

Schmelzkleber U 320

Filler-free hot melt wrapping adhesive for decorative finish films

Properties

RAKOLL®-Schmelzkleber U 320 is a filler-free EVA based synthetic resin adhesive with a short open time, low viscosity and relatively high heat resistance, as well as very good wetting qualities which also apply to difficult decorative finishing films.

Application

- Cladding of chipboard, MDF and solid wood profile cores with decorative finishing sheets and thin paper films as well as with Alkorcell.

Instructions for use

Set up the cladding machine in accordance with the instructions of the machine manufacturer.

The type and quality of the materials can greatly influence the gluing, as can the working conditions.

Good results will be achieved under the following conditions:

Room and material temperature 18 ... 20°C

Moisture content of wood 8 ... 10%

Processing temperature 160 ... 180°C
(at the roller)

Application quantity 70 ... 100 g/m²

Feed speed at least 20 m/min

Cleaning

The melting vessels should be cleaned at regular intervals.

Chemical-technical data

RAKOLL®-Schmelzkleber U 320

Basis: Ethylene vinylacetate copolymer (EVA)

Density: approx. 0,98 g/cm³

Viscosity: approx. 5.500 mPa.s
(Brookfield RV, Spindle SC 4-29, at +204°C)

Softening point: approx. +81°C
(ring + ball method based on ASTM E 28)

Heat resistance

The heat resistance of wrapped profiles depends primarily on the glued materials, the shape and size of the profiles and on the gluing procedure. No general statement can therefore be made regarding the heat resistance.

In tests with increasing temperature, the heat resistance achieved on profiles wrapped in practice were found to lie around 70°C

Labelling

RAKOLL®-Schmelzkleber U 320 is not subject to marking regulations pursuant to the current version of the Dangerous Goods Act.

Precaution

Hot melt adhesives release vapours even when the prescribed processing temperatures are observed. These can irritate the respiratory organs. Measures should therefore be taken for the elimination of vapours, e.g. through the use of a suitable extraction system.

Storage

Store RAKOLL®-Schmelzkleber U 320 in a cool and dry place.

Technical stage of development: March 2002

The data of former leaflets which differ from this version are no longer valid.