



H.B. Fuller

**Rakoll**  
Woodworking Adhesives



WOOD AND COMPOSITES

# Adhesive Selection Guide for Interior Door Manufacturing

Door manufacturing continues to evolve with new materials, process efficiencies and innovations while consumer expectations continue to grow. Today's adhesives must provide flexibility, speed and wider adhesion performance with high-end use reliability.

Discover our modern and sustainable range of adhesives for the typical processes and applications of interior door manufacturing.

### D3 AND D4 CERTIFIED PVAc ADHESIVES

Product Name	Key Properties	Viscosity (mPas) at 20°C	pH-Value	Open Time (min)
<b>D3 Adhesives</b>				
<b>Rakoll® 4330</b>	Developed for foaming application for improved surface finishing and wetting	9,000	3	8-12
<b>Rakoll® GXL 3</b>	Easy-to-apply and suitable for many processing conditions, provides very strong bonding	13,000	3	8-12
<b>Rakoll® ECO 3</b>	Easy-to-apply and suitable for many processing conditions, recommended for UF replacement	11,500	3	12
<b>D4 Adhesives</b>				
<b>Rakoll® GXL 4</b>	One-component adhesive emulsion, strong adhesion to many difficult-to-bond woods, quick strength properties immediately after bonding, performs very well on High Frequency (HF) presses	5,500	3,5	8-9
<b>Rakoll® ECO 4</b>	One-component adhesive emulsion, suitable for many processing conditions	5,500	3,5	8-9

### PROFILE WRAPPING THERMOPLASTIC HOT MELTS

Product Name	Line Speed (m/min)	Material foil	Coat weight	Applicaton (Roller or slot nozzle)	Application Temp. °C	Technology (Polyolefine, EVA...)
<b>Rakoll® 5437</b>	>20	pretreated PP foils, PVC, veneer, CPL and decorative paper foils	30 - 100 g/m <sup>2</sup>	nozzle	160-190	PO
<b>Rakoll® U 320</b>	>20	PVC, veneer, CPL and decorative paper foils	30 - 100 g/m <sup>2</sup>	roller/nozzle	160-180	EVA

## PROFILE WRAPPING - HMMC

Product Name	Open Time	Materials	Green Strength	Application (Roller or slot nozzle)	Pre Heating	Application Temp. °C	Additional Information
Rakoll® 4654	Medium	Wooden materials, plastics, ...	High	Slot nozzle	Yes	120-140	Specially recommended for low ambient temperatures.
Rakoll® 4655	Short	Wooden materials, plastics, ...	Extremely High	Slot nozzle	Yes	130-150	Specially recommended for high ambient temperatures.

## DOOR LAMINATION - HMMC

Product Name	Key Properties	Materials	Application	Open Time (min)	Viscosity (mPas) at 120°C
Rapidex® NP 2075 LT	Very high initial strength, provides very good bonding on tensioned substrates	PVC, ABS, PC and veneer	Nozzle, roller	3	45,000
Rakoll® 5010	Low monomer, high initial strength, shows excellent adhesion to typical wood substrates and decorative materials	Wood, XPS, EPS, EPS, metal textiles, PUR-foams, plastics like PVC, ABS, PC, GRP, aluminum and metalloid	Roller	Up to 6	14,500

## EDGEBOARDING - HMMC

Product Name	Key Properties	Materials	Application	Viscosity (mPas) at 160°C	Application Temp. (°C)
Rakoll® 4020	Low monomer, good flow properties, fast melting, high initial strength, good cold and heat resistance	ABS, PP, PVC, Veneer, Melamine and Solid Wood edges	Slot nozzle, roller	50,000	120-150

## EDGEBOARDING - HOT MELTS

Product Name	Key Properties	Heat Resistance (°C)	Line Speed (m/min)	Technology
Rakoll® TE 5728	High heat resistance, low stringing properties for clean and efficient processing, thin glue line for good finishing	up to 110	20-80	PO
Rakoll® K 4/581 LV NAT	Designed to be compatible with most edgebanding substrates, and typical application speeds and settings	up to 75	5-70	EVA

## 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.



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