



**RAUBOND™** hot melt adhesives  
Technical information for edgeband application

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Forming a strong bond between band and board.



## RAUBOND edgeband hot melt adhesives

REHAU wants to make edging your project easy and reliable. To ensure the best application of our edgeband to your furniture, we have partnered with JOWAT® to manufacture our own line of hot melt adhesives.

Recommended for use with all of our edgebands, RAUBOND hot melt adhesives can be easily applied with any hot melt edgebander. No matter what band material or application process you're using, we provide an adhesive that will allow you to achieve strong adhesion, easy processing and good value.

Offered through our stock program, RAUBOND hot melt adhesives can be purchased in various quantities and shipped along with our edgeband.



# Product Overview

## A solution for every edgeband application

Product	Application	Jowat Part No.	REHAU Art. No.	Color	Packaging	Page
RAUBOND Universal	Medium viscosity filled EVA hot melt suitable for edgebanding of PVC, ABS, PP, PET, veneer, solid wood, melamine and primed HPL	288.60	122870-201	Natural	44 lbs/bag	4
		288.61	122870-002	White	55 lbs/bag	
		288.62	122870-003	Brown	55 lbs/bag	
		288.63	122870-004	Black	55 lbs/bag	
RAUBOND Universal Cartridge	Medium viscosity filled EVA hot melt for automatic edgebanding of PVC, ABS, PP, veneer, solid wood and primed HPL; use with Holz-Her cartridge edgebanders	286.80	122951-004	Natural	35 lbs/box	5
		286.81	122951-007	White	35 lbs/box	
		286.82	122951-006	Brown	35 lbs/box	
		286.83	122951-005	Black	35 lbs/box	
RAUBOND Superior	High-end, medium viscosity unfilled EVA hot melt for automatic edgebanding of PVC, solid wood, veneer and melamine; especially suited for BAZ or Combiformer applications. Good cold flexibility	280.30	122880-001	Natural	55 lbs/bag	6
RAUBOND Superior Cartridge	High-end, unfilled EVA hot melt, for use with Holz-Her cartridge edgebanders	286.30	122005-001	Translucent	26 lbs/box	7
RAUBOND Economy*	Medium viscosity filled EVA hot melt for PVC, ABS, PP, PET melamine and veneer	296.30	122941-208	Natural	44 lbs/bag	8
		296.31	122941-003	White	55 lbs/bag	
RAUBOND Low Viscosity Contour*	Low viscosity filled EVA hot melt for contour edgebanding of PVC, ABS, PP, PET, paper and polyester at low application temperatures and slow feed speeds	282.20	122981-005	Natural	55 lbs/bag	9
RAUBOND Clear*	Medium viscosity unfilled EVA hot melt with high heat resistance, suitable for PVC, ABS, PP, PET, solid wood, veneer and melamine; also used for soft-forming applications	280.58	122990-204	Clear	44 lbs/bag	10
RAUBOND High Viscosity Contour*	High-end, high viscosity unfilled EVA hot melt for edgebanding suitable for PVC, solid wood, veneer and melamine. Especially suited for BAZ or Combiformer applications	280.10	128010-001	Natural	55 lbs/bag	11
RAUBOND PUR	Fast setting bonding edgebands such as ABS, PP, PVC, resinated decor paper, aluminum HPL or veneer with an appropriate pretreatment. Specialized processing equipment required	60800-0010G	122993-005	Translucent	10 lbs/box	12
RAUBOND PUR Cartridge	Fast setting bonding edgebands such as ABS, PP, PVC, resinated decor paper, aluminum HPL or veneer with an appropriate pretreatment. Specialized processing equipment required; use with Holz-Her cartridge edgebanders	60800-013HG	122961-010	Translucent	14 lbs/box	13

\*Item not stocked - available in a 10-day lead time

# RAUBOND Universal Adhesive

## Articles 122870-002, 003, 004, 201

Medium viscosity EVA edgebanding hot melt with good color and heat stability in the melt. Hot melt has good wetting and adhesion properties and offers improved performance and good value. Edge materials include veneer, solid wood, resin impregnated paper edgebands, PVC, ABS, PP and primed HPL.

### Characteristics

Type	Filled Ethylene-Vinyl Acetate (EVA)	
Color(s)	Natural: 122870-201 Brown: 122870-003	White: 122870-002 Black: 122870-004
Softening point	230°F (110°C) Ring & Ball	
Density (p)	1.33 g/ml (10.8 lbs/gal)	
Viscosity (μ)	120,000 mPAS/Ps @ 374°F (190°C) 90,000 mPAS/Ps @ 392°F (200°C) 70,000 mPAS/Ps @ 410°F (210°C)	

### Processing

Methods	Suitable for medium- high-speed edgebanding. This adhesive can also be used for precoating and soft-forming applications.
Application temp	374-410°F (180-200°C)
Feed speed	12-60m/min (30-180ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	PRIMER SHOULD CONSIST OF RAUBOND HPL PRIMER DILUTED WITH WATER 50:50. Due to the differences in HPL, we strongly recommend to carry out suitability tests prior to production. A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	122870-201 in 44 lbs net weight in durable plastic bags, all other variants in 55 lb bags
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND Universal Cartridge Adhesive

## Article 122005-001

Medium viscosity EVA edgebanding hot melt that is very economical with good color and heat stability in the melt. Excellent wetting and adhesion properties. Suitable for primed HPL, solid wood, veneer, resin-impregnated paper edgebands, PVC, ABS, PP and similar. For HPL, primer should be used consisting of RAUBOND HPL Primer (Art. 124600-001) diluted with water 50:50. Due to differences in HPL, it is strongly recommended to carry out suitability tests prior to production.

### Characteristics

Type	Filled Ethylene-Vinyl Acetate (EVA)	
Color(s)	Natural: 122951-004 Brown: 122951-006	White: 122951-007 Black: 122951-005
Softening point	212°F (100°C) Ring & Ball	
Density (p)	1.30 (10.8 lbs/gal)	
Viscosity (μ)	115,000 mPAS/Ps @ 356°F (180°C) Brookfield-Thermosel 80,000 mPAS/Ps @ 374°F (190°C) 60,000 mPAS/Ps @ 392°F (200°C)	

### Processing

Methods	This adhesive is made for Holz-Her cartridge edgebanders.
Application temp	356°-392°F (180°-200°C)
Feed speed	Roller application: 18-60 m/min (50-180 ft/min) Nozzle application: 10-40 m/min (30-120 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	35 lbs net weight in cartons, 48 cartridges per carton.
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND Superior Adhesive

## Article 122880-001

Medium viscosity EVA edgebanding hot melt that is very economical with good color and heat stability in the melt. Excellent wetting and adhesion properties. Suitable for primed HPL, solid wood, veneer, resin-impregnated paper edgebands, PVC, ABS, PP and similar. Good cold flexibility.

### Characteristics

Type	Unfilled Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural
Softening point	194°F (90°C) Kofler Bench
Density (p)	1.03 (8.6lbs/gal)
Viscosity (μ)	95,000 mPAS/Ps @ 356°F (180°C) 70,000 mPAS/Ps @ 374°F (190°C) 50,000 mPAS/Ps @ 392°F (200°C)

### Processing

Methods	Optimum for medium- to high-speed, straight-line edgebanding as well as contour applications.
Application temp	356-392°F (180-200°C)
Feed speed	Roller application: 18-60 m/min (50-180 ft/min) Nozzle application: 10-40 m/min (30-120 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	55 lbs net weight in durable plastic bags
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND Superior Cartridge Adhesive

## Article 122005-001

Medium viscosity EVA edgebanding hot melt that is very economical with good color and heat stability in the melt. Excellent wetting and adhesion properties. Suitable for primed HPL, solid wood, veneer, resin-impregnated paper edgebands, PVC, ABS, PP and similar. Good cold flexibility.

### Characteristics

Type	Unfilled Ethylene-Vinyl Acetate (EVA) cartridge
Color(s)	Natural
Softening point	221°F (105°C) Ring & Ball
Density (p)	1.05 (8.7lbs/gal)
Viscosity (μ)	95,000 mPAS/Ps @ 356°F (180°C) 70,000 mPAS/Ps @ 374°F (190°C) 50,000 mPAS/Ps @ 392°F (200°C)

### Processing

Methods	This adhesive is made for cartridge edgebanders including Holz-Her
Application temp	356-392°F (180-200°C)
Feed speed	Roller application: 18-60 m/min (50-180 ft/min) Nozzle application: 10-40 m/min (30-120 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	In cartons, 26 lbs/box, 48 cartridge/carton
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND Economy Adhesive

## Articles 122941-003, 208

Economical, medium-viscosity hot melt suitable for a wide variety of edging including PVC, ABS, PP, veneer and melamine. A great all-purpose edgebanding adhesive.

### Characteristics

Type	Filled Ethylene-Vinyl Acetate (EVA)
Color(s)	White: 122941-003 Natural: 122941-208
Softening point	266°F (130°C) Ring & Ball
Density (p)	Approximately 1.40 g/ml (11.5 lbs/gal)
Viscosity (μ)	120,000 mPAS/Ps @ 374°F (190°C) 90,000 mPAS/Ps @ 392°F (200°C) 70,000 mPAS/Ps @ 410°F (210°C)

### Processing

Methods	Optimum for medium- to high-speed, straight-line edgebanding.
Application temp	374-410°F (190-210°C)
Feed speed	Minimum 15 m/min (50 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	122941-003 in 55 lbs net weight in durable plastic bags. 122941-208 in 44 lbs bags
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.



# RAUBOND Low Viscosity Contour Adhesive

## Article 122981-005

Low viscosity hot melt with fast melting properties, long open time as well as good color and heat stability in the melt. Suitable materials include PVC, ABS, PP, paper and polyester.

### Characteristics

Type	Filled Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural
Softening point	194°F (90°C) Ring & Ball
Density (p)	1.3 g/ml (10.8 lbs/gal)
Viscosity (μ)	60,000 mPAS/Ps @ 266°F (130°C) 40,000 mPAS/Ps @ 284°F (140°C) 30,000 mPAS/Ps @ 302°F (150°C)

### Processing

Methods	Designed for contour edgebanding with low application temperatures at slower feed speeds. Also suitable for soft-forming PVC edges.
Application temp	266-302°F (130-150°C)
Feed speed	Minimum 5 m/min (15 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	55 lbs net weight in durable plastic bags
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND High Viscosity Contour Adhesive

## Article 128010-001

High viscosity hot melt with high heat resistance and good cold flexibility. Excellent color and heat stability in the melt. Suitable for automatic edgebanding of solid wood, veneer, primed thermoplastic (PVC, ABS, PP) and resinated paper edgebands. Also used for soft forming application (especially on BAZ and Combiformer machines).

### Characteristics

Type	Unfilled Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural
Softening point	248°F (120°C) Ring & Ball
Density (p)	1.05 g/ml (8.7 lbs/gal)
Viscosity (μ)	200,000 mPAS/Ps @ 374 °F (190 °C) 150,000 mPAS/Ps @ 392 °F (200 °C) 110,000 mPAS/Ps @ 410 °F (210 °C)

### Processing

Methods	Designed for automatic contour edgebanding such as BAZ or Combiformer applications
Application temp	374-410°F (190-210°C)
Feed speed	Roller application: 18-60 m/min (50-180 ft/min) Nozzle application: 10-40 m/min (30-120 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	55 lbs net weight in durable plastic bags
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND Clear Adhesive

## Article 122990-204

Medium viscosity edgebanding hot melt with high heat resistance. Excellent color and heat stability in the melt. An optimal product for a wide variety of edging including PVC, ABS, PP, veneer and melamine. Excellent resistance to oxidation.

### Characteristics

Type	Unfilled Ethylene-Vinyl Acetate (EVA)
Color(s)	Clear
Softening point	239°F (115°C) Ring & Ball
Density (p)	1.00g/cm <sup>3</sup> (8.3 lbs/gal)
Viscosity (μ)	135,000 mPAS/Ps @ 356°F (180°C) 95,000 mPAS/Ps @ 374°F (190°C) 75,000 mPAS/Ps @ 392°F (200°C)

### Processing

Methods	Optimal for medium- to high-speed, straight-line edgebanding. Also great for soft-forming applications.
Application temp	356-392°F (180-200°C)
Feed speed	Roller application: 18-60 m/min (50-180 ft/min) Nozzle application: 10-40 m/min (30-120 ft/min)
Cleaning	Preliminary cleaning while hot by scraping with a spatula. Hot melt cleaner recommended for residual cleaning while cold.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	44 lbs net weight in durable plastic bags
Storage	In closed containers. Shelf life is at least 3 years from the date of manufacture in dry and cool 58-76°F (15-25°C) conditions.
Marking	None. We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND PUR Pellets

## Article 122993-005

Fast setting translucent bond with excellent thermal stability, high initial strength, high resistance to heat, water, steam, solvents and cleaners. For bonding thermoplastic edgebands such as ABS, PP, PVC with suitable primer application to the reverse side. Also for edgebands made from resinated decor paper, aluminum with an appropriate pretreatment, HPL or veneer. Specialized processing equipment from moisture-proof sealed containers required.

### Characteristics

Type	Reactive Polyurethane (PUR) granules
Color(s)	Translucent
Softening point	149°F (65°C) Kofler bench
Density (p)	1.10 g/cm <sup>3</sup> (9.18 lbs/gal)
Viscosity (μ)	90,000 mPAS/Ps @ 248°F (120°C)

### Processing

Methods	For automatic edgebanders with specialized PUR processing equipment
Application temp	212-248°F (100-120°C)
Feed speed	10-40 m/min (30-120 ft/min)
Cleaning	If necessary, flush out hot melt remnants from the melt and applicator units with Jowat Flushing agent 930.94. Use Jowat Cleaner 930.30 to dissolve solid material.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	10 lbs net weight, 9 cans per box
Storage	In sealed containers, cool and dry (15-25°C (59-77°F)) Please see container label for Best-before-date. After the elapse of the best-before-date, verify that the product is fit for intended application. Protect from moisture.
Marking	We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

# RAUBOND PUR Cartridge

## Article 122961-010

Fast setting translucent bond with excellent thermal stability, high initial strength, high resistance to heat, water, steam, solvents and cleaners. For bonding thermoplastic edgebands such as ABS, PP, PVC with suitable primer application to the reverse side. Also for edgebands made from resinated decor paper, aluminum with an appropriate pretreatment, HPL or veneer. Specialized processing equipment from moisture-proof sealed containers required.

### Characteristics

Type	Reactive Polyurethane (PUR) Cartridge
Color(s)	Translucent
Softening point	149°F (65°C) Kofler bench
Density (p)	1.10g/cm <sup>3</sup> (9.18 lbs/gal)
Viscosity (μ)	90,000 mPAS/Ps @ 248°F (120°C)

### Processing

Methods	This adhesive is made for PUR cartridge edgebanders including Holz-Her
Application temp	212-248°F (100-120°C)
Feed speed	10-40 m/min (30-120 ft/min)
Cleaning	If necessary, flush out hot melt remnants from the melt and applicator with Jowat Flushing Agent 930.94. Use Jowat Cleaner 930.30 to dissolve solid material.
Tips	A number of factors influence adhesion including substrate temperature and moisture content; ambient temperature, humidity and airflow; equipment type. Settings should be optimized for each material type and equipment at the customer's facility.

### Packaging/Storage

Packaging	14 lbs net weight, 24 cans per box
Storage	In sealed containers, cool and dry (15-25°C (59-77°F)) Please see container label for Best-before-date. After the elapse of the best-before-date, verify that the product is fit for intended application. Protect from moisture.
Marking	We recommend drawing off any vapors which may form. Consult Material Safety Data Sheet for additional information.

**Customer Service Contacts**

Hours Monday to Friday, 8 am to 6:30 pm EST

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