



# Rakoll 2021

<b>General Properties</b>	Technology/Base	polyurethane, dispersion
	Type of Product	adhesive
	Color	white
	Product Benefits	good spraying behaviour reactivatable high initial bonding strength high heat resistance

## Technical Data

### General

<b>Physical Properties</b>		
Density (wet)	1.06 g/cm <sup>3</sup>	Internal HBF Standard PAN 162
<b>Processing Guidelines and Parameters</b>		
Storage Temperature	15 °C to 25 °C	Internal HBF Standard PAN 100 25 °C, depending on substrates and application weight storage at room temperature (20 °C), application weight 40 g/m <sup>2</sup> (dry) depending on substrates
Processing Temperature	18 °C to 20 °C	
Relative air humidity	40% to 60%	
Moisture content of wood	8% to 10%	
Viscosity	2,600 mPa·s	
Flash-off time / waiting time	min. 60 min	
Reactivation	max. 3 d	
Activation Temperature	55 °C to 65 °C	
Storage Time	max. 6 months	
Application Weight (dry)	40 g/m <sup>2</sup>	

## Product Properties

<b>Applications</b>	Fields of Application	woodworking
	Special Applications	bonding of thermoplastic furniture foils for 3D lamination
<b>Processing</b>	Suitable Substrates	wood based materials MDF
	Suitable films for lamination	PVC-films ABS-films
	Surface Requirements	dry clean free of grease free of dust
	Application Method	spraying
<b>Cleaning</b>	Cleaner for Tools	Körasolv PU ISA Verdünner 220
<b>Hints</b>	Stir Well Before Use	<b>Adhesive must be stirred well before use.</b>
	Frost protection	<b>Protect Rakoll 2021 strictly from frost, product will get damaged.</b>



## Additional Information

### Storage

Rakoll 2021 should be used within the shelf life specified on the packaging. The storage stability only applies to material stored under appropriate conditions (original unopened containers, recommended storage temperature).

### Safety

Please read our Material Safety Data Sheet (MSDS) and the labels of each product before use. The valid safety regulations must be considered.

### Preparation

The surfaces to be bonded must be dry, clean, free of grease and free of dust to ensure a reliable bonding.

### Bonding

After drying the bond is effected by activation in the 3D process. Sealing time depends on thermal conductivity of the substrates. Press time depends on temperature, pressure and substrates. Sealing and press times must be determined by preliminary tests.

### Cleaning

Water for fresh adhesive, when film is dried use Köra-solv PU or ISA Verdünner 220.

### Disposal

Please refer to the Material Safety Data Sheet (MSDS) for appropriate disposal instructions.

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