

TECHNICAL DATA SHEET – MAY 2015

RAKOLL® K4/570 NATURAL OR WHITE

Page 1 of 2
Version 4
26/05/2015

Universal hot melt adhesive for edgebanding machines.

Characteristics

RAKOLL® hot melt adhesive K4/570 is an EVA based synthetic resin with good working properties that can be used on edge banders. The adhesive melts and flows well. It is clean in use and non-stringing. RAKOLL® hot melt adhesive K4/570 exhibits good bonding properties in connection with decorative laminate edge strips.

edge strip. The strength and resistance of the bonds depend, among other things, on the percentage of joint surface that has really been bonded. The heat resistance of RAKOLL® adhesive K4/570 meets all the demands made on furniture in cold, moderate or dry and warm climatic zones.

Heat resistance tested with rising temperature according to a RAKOLL® standard:

Melamine edge strips	approx. 65°C
Polyester laminates	approx. 64°C
Veneers	approx. 65°C

Chemical - Technical data:

Base: Ethylene vinyl acetate copolymer
Viscosity: Approx. 60,000 – 90,000 Cps
(Brookfield RVT spindle 29, 5 r.p.m, 204 °C)
Softening point: Approx. 92°C - 99°C
(Ring & Ball, ASTM E 28)

Cleaning

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

Fields of applications:

RAKOLL® hot melt adhesive K4/570 can be used for most types of edge strips which have been tested by the edge strip manufacturers and approved for the hot melt edgebanding method

Edging material

Edge strips have very different adhesive properties, even if material group is the same. For this reason, it is advisable to make tests if the materials are of an unknown type in order to see whether the adhesives can be used.

Pay attention to the recommendations given by the edge strip manufacturers.

Instructions for use:

The machine should be adjusted in accordance with the manufacturer's recommendations

RAKOLL® hot melt adhesive K4/570 can be processed in the usual way. Good results are obtained under the following conditions:

Room and material temperature: 18 - 20°C
Wood moisture: 8 - 10 %

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Operating temperature at the applicator roll: 190 - 210°C
Feed speed: at least 20 m/min

The feed speed should be at least 20m/min so that the adhesive does not cool down prematurely and is still fluid enough to wet the entire surface of the

Safety recommendations

RAKOLL® K4/570 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, e.g. by means of an extraction system.

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

Storage

Store RAKOLL® K4/570 hot melt adhesive in a cool and dry place

Made in Australia

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