

Schmelzkleber U 290

Profile wrapping hot melt adhesive for decor finishing films

Properties

RAKOLL®-Schmelzkleber U 290 is an EVA-based synthetic resin adhesive with a short open time, low viscosity, relatively high heat resistance and very good wetting properties, even on difficult decor finishing films.

Application

- Wrapping profile cores made from chipboard, MDF board and solid wood with decor finishing films, including thin paper films.

Instruction for use

The type and properties of the materials and the working conditions can have a considerable influence on the bonding.

According to our experience good results will be achieved if the following conditions are observed:

Room,- material and adhesive temperature	18 ... 20°C
Wood moisture content	8 ... 10%
Processing temperature (at the roller)	160 ... 180°C
Application amount	70 ... 100 g/m ²
Feed speed	at least 20 m/min

Cleaning

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

Chemical-technical data

RAKOLL®-Schmelzkleber U 290

Basis:	Ethylene-vinyl acetate copolymer (EVA)
Density:	approx. 1,14 g/cm ³
Viscosity:	approx. 4.000 mPa.s (Brookfield RV, spindle SC 4-29, at +204°C)
Softening point:	approx. +85°C (ring + ball method based on ASTM E 28)

Heat resistance

The heat resistance of wrapped profiles largely depends on the materials being bonded, the shape and size of the profile and the gluing procedure followed. For this reason, no general information can be given on the heat resistance.

In a test with increasing temperature, profiles wrapped in practise showed a heat resistance of 70 ... 75°C.

Labelling

RAKOLL®-Schmelzkleber U 290 is not subject to marking regulations pursuant to the German Dangerous Goods Act in its present version.

Precaution

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

Storage

Storage RAKOLL®-Schmelzkleber U 290 in a cool and dry place.

Technical stage of development: June 2002

The data in former leaflets which differ from this version are no longer valid.