

Rakoll® 4933

- Type of Product** One component D3 PVAc adhesive.
- Product Characteristics**
- Formaldehyde free adhesive
 - Low VOC (Volatile Organic Content)
 - Good water resistance
 - Quick setting time
 - Bonded joints with good high-temperature resistance
 - Classification according to EN 204: load group D3 and EN 14257 (WATT91) as one-component system (ift certified)
 - Classification according with GEV requirements: Emicode EC1 ^{Plus} (Fraunhofer WKI certified)
 - Does not discolour at high temperatures
- Typical Applications** This product can be used for a variety of applications including:
- surface gluing of decor-finish film
 - veneering
 - high-frequency bonding
 - surface bonding of HPL/CPL in short cycle presses
 - carcass and assembly gluing
 - bonding joints in boards and block gluing of softwoods and chipboard as well as hardwoods
- Suitable substrates** Wood and wood-based materials.

Typical Properties

Property	Value
Colour	white
pH	4
White point	approx. 5°C
Viscosity (Brookfield RV – Type; Sp5; 20rpm; at 20°C)	approx. 13 000 mPa.s
Shelf life	12 months

Application Instructions

Apply Rakoll® 4933 thinly and evenly to one side or, if a high degree of water resistance is required, to both sides, using a spreading machine, glue roller, serrated trowel, glue brush or another suitable device.

Good results will be achieved if the following conditions are observed:

Room and material temperature	18°C – 20°C
Moisture content of wood	8 – 10%
Relative humidity	40 – 60%
Amounts of adhesive to apply:	
For surface bonding	30 – 120 g/m ²
For assembly gluing	160 – 180 g/m ²
Open time at 150 g/m ²	8 – 12 minutes

Open time and setting time: strongly depend on working conditions such as temperature, humidity, absorbency of the materials being worked, and amounts applied.

Laminating of wooden window profiles:

In accordance with the Quality Guidelines of i.f.t., “Laminated Profiles for Wooden Windows”, the wood moisture content must be 13 +/- 2%. The room temperature and the wood temperature must be at least +15°C.

Wood preparation:

All parts should mate well and be dust and grease free. Over tolerances will lead to longer setting times and weaker bonds. The joints should be cut shortly before bonding.

IMPORTANT: Information, specifications, procedures and recommendations provided (“information”) are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser’s sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company (“H.B. Fuller”) or one of its affiliated entities.

NOTE TO USER: *by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller’s liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.*



Application Instructions**Presses:**

Lay the items to be bonded together within the workable time and press them for as long a time as is needed to achieve the required initial firmness upon release. The pressure should be high enough to ensure contact of the parts over the entire area of the joint. Depending on the material and the type of bond being used, the mechanical firmness required for further processing of the parts is achieved within the shortest possible space of time. The higher levels of water resistance form more slowly and should be tested not earlier than 7 days after bonding.

Cleaning Instructions

Clean machine and tools with warm water before the adhesive dries.

Typical Packaging

Please contact your local Sales Office for available packaging options.

Storage Conditions

In original sealed packaging in clean and dry conditions above +5°C and below +35°C.
Store this product away from frost.

Disposal Advice

Please refer to the MSDS for disposal instructions.

Safety Advice

Please refer to the MSDS for safety advice.

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company ("H.B. Fuller") or one of its affiliated entities.

NOTE TO USER: by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.

