

## Rakoll® 4020

<b>Type of Product</b>	Polyurethane based reactive hotmelt
<b>Product Characteristics</b>	<ul style="list-style-type: none"><li>– No hazardous material (no hazard pictograms requested)</li><li>– good flow properties</li><li>– fast melting</li><li>– high initial strength</li><li>– good cold- and heat resistance (Rakoll® method)</li></ul>
<b>Typical Applications</b>	It is suitable for all types of edge banding machines and various kinds of edge banding materials via roller- and nozzle application.
<b>Suitable substrates</b>	Veneer-, solid wood- and plastic edges (ABS, PP, PVC) as well as strong and decorative papers.

### Typical Properties

Property	Value
Base	polyurethane
Colour	natur
Density	approx. 1.10 g/cm <sup>3</sup>
Viscosity at 160 °C (Brookfield HB; Sp29; 10 rpm)	approx. 45.000 mPa.s
Shelf life	9 months

<b>Application Instructions</b>	<p>Roller- and nozzle application units. Application temperature: 120 °C – 150 °C</p> <p>Open time: very short (depending on temperature, amount and substrate)</p> <p>Good results will be achieved if the following conditions are observed:</p> <ul style="list-style-type: none"><li>- Room-, material- and adhesive temperature: 18 – 20 °C</li><li>- Moisture content of wood: 8 – 10 %</li><li>- Relative humidity: 40 – 60 %</li><li>- Feed speed: up to 40 m/min</li></ul> <p>The surfaces of the substrates must be clean, dry and free from oil and grease. The processing temperature during coating should be at 15 °C – 35 °C. Final strength is achieved after approx. 5 - 7 days depending on availability of moisture and temperature.</p> <p>Due to the great variety of materials, proper tests must be done, to determine the suitability of our product.</p>
<b>Cleaning Instructions</b>	<p>For cleaning we recommend Ipatherm Cleaner 13. Cured adhesive can only be removed mechanically. Please contact your local Sales Office.</p>
<b>Typical Packaging</b>	<p>Please contact your local Sales Office for available packaging options.</p>
<b>Storage Conditions</b>	<p>In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above -25 °C and below +35 °C.</p>
<b>Disposal Advice</b>	<p>Please refer to the SDS for disposal instructions.</p>
<b>Safety Advice</b>	<p>Please refer to the SDS for safety advice.</p>

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company ("H.B. Fuller") or one of its affiliated entities.

**NOTE TO USER:** *by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.*