

Bitte Technisches Datenblatt anfordern und beachten!

Before use please study technical and safety data sheet.

Veuillez demander et respecter la fiche technique !

Consultar la ficha técnica y ficha de seguridad antes de utilizar!

Przed użyciem proszę zapoznać się z informacjami zawartymi w karcie danych technicznych!

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Made in Germany

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RAUBOND EVA 111

DE EVA-Hotmelt
EN EVA hot melt
FR Colle thermofusible à base de EVA
ES Adhesivo termofusible a base de EVA
PL Klej termotopliwy EVA

REHAU

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RAUBOND

Technical Information



RAUBOND – Technical Information

1. Suitability

RAUBOND is a hot-melt adhesive that can be used for bonding thermoplastic edgebands and other edgebands made of, e.g., HPL, CPL, polyester, impregnated paper and veneer. The individual properties of the edgeband material and the application of adhesion promoter on the back must be checked before use.

2. Processing instructions

RAUBOND adhesives are particularly suitable for processing with edgeband gluing machines and boast excellent processing properties including high heat resistance and precise adhesive application without stringing.

2.1. RAUBOND EVA 111/112

RAUBOND EVA 111/112 hot-melt adhesives are recommended for straight edgeband applications. They can be applied using automatic equipment with a roller.

Properties

| | |
|---------------------------------------|--|
| Base | Ethylene vinyl acetate copolymer (EVA) |
| Supply form | Pellets |
| Density at 20 °C [g/cm ³] | 1.52 ± 0.03 (pycnometer, 100 ml) |
| Colour | RAUBOND EVA 111: beige RAUBOND EVA 112: white |
| Viscosity at 200 °C [mPa·s] | 75,000 ± 10,000 (Brookfield) |

The following information provides processing instructions for the adhesive based on practical experience and laboratory tests:

| | |
|-----------------------------|---|
| Processing temperature [°C] | 190–210 |
| Feed rate [m/min] | 8–60 |
| Softening range [°C] | approx. 90 ± 5 |
| Open time at 190 °C [s] | approx. 8 ± 1 (measured on a 200 µm film) |

2.2. RAUBOND EVA 121/122

RAUBOND EVA 121/122 adhesives are recommended for use on straight edgebands or for soft-forming and CNC machinery. They can be applied using automatic equipment with a roller and wide-slot nozzle.

Properties

| | |
|---------------------------------------|--|
| Base | Ethylene vinyl acetate copolymer (EVA) |
| Supply form | Pellets |
| Density at 20 °C [g/cm ³] | 1.14 ± 0.03 (pycnometer, 100 ml) |
| Colour | RAUBOND EVA 121: beige RAUBOND EVA 122: white |
| Viscosity at 200 °C [mPa·s] | 85,000 ± 13,000 (Brookfield) |

The following information provides processing instructions for the adhesive based on practical experience and laboratory tests:

| | |
|-----------------------------|--|
| Processing temperature [°C] | 180–200 |
| Feed rate [m/min] | 8–75 |
| Softening range [°C] | approx. 95 ± 5 |
| Open time at 190 °C [s] | approx. 12 ± 1 (measured on a 200 µm film) |

2.3. Areas of application

| | RAUBOND EVA 111/112 | RAUBOND EVA 121/122 |
|-------------------|-------------------------------------|-------------------------------------|
| Straight edgeband | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |
| Soft-forming | | <input checked="" type="checkbox"/> |
| CNC machinery | | <input checked="" type="checkbox"/> |

2.4. General processing information

For bonding, the substrate material to which the edgebands are applied, as well as the edgebands themselves, should be free from dust, oil and grease. Precise right-angled processing of the substrate material should also be ensured.

It is recommended to normalize the boards and edgeband material to at least 18 °C (temperatures <18 °C may lead to improper bonding!). Avoid draughts during processing.

3. Delivery format, environment, labelling

Bags filled with 25 kg of solid adhesive pellets are available.

3.1. Labelling

Industrieverband Klebstoffe [German Adhesives Association] provides the following recommendations for the processing of hot-melt adhesives that do not require labelling:

"Vapours escape from the hot-melt adhesives during processing. The type and quantity of these vapours depend on the type of adhesive, the application method and the processing temperature. The manufacturer's instructions, especially those relating to the application temperature, must be strictly observed. Vapours must be extracted using suitable devices."

RAUBOND EVA 122 is an exception. This is subject to mandatory labelling with the following EUH statements according to Delegated Regulation (EU) 2020/217:

- EUH 212: Warning! Hazardous respirable dust may be formed when used.
Do not breathe dust.
- EUH 210: Safety data sheet available on request.

Further information on safety, handling, transport and disposal can be found in the respective safety data sheets

4. Storage

The adhesive must be stored in closed original containers in a cool and dry place. The expiration date can be found on the container label.

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