

Rakoll[®] 5010

Type of Product Polyurethane-based reactive hot melt.

Product Characteristics

- high initial strength
- long open time
- excellent adhesion on various plastics
- high thermal stability
- good flexibility after complete curing
- label-free due to residual monomer content < 0.1 %

Typical Applications Bonding of wooden material, metal, glass, textiles, PUR-foams, plastics like PVC, ABS, PC, aluminium and metalloids.

Suitable substrates Wooden material, metal, glass, textiles, PUR-foams, plastics like PVC, ABS, PC, aluminium and metalloids.

Typical Properties

Property	Value
Colour	yellowish
Density at 20°C	approx. 1.2 g/cm ³
Viscosity at 130°C	11 000 to 18 000 mPa.s
Shelf life	9 months

Application Instructions

Application procedure and type of applicator: drum, pail and bag unloaders in combination with nozzle-, coating roller- and/or screen-printing systems.

Application temperature: approx. 120°C – 140°C

Open time: Up to 6 minutes, depending on application procedure, application thickness and substrate.

Pre-treatment of bonding surfaces:

Bonding surfaces have to be clean, dry and free of grease and oil. Polyolefin materials have to be corona-pre-treated or flame-treated.

Preparation:

Drum unloader, heating plate and applicator gun can, as a rule, be set to different temperatures. Excessive heat may cause decomposition of the adhesive. Depending on the construction of the equipment, a temperature of 110°C is enough for the heating plate. Due to the short operation time, the application equipment may be run at temperatures of up to 140°C. For tank melters only protective gases with <5ppm humidity should be used. Positive results have been achieved with nitrogen. Please take care of that packages are used immediately after opening to prevent possible reactions with moisture.

Adhesive application:

It is either applied in beads or tapes or as a sheet onto one of the bonding surfaces. Bonding is carried out immediately upon application.

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Application Instructions	Special attention: Final cure is achieved by reaction with ambient moisture or moisture from the substrate. Curing time depends on the access of humidity to the bonding seam, i.e. the humidity of the substrate, substrate permeability, adhesive film thickness, relative air humidity and ambient temperature. Average curing time for bonding onto wooden materials at a temperature of +20°C and relative humidity of 65% amounts to up to 3 – 4 days. If large surfaces and/or impermeable materials are bonded under unfavourable climatic conditions, the curing time may be considerably longer.
Cleaning Instructions	Please contact your local Sales Office for available cleaning solutions.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above -25°C and below +35°C.
Disposal Advice	Please refer to the MSDS for disposal instructions.
Safety Advice	Please refer to the MSDS for safety advice.

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