuant to the Dangerous Goods Act in its present version.

Labelling

Hot melt adhesives release vapours even when the recommended processing temperature is observed. These vapours can irritate the respiratory system. Measures should therefore be taken for the removal of vapours, e.g. by means of an extracting system.

Storage

Store RAKOLL®-Surewrap Plus in closed original containers in a cool an dry place. Shelf life is at least 12 months.

Technical stage of development: April 2007

The data of former leaflets which differ from this version are no longer valid.



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