

## Rakoll® U 320

**Type of Product** Hot melt adhesive.

**Product Characteristics**

- fast setting
- low viscosity
- relatively high heat resistance
- very good wetting qualities (which also apply to difficult decorative finishing films)

**Typical Applications** Profile wrapping of chipboard, MDF and solid wood profile cores with decorative finishing sheets and thin paper films as well as with Alkorcell.

**Suitable substrates** Wood and wooden based materials.

### Typical Properties

Property	Value
Base	(EVA) ethylene-vinylacetate copolymer
Softening point (R&B – ASTM E28-99)	approx. 83°C
Density	approx. 0,96 g/cm <sup>3</sup>
Viscosity (Brookfield HB, SC 21, 20rpm, at 204°C)	approx. 4 500 mPa.s
Shelf life	12 months

<b>Application Instructions</b>	<p>Set up the profile wrapping machine in accordance with the instructions of the machine manufacturer. The type and quality of the materials can greatly influence the gluing, as well as the working conditions.</p> <p>Good results can be achieved under the following conditions:</p> <ul style="list-style-type: none"><li>– Room and material temperature: 18°C – 20°C</li><li>– Moisture content of wood: 8 – 10%</li><li>– Processing temperature (at the roller): 160°C – 180°C</li><li>– Application quantity: 30 – 80 g/m<sup>2</sup></li><li>– Feed speed: at least 20 m/min</li><li>– Relative humidity: 40 – 60%</li></ul> <p><b>Heat resistance:</b></p> <p>The heat resistance of wrapped profiles depends primarily on the glued materials, the shape and size of the profiles and on the gluing procedure. No general statement can therefore be made regarding the heat resistance.</p> <p>In tests with increasing temperature, the heat resistance achieved on profiles wrapped in practice were found to lie around 70°C.</p>
<b>Cleaning Instructions</b>	Please contact your local Sales Office for available cleaning solutions.
<b>Typical Packaging</b>	Please contact your local Sales Office for available packaging options.
<b>Storage Conditions</b>	In original sealed packaging, at room temperature, protected from sun, dust, moisture and high temperatures.
<b>Disposal Advice</b>	Please refer to the MSDS for disposal instructions.
<b>Safety Advice</b>	<p>At the recommended working temperature, the hot melt will cause burns in contact with skin. Do not inhale fumes that are released at the working temperature. These vapours/fumes can irritate the respiratory organs. A suitable exhausting system shall be installed in the working area.</p> <p>Please refer to the SDS for additional safety advices.</p>

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