

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

**Engineering progress
Enhancing lives**

**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

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Braniměřice, 39101 Břežany
www.rehau.com

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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 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]	10 – 75
Softening range [°C]	approx. 95 ± 5
Open time at 190 °C [s]	approx. 12 ± 1 (measured on a 200 µm film)

2.3. RAUBOND EVA 123

RAUBOND EVA 123 is characterized by its colorless, opaque appearance in the adhesive joint. It is therefore particularly suitable for processing dark edgebands and designs.

Properties

Base	Ethylene vinyl acetate copolymer (EVA)
Supply form	Pellets
Density at 20 °C [g/cm ³]	1.0 ± 0.02 (pycnometer, 100 ml)
Color	without colour
Viscosity at 200 °C [mPa·s]	85,000 ± 10,000 (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]	10 – 40
Softening range [°C]	approx. 95 ± 5
Open time at 190 °C [s]	approx. 9 ± 2 (measured on a 200 µm film)

2.4. Range of application

	RAUBOND EVA 111/112	RAUBOND EVA 121/122	RAUBOND EVA 123
Straight edgeband	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Soft-forming		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Processing center		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

2.5. General processing information

For bonding, the substrate material to which the edgebands are to be applied, as well as the edgebands themselves, should be dry and 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." Further information on safety, handling, transport and disposal can be found in the respective safety data sheet.

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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Helmut-Wagner-Straße 1
95111 Rehau, Germany

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