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**TECHNICAL DATA SHEET**

## **Rakoll® U 12**

**Type of Adhesive** EVA based synthetic resin adhesive.

**Product Benefits** Good melting and flowing properties.

**Typical Applications** Especially suitable for edgebanding on round panels in manual and low-speed edgebander machines.  
It is also suitable for pre-coating of PVC edges.

**Suitable substrates**

Plastic edges (PVC, ABS, PP, etc.), veneer edges and particleboards and MDF based panels.

**Typical Properties**

Property	Value
Base	EVA copolymer
Viscosity (Brookfield HB; 204 °C)	approx. 13 000 mPa.s
Softening point (R&B ASTM E-28))	approx. 84 °C
Shelf life	12 Months

**Application  
Instructions**

Materials should be free from dust and grease.

Set up the machine in accordance with the instructions of the machine manufacturer.

Recommended application conditions:

? Room and materials temperature: 18 - 20 °C

? Wood moisture: 8 - 10 %

? Temperature at the applicator roll: 170-180 °C

? Spread: 160 - 200 g/m<sup>2</sup>

? Feed speed: at least 15 m/min

Edges strips can have very different adhesion properties, even if the base material is the same.

For this reason, it is advisable to make trials if the edges are of an unknown type in order to test the suitability of the adhesive and the correct application conditions.

The recommendations given by the edge strip manufacturers should be followed.

During long stops the adhesive temperature should be lowered to 160 °C to avoid degradation of the characteristics.

**Cleaning Instructions**

All residual encrustations of adhesive must be completely cleaned from the melting tank from time to time as they conduct heat poorly and cause a lowering of the adhesive temperature. 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 in a clean and dry conditions at room temperature.

Please refer to the MSDS for disposal instructions.

**Disposal Advice****Safety Advice**

The hot-melt cause burns on contact with the skin at the application temperature.

At the recommended working temperature, the hot-melt will give off fumes that can irritate the respiratory tract. If the working temperature is exceeded over a long period, harmful decomposition products will form.

In any case an appropriate exhausting system shall be installed in the working area.

For additional information, please refer to the MSDS for safety advices.

**Our Focus is Clear. Perfecting Adhesives.**

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