



## EXPRESS COLLECTION

RAUBOND™ HOT MELT AND ADHESIVES  
FOR EDGE BAND APPLICATION

# HOT MELT AND ADHESIVES COLLECTION

## FORMING A STRONG BOND BETWEEN BAND AND BOARD

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

Recommended for use with all of our edgebands, our adhesives can be easily applied with any hotmelt 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 Express Collection stock program, our hot melt and adhesives can be purchased in small quantities and shipped along with our edgeband.

# PRODUCT OVERVIEW

## A SOLUTION FOR EVERY EDGEBANDING APPLICATION

Product	Application	Art. No.	Color	Packaging	Page
RAUBOND Universal	Low viscosity hot melt for PVC, ABS, PP, PET, melamine and veneer	122941-008	Natural	55 lbs./bag	4
		122941-003	White	55 lbs./bag	
RAUBOND Premium	Medium-high viscosity hot melt suitable for edgebanding, of PVC, ABS, PP, PET, veneer, solid wood, melamine and primed HPL	122870-001	Natural	55 lbs./bag	5
		122870-002	White	55 lbs./bag	
		122870-003	Brown	55 lbs./bag	
		122870-004	Black	55 lbs./bag	
RAUBOND Superior	High viscosity hot melt with high heat resistance and good cold flexibility, suitable for PVC, ABS, PP, PET, solid wood, veneer and melamine; also used for soft-forming applications	122990-001	Clear	55 lbs./bag	6
RAUBOND Unfilled	High end, high viscosity hot melt for automatic edgebanding of PVC, solid wood, veneer and melamine; especially suited for BAZ or Combiformer applications	122880-001	Natural	55 lbs./bag	7
RAUBOND Contour	Low viscosity hot melt for contour edgebanding of PVC, ABS PP, PET, paper and polyester at low application temperatures and slow feed speeds	122981-005	Natural	55 lbs./bag	8
RAUBOND Cartridge	Medium-high viscosity EVA hot melt for automatic edgebanding of PVC, ABS, PP, veneer, solid wood and primed HPL; use with Holz-Her cartridge edgebanders	122951-004	Natural	35 lbs./bag	9
		122951-007	White	35 lbs./bag	
		122951-006	Brown	35 lbs./bag	
		122951-005	Black	35 lbs./bag	
RAUBOND Unfilled Cartridge	Medium-high viscosity EVA hot melt for automatic edgebanding of PVC, ABS, PP, veneer, solid wood and primed HPL; use with Holz-Her edgebanders	122005-001	Natural	26 lbs./bag	10
Material Safety Data					11

# RAUBOND UNIVERSAL ADHESIVE

ARTICLES 122941-003, 008



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	Ethylene-Vinyl Acetate (EVA)
Color(s)	White: 122941-003 Natural: 122941-008
Softening Point	~ 230°F (110°C)
Density (p)	~ 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	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 PREMIUM ADHESIVE

ARTICLES 122870-001, 002, 003, 004

Medium-high 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	Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural: 122870-001      White: 122870-002 Brown: 122870-003      Black: 122870-004
Softening Point	230°F (110°C)
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 to high-speed edgebanding. This adhesive can also be used for precoating and soft-forming applications.
Application Temp	374-410°F (190-210°C)
Feed Speed	12-40 m/min (30-120ft/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	55 lbs. net weight in durable plastic bags
Storage	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 122990-001



High viscosity edgebanding hot melt with high heat resistance and good cold flexibility. Excellent color and heat stability in the melt. An optimum product for a wide variety of edging including PVC, ABS, PP, veneer and melamine.

Characteristics	
Type	Ethylene-Vinyl Acetate (EVA)
Color(s)	Clear
Softening Point	221°F (105°C) Ring and Ball
Density (p)	1.10 g/ml (9.1 lbs/gal)
Viscosity (μ)	135,000 mPAS/Ps @ 374°F (190°C)
	95,000 mPAS/Ps @ 392°F (200°C)
	75,000 mPAS/Ps @ 410°F (210°C)
Processing	
Methods	Optimum for medium to high speed, straight-line edgebanding. Also great for soft-forming 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 UNFILLED 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.



Characteristics	
Type	Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural
Softening Point	~ 221°F (105°C)
Density (p)	~ 1.05 g/ml (8.7 lbs/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 CONTOUR ADHESIVE

ARTICLE 122981-005



## RAUBOND Contour Adhesive

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	Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural
Softening Point	194°F (90°C) Ring and 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 6 m/min (20 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 CARTRIDGE ADHESIVE

ARTICLE 122005-001

Medium-high 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	Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural: 122005-001   White: 122951-007   Brown: 122951-006   Black:122951-005
Softening Point	221°F (105°C) Ring & Ball
Density (p)	1.05g/ml (8.7 lbs./gal)
Viscosity (μ)	95,000 mPAS/Ps @ 356°F (180°C) Brookfield-Thermosel 70,000 mPAS/Ps @ 374°F (190°C) 50,000 mPAS/Ps @ 392°F (200°C)
Processing	
Methods	This adhesive is made for Holz-Her cartridge edgebanders.
Application Temp	356°-392°F (18°0-200°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	26 lbs. net weight in cartons, 48 cartridges per carton.
Storage	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.

# RAUBOND UNFILLED ADHESIVE

ARTICLE 122880-001



Medium viscosity EVA edgebanding hot melt with high heat resistance and good cold flexibility. Very good color and heat stability in the melt. No filler composition offers reduced application weight. Suitable for a wide variety of edging including PVC, ABS, PP, veneer and melamine.

Characteristics	
Description	A medium viscosity EVA edgebanding hot melt with high heat resistance and good cold flexibility. Very good color and heat stability in the melt. The no filler composition offers a reduction in application weight. Suitable for a wide variety of edging including PVC, ABS, PP, veneer and melamine.
Type	Ethylene-Vinyl Acetate (EVA)
Color(s)	Natural
Softening Point	~ 221°F (105°C)
Density (p)	~ 1.05 g/ml (8.7 lbs/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.

# MATERIAL SAFETY DATA SHEET

## RAUBOND HOT MELT ADHESIVE

### Section I - Product Information

Product Identification - RAUBOND Hot Melt Adhesive- All Grades

Supplier Manufacturer - REHAU

Address - North American Headquarters: 1501 Edwards Ferry Road, N.E., Leesburg, VA 20176

Telephone - (703) 777-5255

Product Use - Hot Melt Adhesive

### Section II - Hazardous Ingredients

Material - CAS No. Concentration (ppm) OSHA (ppm) ACGIH TLV (ppm)

Vinyl Acetate Monomer 108-05-4 ≤ 10 10 10

### Section III - Physical Data

Melting Point - N/A Boiling Point N/A

% Volatiles - Negligible VOC % ≤ 10g/L

Water Solubility - Negligible Moisture Content ≤ 0.5%

Form - At room temperature solid; block, pellets or slugs

Odor - Mild ester odor

### Section IV – Fire Explosion Hazard Data

Flashpoint - >482°F (>250°C) COC

Fire and Explosion Hazards - None known to REHAU

Hazardous Combustion Products - Like most organic products, it may form carbon monoxide, -dioxide and other byproducts

Extinguishing Media - Water fog, carbon dioxide, foam, dry chemical

Special Firefighting Procedures - Do not use water to extinguish fire at temperatures above 430°F (220°C). Material may foam and sputter. Wear NIOSH/MSHA-approved positive pressure self-contained breathing apparatus if exposed to fumes.

### Section V – Reactivity Data

Stability - Stable

Conditions to Avoid - Do not heat above >430°F (>220°C) for prolonged time

Materials to Avoid - None known to REHAU

Hazardous Decomposition and Byproducts - Like most organic materials, it may form carbon monoxide, -dioxide and other by products

Hazardous Polymerization - Will not occur

### Section VI – Health Hazard Data

Routes of Entry - Inhalation: Of vapors of molten materials; Ingestion: Very unlikely; Skin: N/A

Health Hazards (Acute and Chronic) - None known to REHAU

Carcinogenicity - NTP: Not listed; IARC: Not listed; OSHA: Not regulated

Signs and Symptoms of Overexposure:

Eyes - Vapors and fumes may cause irritation

Skin - No known effects

Inhalation - Vapors and fumes may cause irritation of the nose, throat and respiratory tract

Chronic - None known to REHAU

Medical Conditions Generally Aggravated by Exposure - None known to REHAU

Emergency and First Aid Procedures:
Eyes - Flush with plenty of water; if irritation appears, consult a physician
Skin - If irritation appears, flush with plenty of soap and water. In case of contact with molten material, flush with plenty of cold water. Do not attempt to remove solidified materials. Consult a physician for burn treatment
Inhalation - Remove to fresh air. If breathing stops, administer respiration or oxygen; call a physician
Ingestion - Induce vomiting after drinking two glasses of water; consult a physician
<b>Section VII – Precautions for Safe Handling and Use</b>
Steps to be Taken in Case Material is Released or Spilled: - Pellets or solid material. Sweep area immediately and dispose of contaminated material accordingly.
Molten Material - Allow to cool and solidify; then remove
Waste Disposal Method - Dispose of as solid waste in compliance with federal, state and local regulations for non-hazardous substances
Precautions to be taken in Handling and Storage - Store in dry, clean and cool area. Avoid temperatures above 50°C (120°F) to prevent material from blocking
Other Precautions - Normal usage involves hot, molten adhesive which can cause severe burns; handle with care
<b>Section VIII – Control Measures</b>
Respiratory Protection - No special requirement under ordinary conditions of use when adequate ventilation is provided
Local Exhaust - Recommended to remove vapors when processing material
Protective Gloves - Wear heat protective gloves when processing
Eye Protection - Safety glasses recommended
Other Protective Clothing or Equipment - Protective apron, long sleeves and safety shower when processing material
Work/Hygienic Practices - Use good hygiene and housekeeping practices
<b>Section IX – Regulatory Information</b>
HMIS – Rating Health – 1; Flammability – 1; Reactivity – 0
DOT Proper Shipping Name - Not a regulated material
TSCA Status - All components of this material are registered under the regulation of the Toxic Substances Control Act
SARA Section 313 Listed Ingredients - Vinyl Acetate Monomer (108-05-4)
This product does not contain any toxic chemical subject to the reporting requirements of section 313 of Title III of the Superfund Amendments and Reauthorization Action of 1986 (SARA) and 40 CFR part 372.
<b>Section IX – Preparation Information</b>
Prepared by - Todd A. Woodruff, EHS Specialist, US & Mexico
Date of Preparation - April 20, 2006
Replaces - June 8, 2000

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For updates to this publication, visit [na.rehau.com/resourcecenter](http://na.rehau.com/resourcecenter)

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