

Adhesives for flat lamination and sandwich panels



Your Advantages:

- > Long-lasting stability and durability
- > Excellent temperature resistance
- > High initial strength and fast curing
- > Humidity and media resistance
- > High productivity through automation
- > Broad application range and adhesion spectrum
- > Minimum pre-treatment needed
- > Solvent-free
- > Long storage stability

Flat lamination for:

- > Facade panels
- > Door panels
- > Wall and roof panels
- > Building and construction products
- > Recreational vehicles, e.g. caravans and motorhomes
- > Transportation vehicles, e.g. trucks, buses, and trains

Flat Lamination Adhesives

RAKU-PUR (2-Component PU)	49-3000	49-3000-90	49-3010	49-3020	49-3060-150	49-3060-40	49-3060-5	49-3070	49-3080
Color	beige	beige	anthracite	beige	beige	beige	beige	beige	blue
A / B Component	49-3000 A 49-2030 B	49-3000-90 A 49-2030 B	49-3010 A 49-2011 B	49-3020 A 49-2010 B	49-3060-150 A 49-2030 B	49-3060-40 A 49-2030 B	49-3060-5 A 49-2030 B	49-3070 A 49-2030 B	49-3080 A 49-2080 B
Mixing ratio A:B [by weight]	100 : 17	100 : 17	100 : 25	100 : 20	100 : 20	100 : 20	100 : 20	100 : 15	100 : 60
Viscosity ¹⁾ (A-Component) [mPas]	paste-like	paste-like	8,000	14,000	20,000	20,000	20,000	120,000	1,700
Viscosity (A:B Mixture) [mPas]	paste-like	paste-like	2,000	9,000	10,000	10,000	10,000	70,000	1,800
Density ²⁾ [g/cm ³]	1.65	1.65	1.58	1.48	1.50	1.50	1.50	1.78	1.09
Pot life ³⁾ [min] at 20 °C	60	90	6	11	150	40	5	90	8 (with 125 g)
Open time at 20 °C [min]	40	60	25	30	240	120	15	130	40
Hardness [Shore D]	80	80	80	67	67	67	67	70	70
Tensile strength ⁴⁾ [MPa]	9 (AlMg1)	9 (AlMg1)	11 (AlMg1), 6 (HPL)	16 (HPL), 8 (AlMg1)	8 (PVC), 6 (ABS), 11 (Stainless steel)	8 (PVC), 6 (ABS), 11 (Stainless steel)	8 (PVC), 6 (ABS), 11 (Stainless steel)	7 (PVC), 4 (ABS)	7 (PVC)
Characteristics	sag resistance, broad adhesion spectrum	sag resistance, broad adhesion spectrum	low viscosity, short pot life, good adhesion to laminate	middle viscosity, universally applicable	medium viscosity, long processing time, good adhesion to aluminum/wood	medium viscosity, good adhesion to aluminium/wood	medium viscosity, good adhesion to aluminium/wood	high viscosity, long pot life, universally applicable	good adhesion to PVC, spray application

RAKU-PUR (1-Component PU)	49-2050	49-2060
Colour	brown	clear
Viscosity ¹⁾ [mPas]	3,000	2,000
Density [g/cm ³]	1.10	1.10
Open time at 23 °C [min]	20	60
Pressing time at 20 °C [min]	60	60
Final strength [d]	3	3
Characteristics	long open time, foams slightly	DIN EN 204-D4, WATT 91

RAKU-MELT (Reactive Hotmelts)	46-4600	46-4610
Viscosity [mPas] at 130 °C	8,000	10,000
Open time at 20 °C [min]	10	2
Initial strength	good	very high
Application	roller spraying slot die	roller spraying
Characteristics	standard type, uni- versally applicable	very fast physical setting

¹⁾ Rheometer, plate, plate, 20 °C

²⁾ Mixture density (A : B)

³⁾ Adjustable as necessary

⁴⁾ DIN EN 1465

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby. The technical data overview is not a specification but contains indicative values. No liability accepted for misprints.

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