



H.B. Fuller

Connecting what matters.™

## WOOD AND COMPOSITES

# North America Edgebanding Selection Guide

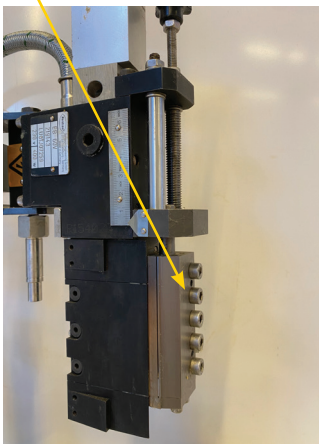


H.B. Fuller's hot melt and reactive adhesives for edgebanding bond to many substrates. Our hot melts were developed to run on many machine types at low to high speeds. Our low temperature application adhesives may enable lower energy and maintenance costs.

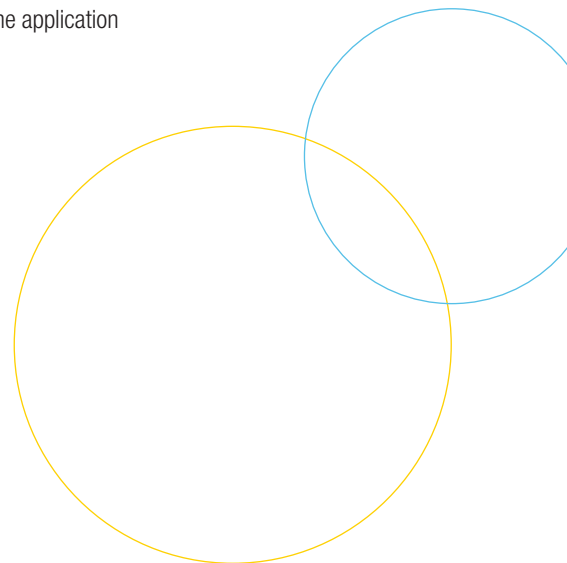
### TYPICAL APPLICATIONS

- Hot melt is applied with rollers or slot-dies to narrow board's face, and immediately pressed after the application

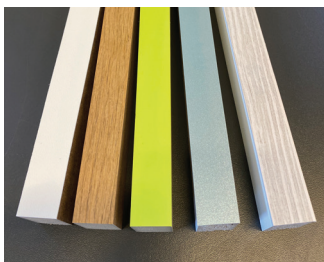
Nozzle



Roller



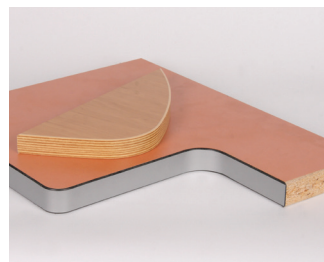
### TYPICAL PROCESSES



- **Straight edgebanding**  
Hot melt is applied with rollers or slot-dies to narrow the face of the board, being immediately pressed after the adhesive is applied



- **Softforming**  
The softforming process is used where the edges of plate shaped materials are particularly profiled for reasons of aesthetics or function (e.g. folded edges on doors) and are to be coated with a coating material



- **BAZ**  
Throughout this process, edge-banding is applied to shaped components in one continuous process, where trimming and scraping occur simultaneously



- **Precoating**  
In this process, the edgebands are precoated and by using heat, the adhesive film will be reactivated

## EDGEBANDING PORTFOLIO

Specifically formulated for edgeworking operations (automatic edgebanders and soft formers) where excellent adhesion to PVC, melamine, and wood is required.

Product	Line Speed (m/min)	Application temperature °C	Color	Softforming Y/N	BAZ Y/N	PRE COATING Y/N	Package size	Viscosity	Softening Point °C	Additional Information
<b>Ethylene Vinyl Acetate Copolymer (EVA) AND PO</b>										
<b>Rakoll® TE5700</b>	>15 m/min	160 - 190	Natural, White	NO	NO	YES	25 kg bag	82,000 @ 204°C	103	Universal adhesive, good heat resistance, cost-effective.
<b>Rakoll® SK K4/570</b>	>15 m/min	160 - 190	Brown, Natural, Black	NO	NO	YES	25 kg bag	65,000 @ 204°C	102	Universal adhesive, first choice for standard edgeworking.
<b>Rakoll Supermelt™ Pro</b>	>15 m/min	170 - 190	Natural	YES	YES	YES	25 kg bag	115,000 @ 204°C	110	High heat resistance with excellent adhesion to a wide variety of substrates.
<b>Rakoll Supermelt™ Plus</b>	>12 m/min	170 - 190	Natural Clear	YES	YES	YES	20 kg bag	54,000 @ 204°C	106	Adhesive for low application temperatures, slow line speeds and low coat weight applications. Long open time. Unfilled. Used for a wide variety of substrates. Natural clear color.
<b>Rakoll® Eclipse HL6733</b>	>15 m/min	180-190	Clear, Trans-parent	YES	YES	NO	22.68 kg bag	118,000 @ 204°C	110	Unfilled for lower coat weights and good bond (standard and BAZ) to most substrates. Edgeworking / Softforming. No stringing application with high strength for clean application. Can replace all colored hot melts with one colorless product. High heat resistance. Patented Water Clear product.
<b>Rakoll® 5728</b>	>20 m/min	190- 210	Colour-less - Clear	NO	NO	NO	25 kg bag	51,000 @ 204°C	127	Good spreading properties. High initial strength and high heat resistance. Good thermal stability. Polyolefin-based adhesives bond well with chipboard, MDF panels, plastic edges (ABS, PVC, PP), melamine and veneer edges.
<b>Hot Melt Polyurethane, HMMC PUR</b>										
<b>Rakoll® HL9622</b>	>8 m/min	120-140	White, Clear	YES	NO	NO	18.14kg pail	25,000 @ 140°C	103	High green strength. Good for vinyl, paper and wood veneers to MDF, particle board and composite.
<b>Swift® lock 2U464-1N</b>	>10 m/min	130-140	Clear Amber	YES	NO	NO	18.14kg pail	65,000 @ 140°C	107	Great adhesion to MDF, particle board, paper and wood veneers. Good balance of properties. Open time of ~30 sec.

## ABOUT H.B. FULLER

Since 1887, H.B. Fuller has been a leading global adhesives provider focusing on perfecting adhesives, sealants and other specialty chemical products to improve products and lives. H.B. Fuller's commitment to innovation brings together people, products and processes that answer and solve some of the world's biggest challenges. Our reliable, responsive service creates lasting, rewarding connections with customers in electronics, disposable hygiene, health and beauty, medical, transportation, aerospace, clean energy, packaging, construction, woodworking, general industries and other consumer businesses. And, our promise to our people connects them with opportunities to innovate and thrive.



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