

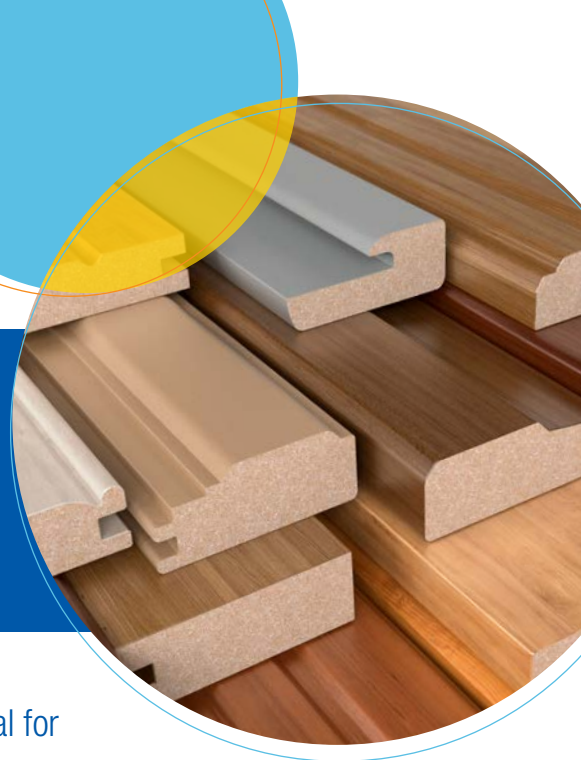


H.B. Fuller

Rakoll 
Woodworking Adhesives

WOOD AND COMPOSITES

Rakoll® 4660: an outstanding adhesive for profile wrapping



H.B. Fuller has developed a fast-setting reactive hot melt that is ideal for profile wrapping with standard memory decorative foils to both basic and more intricate profiles. The **Rakoll®4660** is a workhorse, universal reactive hot melt adhesive for wrapping a wide variety of standard thickness interior foils.

ADVANTAGES OF RAKOLL® 4660

- High green strength
- Excellent melt flow properties enabling fast line speeds.
- Open time can be extended by increasing application temperatures.
- Outstanding thermal stability for wrapping in winter and summer ambient conditions.

OUR APPLICATIONS CENTER

- We have a production capacity profile wrapping machine in our technical center, St. Paul, MN.
- We are capable of benchmarking adhesives or run small trials.
- Our technical experts will help you select the right adhesive for your decorative wrapping applications. Contact us to schedule a visit:
 - hbfuller.com/wood-adhesives or
 - inquiry@hbfuller.com or
 - 833-672-1482

TYPICAL APPLICATIONS

- Rakoll® 4660 is ideal for profile wrapping standard memory decorative foils to both basic and more intricate profiles.
- Typical substrates: MDF, wood, plastic and vinyl

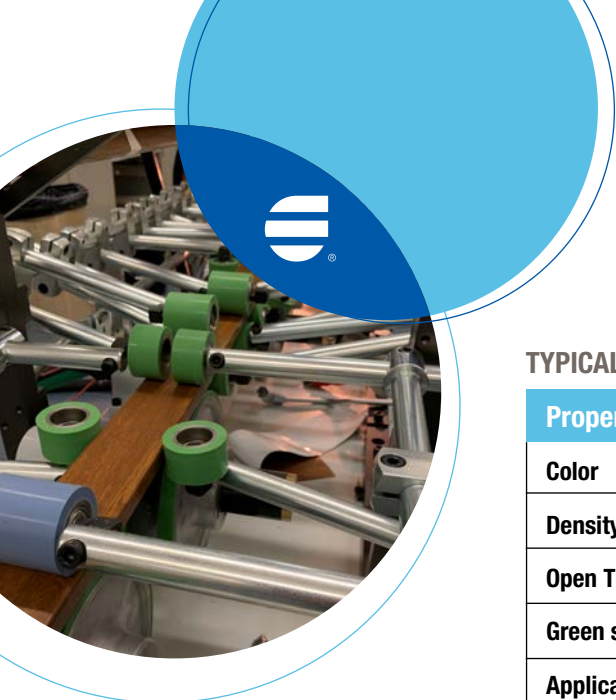


Profile wrapping with Rakoll® 4660

Profile wrapping is a process of bonding a decorative foil to the outside of a lineal profile. It requires a special equipment and adhesive to wrap intricate profiles.

Rakoll®4660 was specifically designed for profile wrapping. It has high green strength and excellent melt flow properties enabling fast line speeds. Open time can be extended by increasing application temperatures.

Rakoll®4660 is a single-component, fully reactive hot melt adhesive that cross-links through a chemical reaction with moisture found in the surrounding air and substrates, to produce a thermoset adhesive.



TYPICAL PROPERTIES

Properties	Rakoll® 4660
Color	Off-white
Density	8.4–10.0 lb/gal
Open Time	20 seconds
Green strength (>50 psi)	15 seconds
Application Temperature	130–140 °C
Shelf Life	9 months

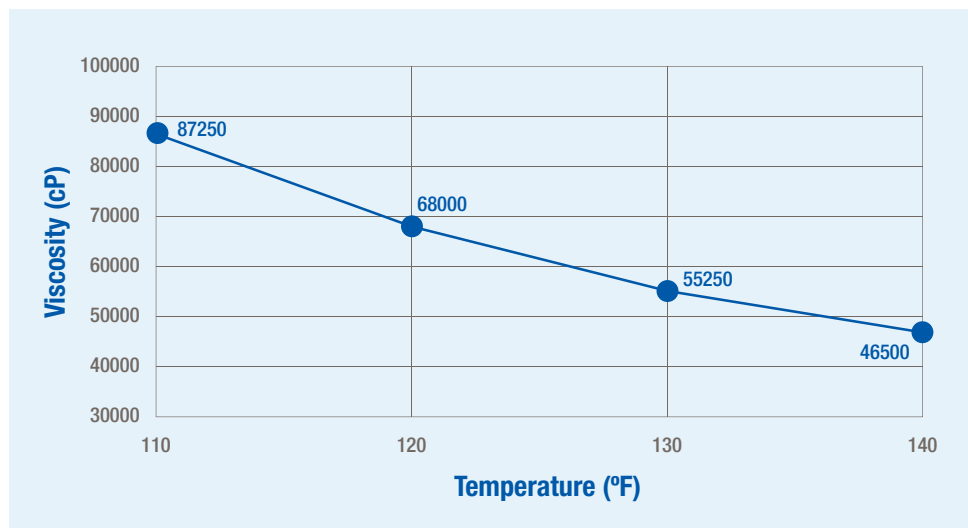
STORAGE AND SHELF LIFE

To ensure maximum stability, product should be stored in the original closed container in a clean and dry interior location capable of maintaining a constant temperature between 50 °F and 90 °F.

HEALTH AND SAFETY

Use only in equipment intended for reactive hot melts. Use with local exhaust ventilation to remove vapors anywhere heated product is exposed to air including adhesive un-loaders, pre-melters, and application areas. Local exhaust ventilation may be required to maintain exposures at safe levels. See Safety Data Sheet (SDS) for additional safety and handling information.

VISCOSITY CURVE



ABOUT H.B. FULLER COMPANY

Since 1887, H.B. Fuller has been a leading global adhesives provider focusing on perfecting adhesives, sealants and other specialty chemical products to improve products and lives. H.B. Fuller’s commitment to innovation brings together people, products and processes that answer and solve some of the world’s biggest challenges. Our reliable, responsive service creates lasting, rewarding connections with customers in electronics, disposable hygiene, health and beauty, transportation, aerospace, clean energy, packaging, construction, woodworking, general industries and other consumer businesses. And, our promise to our people connects them with opportunities to innovate and thrive.



For more information, visit www.hbfuller.com/wood-adhesives

Join the Conversation | www.hbfuller.com/connect

IMPORTANT: The information contained herein is believed to be correct to the best of our knowledge. However the recommendations and suggestions herein are made without guarantee or representation as to results. It is the purchaser’s responsibility to test and determine the suitability of the product for the purchaser’s intended use and purpose. Purchaser assumes all risk and liability whatsoever regarding such suitability. Any product samples provided for testing are provided in accordance with standard limited warranties as stated on our technical data sheets.
Rakoll® is a trademark of H.B. Fuller Company (“H.B. Fuller”) or an affiliated company of H.B. Fuller, and is registered in the U.S. and other countries.