

TECHNICAL DATA SHEET – SEPTEMBER 2011

RAKOLL K 650P/2 NATURAL OR WHITE

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Universal hot melt adhesive designed and approved for use in hot melt cartridge machines such as Holzher

Characteristics

RAKOLL® hot melt adhesive K650 P/2 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 K650 P/2 exhibits good bonding properties in connection with decorative laminate edge strips.

Chemical - technical data:

Base: Ethylene vinyl acetate copolymer

Viscosity: Approx. 65,000 cP
(Brookfield RVT, spindle 29,
5 RPM, 204 °C)

Softening point:: Approx. 96 °C
(Ring & Ball, ASTM E 28)

Fields of applications

RAKOLL® hot melt adhesive K650 P/2 can be used for most types of edge strips which have been tested by the edge strip manufacturers and approved for the hot melt edgbanding method.

Instructions for use

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

RAKOLL® hot melt adhesive K650 P/2 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 %
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

depend, among other things, on the percentage of joint surface that has really been bonded.

The heat resistance of RAKOLL® adhesive K650 P/2 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

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.

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.

Safety recommendations

RAKOLL® K650 P/2 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 extracting system.

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

Storage

Store Rakoll® K650 P/2 hot melt adhesive in a cool and

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.

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still fluid enough to wet the entire surface of the edge dry place.
strip. The strength and resistance of the bonds

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