

TECHNICAL DATA SHEET – OCTOBER 2012

RAKOLL® EXPRESS HP2

EXPRESS HP 2

PVA adhesive for continuous post-forming machines

Properties

RAKOLL® Express HP 2 is a dispersion adhesive that has been specially developed for use for the continuous post-forming of HPL/CPL and polyester laminates. RAKOLL® Express HP 2 is specially suited for spray-gun application. It permits a high feed speed and achieves a high level of heat resistance after setting.

Application

For use is in post-forming machines, preferably for application using spray guns.

Instructions for use

Material preparation:

- Substrate
The profile on the substrate must correspond with the pressure rollers and be cleanly cut; the transitions in particular must be perfectly formed.
- Coating material
The HPL/CPL sheets or polyester laminates must be suitable for post-forming. The manufacturer's instructions concerning forming temperatures, etc. must be observed.

Glue spread

The glue can be spread using sprays and rollers. The glue spread using spray guns must be adjusted so that a glue film results on the edge profile of the substrate and the overlapping part of the HPL sheet which is as thin and even and as coherent as possible.

The spray pressure must be set up according to the operating conditions of the machine. As a guideline value, a pressure of approximately 120 kPa can be assumed.

Machine settings

Feed speed and heating must be matched so that the glue dries transparent, but still contains a certain proportion of dispersion water before the laminate plate or the polyester laminate is bent.

Cleaning

Clean the glue container and spray jet with water before the glue dries.

Chemical-technical data

Base: Polyvinyl acetate dispersion (PVA)

Colour: white, when wet; transparent dry

Viscosity (#3/20rpm/20°C): 6600 cP

White point: 4°C

pH value: 6

Safety recommendations

Refer to MSDS.

Storage

Store in tightly closed original containers. Protect from frost.

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.