



# H.B. Fuller

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## TECHNICAL DATA SHEET

# RAKOLL TE 5700

### CHARACTERISTICS AND APPLICATIONS:

**RAKOLL TE 5700** is an EVA based synthetic resin adhesive with good working properties, which can be universally used on edgebanders with PVC melamine and veneers edges. The adhesive presents good melting and flowing properties.

**RAKOLL TE 5700** has good adhesion properties and a long open time.

### PHYSICAL PROPERTIES:

Characteristics	Value	Unit	Internal Method	Adapted Standard
Viscosity (Brookfield HB; 204 °C)	Approx. 82 000	mPa.s	I PRO 00 04	ASTM D 3226
Softening point (Ring and ball)	Approx. 103	°C	I PRO 00 02	ASTM E 28

### INSTRUCTIONS FOR USE:

The machine should be adjusted according to the recommendations of the machine manufacturers.

**RAKOLL TE 5700** can be processed in the usual way. Good results are obtained under the following conditions:

#### WORKING CONDITIONS

Room and materials temperature	▷	18 - 20°C
Wood moisture	▷	8 - 10%
Temperature at the applicator roll	▷	190 - 210 °C
Feed speed	▷	at least 12 m/min

The feed speed should be at least 12 m/min so that the adhesive does not cool down prematurely and is still fluid enough to wet the entire surface of the edge strip.

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. 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. 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.

**RAKOLL TE 5700** is available on natural, white and brown colours.

### HAZARDOUS INFORMATION'S:

At the recommended working temperature the hot-melt will give off fumes that can irritate the respiratory organs. 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.

### STORAGE:

**RAKOLL TE 5700** should be stored in closed original containers at room temperature. In these conditions the glue can be conserved for at least 12 months without changing its properties.

*All information in this technical data sheet is given in good faith, based on our research and practical experience. Whilst we guarantee the constant quality of our products we cannot be responsible for the results obtained in their use, since the conditions of use and working methods are beyond our control.*

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