



Rakoll[®] smartpress Plus TG

Type of Adhesive One component Membrane press adhesive.

Product Benefits

- good adhesion properties
- one component, no need to mix with a hardener
- can be readily sprayed and provides a good and even coating

Typical Applications Bonding of thermolaminates on shaped parts in membrane presses as well as in non-membrane presses.

Suitable substrates PVC foil or other laminates on shaped parts made of wood or plastic.

Typical Properties

Property	Value
Base	PUR dispersion
Colour	white
pH	approx. 9
Viscosity at 20°C	Brookfield RV, Spindle 4, 20 rpm approx. 1 900 mPa.s
Shelf life	6 months



Application Instructions

Application with spraying gun.

All surfaces must be clean and free from grease and dust.

Application method:

This product is best applied using HVLP (High Volume Low Pressure) spray guns, nozzle diameter 0.8 – 1.5 mm.

The quantity of adhesive to be applied depends on the type of material and the shape of the parts. It can vary within a wide range and can only be determined by trials for a given set of variables.

- on the edge and moulded parts: 40 – 60 g/m²
- on the surface: 20 – 40 g/m²

Drying:

The adhesive should be allowed to dry completely.

The required drying time is affected by external factors, such as room climate, quantity applied, absorbency of the material, etc.

For normal temperatures, 20 minutes to one hour can be assumed.

Heat and/or air motion reduce the drying time.

Press conditions:

The pressing conditions depend on factors such as the thickness of the thermolaminate (and its stiffness), the shape of the part to be coated, etc.

They must be adapted to the situation.

Reactivation of the glue line should be possible for up to 4 days after application of the adhesive.

Starting values for trials:

- Membrane temperature: 80 – 120°C
(Not identical with the temperature setting of the press!)
- Press pressure: 4 – 6 bar
- Recommended reactivation temperature in the glue line:
approx. 60°C
- Press cycle: 80 – 120 sec

Final strength of the bond is achieved after several days. The initial strength is adequate for careful processing.

Heat resistance:

The heat resistance of the manufactured pieces depends amongst other factors on the glued materials and the shape of the profiles. No general statement can therefore be made regarding the heat resistance.

Heat resistance performs to BS 6222 testing and typically 80°C European Rising Heat Tests.



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TECHNICAL DATA SHEET

Cleaning Instructions	Clean application tools with water before the adhesive dries. After crosslinking, it can only be removed by mechanical means.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above 10°C and below 30°C. Do not allow the product to freeze!
Disposal Advice	Please refer to the MSDS for disposal instructions.
Safety Advice	Please refer to the MSDS for safety advice.

Our Focus is Clear. Perfecting Adhesives.

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