



# H.B. Fuller

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## TECHNICAL DATA SHEET

# RAKOLL TE 5707

### CHARACTERISTICS AND APPLICATIONS:

**RAKOLL TE 5707** is an EVA based adhesive with good melting flowing properties and it can be used on edgebanders with PVC, melamine and veneers edges.

**RAKOLL TE 5707** is also suitable for bonding PVC edges on round panels with the application on the edge side and for works with low-speed edgbanders .

**RAKOLL TE 5707** presents a long open-time.

### PHYSICAL PROPERTIES:

Characteristics	Value	Unit	Internal Method	Adapted Standard
Viscosity (Brookfield HB; 150 °C)	Approx. 37 500	mPa.s	I PRO 00 04	ASTM D 3226
Softening point (Ring and ball)	Approx. 82	°C	I PRO 00 02	ASTM E 28

### INSTRUCTIONS FOR USE:

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

**RAKOLL TE 5707** can be processed in the usual way. Good results can be obtained under the following conditions:

### WORKING CONDITIONS

Room and materials temperature	▷	18 - 20 °C
Wood moisture	▷	8 - 10 %
Temperature of the applicator wheel	▷	150 - 180 °C
Feed speed	▷	5 to 20 m/min

Edges strips can have very different adhesion properties, even if the base material is the same. For this reason, it is advisable to make trials if the edges are of an unknown type in order to test the suitability of the adhesive. The recommendations given by the edge strip manufacturers should be followed.

During long stops, the adhesive temperature should be lowered to 140 °C to avoid degradation of the characteristics. 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.

**RAKOLL TE 5707** is available on natural, white, brown and black colours.

### 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 TE 5707** should be stored in closed original containers in a cool and well-ventilated place. 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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