



### Rakoll® P2/650

**Type of Adhesive** EVA based hot melt adhesive.

**Product Benefits**

- very good processing-properties on the HOLZ-HER type edgebanding machines, which work with cartridges (80 mm length x 63 mm diameter)
- suitable for almost all types of edges
- the hot melt adhesive melts very easily and has good heat resistance

**Typical Applications** Straight and round edgebanding on the HOLZ-HER type edgebanding machines.

**Suitable substrates** Veneer edges, melamine-resin edges, HPL (possible with primer agent), plastic edges (PVC, ABS, PP, ...).

#### Typical Properties

Property	Value
Colour	Natural, or White, or Brown, or Black
Viscosity (Brookfield HB; 204°C)	approx. 65 000 mPa.s
Softening point (R&B – ASTM E 28)	approx. 97°C
Shelf life	12 months



### Application Instructions

The carrier-material and the edge-strips have to be perfectly clean. Adjust the machine in accordance with the instructions of manufacturer.

Recommended application conditions:

- Room and material temperature: 18 – 20°C
- Wood moisture: 8 – 10%
- Working application temperature: 180 – 200°C
- Feed speed: minimum 15 m/min

Heating up the edge-surfaces before gluing may improve the bonding quality of some more difficult edges.

Edges strips can have very different adhesion properties, even if the base material is the same. For this reason, it is advisable to make preliminary trials in order to test the suitability of the adhesive and to identify the correct application conditions. The recommendations given by the edge strip manufacturers should be followed.

The heat resistance of this adhesive is adequate for all normal requirements for furniture for use in homes as met in the several types of climates.

### Cleaning Instructions

Please contact your local Sales Office for available cleaning solutions.

### Typical Packaging

Please contact your local Sales Office for available packaging options.

### Storage Conditions

In original sealed packaging, under clean and dry conditions at room temperature.

### Disposal Advice

Please refer to the MSDS for disposal instructions.

### Safety Advice

Hot melt adhesives release vapours even when the prescribed processing temperatures are observed. These can irritate the respiratory organs. Measures should therefore be taken for the elimination of vapours, e.g. through the use of a suitable extraction system.

Please refer to the MSDS for safety advice.

## Our Focus is Clear. Perfecting Adhesives.

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