

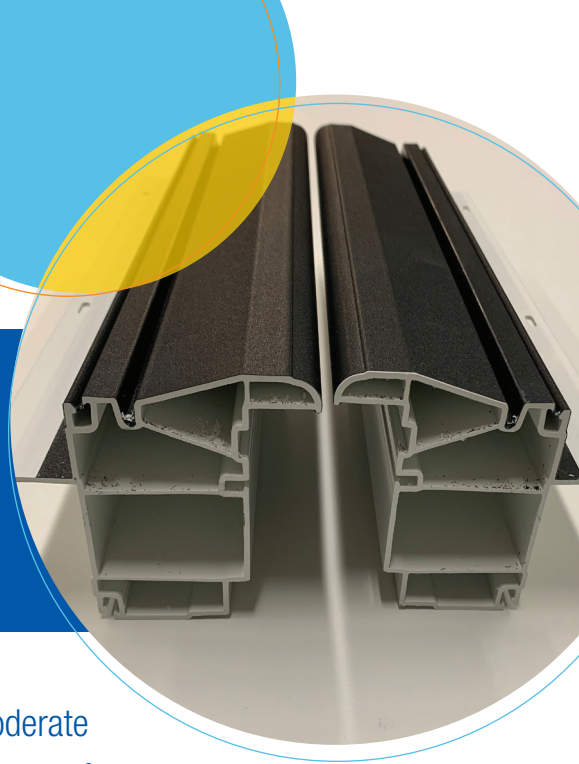


H.B. Fuller

Rakoll 
Woodworking Adhesives

WOOD AND COMPOSITES

Premium Exterior Profile Wrapping Adhesive System



When you manufacture window profiles that will be used in cold, moderate or hot and humid climates, you can rely on the high-quality performance of **Rakoll® 4780** and **Swift®prime 4956 FL**.

TYPICAL APPLICATION

- Rakoll® 4780 is an adhesive ideal for window profile wrapping (PVC, fiberglass, and aluminum).
- Swift®prime 4956 FL is applied to rigid PVC, fiberglass, and aluminum profiles to improve adhesion and final bond performance.

ADVANTAGES OF RAKOLL® 4780 AND SWIFT®PRIME 4956 FL

- Passes a demanding RAL 716 requirements
- Non-flammable, fast drying primer
- High curing speed increases productivity and reduces Work in Progress
- Very good performance on difficult to bond substrates
- High initial strength enables lamination of stiff foils and narrow edges

TYPICAL PROPERTIES

Properties	Rakoll® 4780
Color	Off-white
Density	1.10 g/cm ³
Open Time	20-40 seconds
Softening Point	75 °C
Application Temperature	120–140°C
Shelf Life	9 months

Properties	Swift®prime 4956 FL
Color	Yellowish
Density at 20°C	1.32 g/cm ³
Shelf Life	12 months

Profile wrapping with Rakoll® 4780 and Swift®prime 4956 FL

Profile wrapping is a process of bonding a decorative foil to the outside of a lineal profile. It requires a special equipment, adhesive, and in some cases a primer to wrap intricate profiles.

Rakoll® 4780 is a single-component, fully reactive hot melt adhesive that cross-links through a chemical reaction with moisture found in the surrounding air and substrates, to produce a thermoset adhesive. It was specifically designed to withstand demanding weathering conditions.

Swift®prime 4956 FL is a solvent-based adhesion promoter. It is used to pre-treat PVC, fiberglass, or aluminum window profiles prior to wrapping with **Rakoll® 4780**.



OUR APPLICATIONS CENTER

- We have a production capacity profile wrapping machine in our technical center, St. Paul, MN.
- We are capable of benchmarking adhesives or run small trials.
- Our technical experts will help you select the right adhesive for your decorative wrapping applications. Contact us to schedule a visit:
hbfuller.com or inquiry@hbfuller.com or 833-672-1482



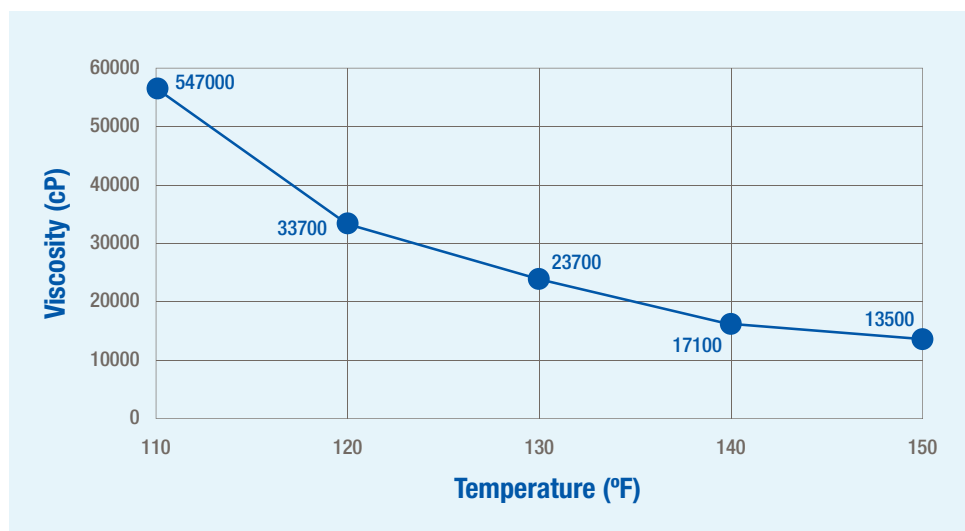
STORAGE AND SHELF LIFE

To ensure maximum stability, product should be stored in the original closed container in a clean and dry interior location capable of maintaining a constant temperature between 50 °F and 90 °F.

HEALTH AND SAFETY

Use only in equipment intended for reactive hot melts. Use with local exhaust ventilation to remove vapors anywhere heated product is exposed to air including adhesive un-loaders, pre-melters, and application areas. Local exhaust ventilation may be required to maintain exposures at safe levels. See Safety Data Sheet (SDS) for additional safety and handling information.

VISCOSITY CURVE



ABOUT H.B. FULLER COMPANY

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. 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 www.hbfuller.com/wood-adhesives

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IMPORTANT: The information contained herein is believed to be correct to the best of our knowledge. However the recommendations and suggestions herein are made without guarantee or representation as to results. It is the purchaser's responsibility to test and determine the suitability of the product for the purchaser's intended use and purpose. Purchaser assumes all risk and liability whatsoever regarding such suitability. Any product samples provided for testing are provided in accordance with standard limited warranties as stated on our technical data sheets.

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