

Technical Data Sheet

Rhenocoll Heißschmelzkleber 638.1 Art. No.: A 1371



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Rhenocoll Heißschmelzkleber HSK 638.1

Hot melt adhesive HSK 638.1 based on ethylene vinyl acetate (EVA)

Art. No.: A 1371 (0-nature)

Art. No.: A 1372 (1-white)

Art. No.: A 1373 (2-brown)

Art. No.: A 1374 (3-black)

Specification: The hot melt adhesive HSK 631.1 is a filled hot melt which is distinguished by good thermal stability, a medium open time, as well as a high starting density and fast setting time. Suitable for an edge thickness of up to 2mm.

Application: For automatic glueing machines, for the glueing of solid wood, MDF and other fine-grained wood composite material with different edges with veneer, as well as primed thermoplastics (PVC, ABS, PP) and resinated paper. For professional use. Please observe the technical data sheet.

Technical values:

Viscosity (Brookfield; 150°C TR11-10rpm):	50000 – 70000 mPa*s
Density (23°C):	ca. 1,38 g/cm ³
Open time:	Medium
Heat resistance:	70 – 75°C
Processing temperature:	190 - 210 °C during melt
Rate of feed:	15 - 40 m/min

Processing instructions: The properties of the basic material and conditions during processing influence the glueing process. For this reason we recommend to conduct several tests. The materials to be glued must be dry and free from dust, oil and grease. The wood moisture should be ca. 8-10%. A minimum temperature of 18°C (room temperature and materials) should be adhered to. Avoid drafts. Lower temperatures will lead to problems with adhesion; higher temperatures for a long period will damage the glue and will lead to unwanted decomposition.

Cleaning: First clean in hot condition by scraping off with a putty knife. Clean off remains in cold condition with cleaner or thinner.

Storage: Dry and cool, storable for at least 12 months (according to our experiences).

Safety advice: During processing, common protection measures and regulations according to the authorized trade association must be observed. Safety-relevant data and instructions regarding disposal can be found in the safety data sheet.

Labeling: No labeling required

Supply units: 25 kg Hobbock

Service:

Our service team for application technology is available to you at any time without obligation.

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The information given within is without obligation and is based on practical experience as well as on experiments which we have carried out and are not attribute guaranties in the sense of the newest BGH legal requirements. We recommend that in any case users carry out their own tests since we have no influence over the large diversity of materials and their processing. No liability for the manufacturer can be derived from the contents of this data sheet. Statements going beyond or deviating from the contents of this data sheet require the written confirmation of the company headquarters. Our General Terms & Conditions apply in any case. With the release of this Technical Data Sheet all previous versions become obsolete.