

# Rakoll® 5125

## General Properties

Experimental Product (XP) Name	Rakoll® XP 37904-0055
Technology/Base	Polyurethane (PU), prepolymer
Type of Product	Reactive hot melt
Curing	Moisture curing hot melt
Parts	One part system
Colour	White
Fields of Application	woodworking
Typical Applications	Edge banding
Product Benefits	<p>Low content of monomeric MDI (&lt;0,1%)</p> <p>Powered with mass balance isocyanate</p> <p>High heat resistance</p> <p>High cold resistance</p> <p>Fast melting</p> <p>Good flow properties</p> <p>High green strength</p>

## Typical Technical Data

### General

<b>Physical Properties</b> Density	1.20 g/cm <sub>3</sub>	
<b>Processing Guidelines and Parameters</b> Shelf Life Storage Temperature Processing Temperature Viscosity Line Speed Typical Curing Time for Final Properties	<p>9 months</p> <p>-25 °C to 35 °C</p> <p>120 °C to 150 °C</p> <p>45,000 mPa·s</p> <p>min. 20 m/min</p> <p>5 d to 7 d</p>	<p>Brookfield Sp. 29</p> <p>Thermosel, 160 °C, 10 1/min,</p>
<b>Recommended Conditions for Good Results</b> Ambient Temperature Substrate Temperature Moisture Content of Wood	<p>18 °C to 20 °C</p> <p>18 °C to 20 °C</p> <p>8% to 10%</p> <p>40% to 60%</p>	

Relative Humidity		
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**Product Properties**

**Processing**

Suitable Substrates	Solid wood Veneer Acrylonitrile butadiene styrene (ABS) Polypropylene (PP) Polyvinyl chloride (PVC) Wood based materials Paper various other substrates
Consistency	Solid
Surface Requirements	Substrate temperature must not be lower than specified in the technical data table Dry Clean Free of grease Free of oil
Application Method	Nozzle Roller

**Certifications**

Certifications and Declarations of Conformity	No GHS labeling
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## Additional Information

### Storage

Rakoll® 5125 should be used within the shelf life specified on the packaging. The storage stability applies to material stored under appropriate conditions only (original unopened containers, recommended storage temperature).

### Safety

Please read our Safety Data Sheet (SDS) of each product before use.

### Processing

Refer to the technical data table regarding processing parameters. Lower temperatures than recommended can cause higher viscosity which result in reduced bond strength and reduced wetting. Refer to the technical data table regarding processing parameters. Lower temperatures than recommended can cause

higher viscosity which result in reduced bond strength and reduced wetting. Depending on the construction of the equipment, a continuous heating above processing temperature can cause decomposition of the adhesive. Tank melters should use protective gases with < 5 ppm humidity, only. Rakoll® 5125 is moisture sensitive, therefore container must be kept closed.

### Cleaning

Clean tools immediately after use. Once cured, the material can only be removed mechanically. Appropriate cleaners are listed in the product properties table. For further information please contact your local sales office.

### Disposal

Please refer to the Safety Data Sheet (SDS) for disposal instructions.

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