

TECHNICAL DATA SHEET – SEPTEMBER 2011

RAKOLL® BAZ 3000

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For processing centre and straight edgebanding of solid wood strips

Properties

RAKOLL® BAZ 3000 is a high viscosity, EVA-based, synthetic resin adhesive. It has good adhesion properties, particularly suited for the use on processing centres and on edge banding machines for the gluing of solid wood. It can be cleanly applied without stringing.

Application

RAKOLL® BAZ 3000 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® BAZ 3000 to ensure this product is suitable for their application and the final destination.

Chemical-technical data

Base:	Ethylene vinyl acetate copolymer (EVA)
Viscosity:	Approx. 190,000 mPa.s (Brookfield RVT, Spindle SC 4-29 at 204°C)
Softening point:	Approx. 118 °C (using ring and ball method based on ASTM E 28)

Instructions for use

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

Caution

Since the required ultimate performance, the substrates used and the production techniques differ, it is essential that this product is fully evaluated under both end use and production conditions before commercial production is embarked upon. Ageing characteristics of the bond should also be considered. If changes in substrates or production conditions occur re-evaluation may be required.

Processing centre

Ambient and substrate temperature	18 - 20 °C
Wood moisture content	8 - 10 %
Application temperature of the adhesive	160 - 180 °C
Feeding speed	4 - 6 m/min

Coatweight should be in line with the requirements of the open time and the material to be bonded.

Straight edge banding

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

Heat resistance

The heat resistance of RAKOLL® BAZ 3000 is adequate for all standard requirements of home furniture used in cold, moderate, or warm and dry climates.

Curved edge banding

As there are big differences in the material stresses when curved edges are bonded, it is not possible for H.B. Fuller to quote a general average heat resistance. Results observed in trials, were above temperatures, which are standard in the industry.

Straight edge banding

As measured with the RAKOLL® test method, using 3 melamine edges, 1 PVC edge, one veneer edge

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RAKOLL® BAZ 3000 may be used according to standard procedures.

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

Solid wood edging material

The strips to be glued should be cut from unstressed wood, and should be as straight as possible. The moisture content of the wood should be between 8 and 10 %.

Teak strips should be used as soon as cut.

Considerable improvement will be achieved with birch strips by spraying with thinned RAKOLL® GXL-3.

Improved strength is achieved using our bonding agent Intrafol L 1130, which is applied first to the strips.

The recommendations of the manufacturer of the edges should be observed.

and 2 extruded edges: approx. 91°C.

Due to higher material stresses, the heat resistances for solid wood edging lie below the stated value.

Safety recommendations

RAKOLL® BAZ 3000 is not classified as hazardous according to the NOHSC criteria and no special handling requirements, other than sound industrial hygiene practices, are needed. However, 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, eg. by means of an extracting system.

A Material Safety Data Sheet is available from the H.B. Fuller representative or agent in your State.

Cleaning

The melting vessels should be cleaned at regular intervals.

Storage

Store RAKOLL® BAZ 3000 in a cool and dry place.

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