

TECHNICAL DATA SHEET – MAY 2015

RAKOLL® ECLIPSE HL 6733 A

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Version 3
26/05/2015

Hot Melt Adhesive for Edgebanding Machines

Characteristics:

RAKOLL® Eclipse HL 6733 A is an EVA based hot melt adhesive with good machining properties and high heat resistance. It is unfilled hot melt adhesive especially developed for bonding edge materials.

Overview:

- * High tack to bond a wide variety of materials
- * Consistent flow properties
- * No stringing
- * Improved mileage
- * No clean up is necessary
- * It is recommended for straight and soft forming applications

Features and Benefits:

- * Wet out, hot tack, and adhesion to a wide variety of substrates
- * Improved mileage because of the lower density of the product. In regards to volume, you need 30 to 50% less of a “filter free” adhesive to produce an identical layer of hot melt when applied. With this premise, the application amount depends on the equipment used, the porosity of the particle board (we still have to cover “high mountains” and “deep valleys” of the particleboard to obtain a good bond), and thickness of the edgebanding tape.
- * Edgebanding of black or other dark-coloured materials due to “shadowing” of the transparent glue line. Gives you the ability to use one, unfilled hot melt for all colours of substrates.
- * No clean up is necessary after changing from one colour hot melt to another on different-coloured substrates.

Instructions for use:

Adjust wrapping equipment in accordance with the manufacturers’ recommendations

Type and nature of the materials as well as the working conditions can influence the bonding considerably. Good results are obtained under the following conditions:

Room and material temperature:	18 - 20 °C
Wood moisture:	8 - 10 %
Operating temperature at the applicator roll:	180 - 200°C
Suggested Coat Weight	120-180 g/m ²
Feed speed :	At least 20 m/min

The strength and resistance of the bonds depend, among other things, on the percentage of joint surface that has really been bonded together.

Cleaning:

The melting pots should be cleaned at regular intervals since burnt adhesive will build up on the walls and impair the conduction of heat.

Edging material:

Edge strips can have very different adhesion properties, even if the material base is the same. For this reason, it is advisable to perform trials if the materials are of an unknown type in order to test the suitability of the adhesive.

Pay attention to the recommendations given by the strip manufacturers.

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Australia
Tel: +61 1800 423 855
customer.service@hbfuller.com
China & Hong Kong
Tel: +86 20 82068291
cs.china@hbfuller.com
Indonesia
Tel: +62-21-5307232/33

Korea
Tel: +82 2 786 8296
cskorea@hbfuller.com
Malaysia
Tel: +603 3345 5200
New Zealand
Tel: +64 800 555 072
customer.service@hbfuller.com

Philippines
Tel: +63 2 5194073
Taiwan
Tel: +886 2 26033385
Thailand
Tel: +66 2 3757442
Vietnam
Tel: +84 8 22225588

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Chemical - Technical data:

Base: Ethylene vinyl acetate copolymer

Viscosity:

Approx. 90,000 – 130,000 cP
(Brookfield RVT, spindle 29, 5 r.p.m., 204 °C)
Molten Gardner Colour: 1-4
Softening Point : 108°C
Specific Gravity: 0.96

Fields of applications:

RAKOLL® Eclipse HL 6733 A hot melt adhesive can be used for most types of edge strips which have been tested by the edge strip manufacturers and approved for the hot melt edge banding method.

Storage:

Store RAKOLL® Eclipse HL 6733 A hot melt adhesive in a cool and dry place.

Marking:

RAKOLL® Eclipse HL 6733 A hot melt adhesive need not to be marked as required by the regulation on hazardous products.

Caution:

Even if the recommended working temperatures are observed, hot melt adhesives will give off fumes, which can irritate the respiratory organs. Therefore, measures should be taken to remove the fumes by appropriate exhausters.

Made in Australia

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customer.service@hbfuller.com
China & Hong Kong
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cs.china@hbfuller.com
Indonesia
Tel: +62-21-5307232/33

Korea
Tel: +82 2 786 8296
cskorea@hbfuller.com
Malaysia
Tel: +603 3345 5200
New Zealand
Tel: +64 800 555 072
customer.service@hbfuller.com

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Tel: +63 2 5194073
Taiwan
Tel: +886 2 26033385
Thailand
Tel: +66 2 3757442
Vietnam
Tel: +84 8 22225588