

Schmelzkleber K 4/581 LV

Edgebanding hot melt

Properties

RAKOLL®-Schmelzkleber K 4/581 LV is an EVA-based, synthetic resin adhesive. It has good working properties, melts and flows well.

Application

RAKOLL®-Schmelzkleber K 4/581 LV is suitable for most types of edge materials which have been tested and approved by the substrate manufacturers for use with hot melt adhesive procedures.

However we advise customers to test RAKOLL®-Schmelzkleber K 4/581 LV to ensure this product is suitable for their application and the final destination.

Instructions for use

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

According to our experience good results will be achieved under the following conditions:

Ambient and substrate temperature	18 ... 20°C
Wood moisture content	8 ... 10%
Application temperature of the adhesive	190 ... 210°C
Feeding speed	at least 20 m/min.

Cleaning

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

Heat resistance

The heat resistance of RAKOLL®-Schmelzkleber K 4/581 LV is adequate for all standard requirements of home furniture used in moderate and cold climates. Heat resistance as measured with RAKOLL®-test method. Raising-temperature is approx. 82°C.

Substrates

Edging strips can have very different adhesion properties, even across a certain group of material. Appropriate tests must therefore be carried out, in order to check the suitability of the adhesive. The recommendations of the substrate manufacturer must also be observed.

Chemical-technical data

RAKOLL®-Schmelzkleber K 4/581 LV

Basis:	Ethylene vinyl acetate copolymer (EVA)
Viscosity:	approx. 80.000 mPa.s (Brookfield RV, Spindle SC 4-29, at +204°C)
Softening point:	+95 - +105 °C (Ring + Ball method based on ASTM E 28)

Labeling

RAKOLL®-Schmelzkleber K 4/581 LV 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 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 extraction system.

Storage

Store RAKOLL®-Schmelzkleber K4/581 LV in a cool and dry place. The shelf life is at least 12 months.

Technical stage of development: August 2011

The data of former leaflets which differ from this version are no longer valid.



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OBSERVATIONS

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