



WOOD AND COMPOSITES

Reactive Polyurethane Hot Melts Profile Wrapping and Flat Lamination Selection Guide

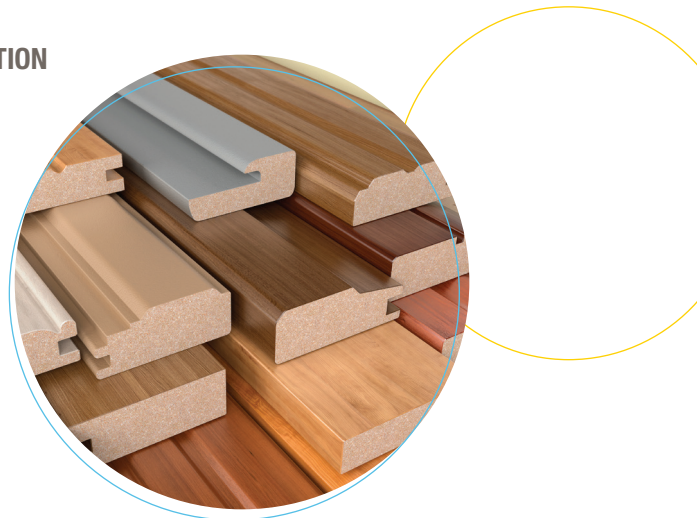
Our robust reactive polyurethane hot melt range for profile wrapping and flat lamination includes products for all processes and materials typically used in this industry. We also cover all possible customer demands in terms of application and final performance.

MATERIALS

- Wooden materials, metal, Paper, PP, PVC, veneer, decorative laminates in general, etc.

TYPICAL PARAMETERS FOR PROFILE WRAPPING AND FLAT LAMINATION

- Application by roller or slot nozzle
- Room and material temperatures: minimum +15 °C
- Application temperatures: from 120 –150 °C
- Line speeds: from 6 to 70 m/min (depends of the product)
- Relative humidity approx. 45 to 60%

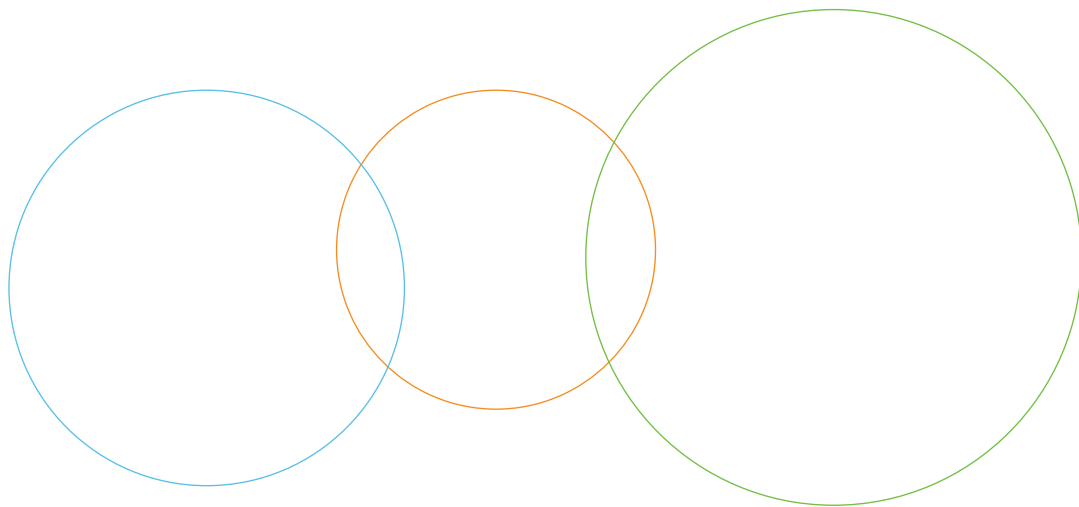


PROFILE WRAPPING PORTFOLIO

Product	Application Temperature	Green Strength	Open Time	Materials	Application	Pre-Heating	Additional Information
Rakoll® 4654	120-130°C	high	Medium	Wood to paper, veneer, PP, thin PVC	slot nozzle	Always	Specially recommended for low ambient temperatures.
Rakoll® 4655	130-150°C	Extremely high	Short	Wood to paper, veneer, PP, All PVCs	slot nozzle	Always	Specially recommended for high ambient temperatures.
Rakoll® 4656	120-150°C	Extremely high	Medium	Wood to paper, veneer, PP, All PVCs	slot nozzle	depending on substrates and conditions	Valid for all ambient temperatures. High bonding strength. Valid for Panel Wrapping (Continuous lines).

FLAT LAMINATION PORTFOLIO

Product	Application Temperature	Green Strength	Open Time	Materials	Application	Pre-Heating	Additional Information
Rapidex® 2075 LT	Premelting approx. 160°C Application Temp: 120-140°C	Extremely high	Medium	Wooden materials, metal, plastics, ...	Roller, slot nozzle, bead	No	Outstanding melt stability.
Rakoll® 3700	130-150°C	High	Long	Wooden materials, metal, plastics, ...	Roller, slot nozzle, bead, spray	No	Excellent fluency. Long Open time. Valid for high gloss application.
Rakoll® 3500	120-140°C	High	Long	Wooden materials, metal, plastics, ...	Roller, slot nozzle, bead, spray	No	
Rakoll® 3422	120-130°C	medium	Long	Wooden materials, metal, plastics, ...	Roller, slot nozzle, bead, spray	No	Excellent fluency. Specially developed for high gloss application.
Rakoll® 5010	120-140°C	High	Long	Wooden materials, metal, plastics, ...	Roller, slot nozzle, bead, spray	Yes	High green strength.
Rakoll® 5016	120-140°C	medium	Long	Wooden materials, metal, plastics, ...	Roller, slot nozzle, bead, spray	Yes	Improved wettability. Specially developed for spray applications.



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