

## Rakoll<sup>®</sup> K 4/581 LV NAT

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

**Product Characteristics** Presents good melting and flowing properties.

**Typical Applications** Is suitable for most types of edge materials which have been tested and approved by the substrate manufacturers for use with hot melt adhesive procedures.

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

### Typical Properties

Property	Value
Base	EVA
Colour	natural
Density	approx. 1,56 g/cm <sup>3</sup>
Viscosity (Brookfield HB, Sp29, at 204°C)	approx. 80 000 mPa.s
Shelf life	12 months

**Application Instructions**

The machine should be adjusted according to the recommendations of the machine manufacturers. This product can be processed in the usual way.

Recommended application conditions:

- room and materials temperature: 18°C – 20°C
- wood moisture: 8 – 10%
- temperature at the applicator roll: 170°C – 190°C
- feed speed: at least 6 m/min

Edging strips can have very different adhesion properties, even across a certain group of material. Appropriate tests must therefore be carried out, in order to check the suitability of the adhesive.

The recommendations of the substrate manufacturer must also be observed.

Heat resistance tested with rising temperatures according to Rakoll® method: approximately +75°C

During long stops the adhesive temperature should be lowered to 160°C.

**Cleaning Instructions**

The melting pots should be cleaned at regular intervals and not allowed to go down too much.

**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 recommended processing temperature is observed. These can irritate the respiratory system. Measures should therefore be taken for the removal of vapours, e.g. by means of an extraction system.

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

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