H.B. Fuller | Rakoll Woodworking Adhesives

WOOD AND COMPOSITE

Changing the understanding of Cabinetry adhesives

H.B. Fuller has developed a unique hot melt technology for Cabinetry assembly that meets and exceeds performance of traditional polyamide products on the marketplace. **Rakoll® HM 2333** is safer to use and runs cleaner than polyamides, while offering stable and forgiving application implementation for all your cabinet assemble needs.

TYPICAL APPLICATIONS

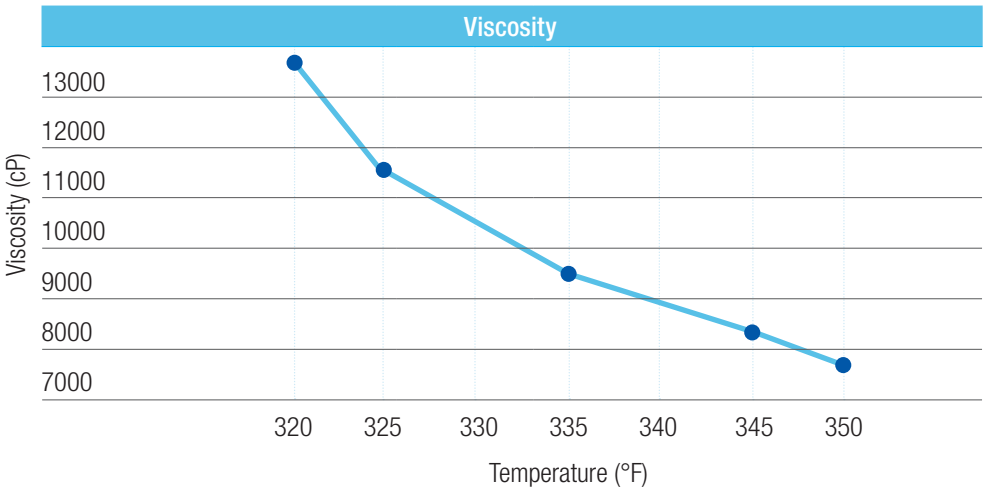
- Kitchen Cabinetry
- Furniture Assembly
- Woodworking Assembly

FEATURE & BENEFITS

- Lower application temperature – safer to use, less energy consumption
- Cleaner running – reduced maintenance of the hot melt application equipment
- Reducing stringing during usage – cleaner work area, reduced rework of finished products
- Adjustable speed of set – wide range of application temperatures

Rakoll HM 2333 is a fast setting thermoplastic hot melt adhesive with excellent heat resistance and good flexibility at low temperatures.

Rakoll HM 2333 is a hydrophobic material with good water resistance and good adhesion to low energy substrates like plastic. It doesn't stick to most decorative cabinetry finishes.



Facts about Polyamide Adhesives:

2%

Polyamide is hydrophilic and absorbs moisture over time. Polyamide can absorb up to 2% moisture in 24 hours. Moisture tends to cause foaming in tanks which creates increased maintenance and safety issues.

Polyamide hot melt adhesives often demonstrate poor stability in the hot melt tank due to thermal oxidization. This can lead to the adhesive darkening in color, skinning on the surface, and in extreme cases char builds up in the application equipment leading to increased maintenance and down time.

Rakoll® HM 2333 HAS:

- Lower application temperature (325º – 335º F) compared to polyamide hot melt (375º – 425º F)
- Higher green strength compared to polyolefin hot melts
- Faster set time compared to polyolefin
- Better heat resistance compared to EVA hot melts
- Better low temperature flexibility compared to typical polyamides
- Meets and exceeds Kitchen Cabinet Manufacturers Association (KCMA) cabinetry adhesive test standards
- Tougher than typical polyamides

	Rakoll HM 2333	Typical Polyamide
Bead to Molten (°F)	193	262
Transition Temp (°F)	260	295
Open Time (seconds)	12	10
Set Time Seconds	15	12
Mettler Softening Point (°F)	302	300
Ultimate Stress (psi)	429	375
Elongation (%)	703	475
Peel Adhesion Failure Temperature (°F)	184	155
Shear Adhesion Failure Temperature (°F)	255	250

Storage and Shelf Life

Store material in original unopened packaging at temperatures between 4°C and 32°C (40°F and 90°F). Shelf life is two years minimum when stored as recommended.

Health and Safety

Prior to working with this or any product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions.

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. With fiscal 2019 net revenue of approximately $3 billion, 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, 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. For more information, visit us at hbfuller.com.

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