

Rakoll Express™ 25 D

Type of Product PVA glue.

Product Characteristics

- reaches a very good final strength
- joints glued using this product are characterised by good resistance to dynamic loading, while at the same time displaying good static load-bearing capabilities

Typical Applications

- gluing of joints in boards and block gluing of hardwood
- gluing of joints in boards and block gluing of softwood and chipboard
- carcass and assembly gluing when average pressing times are required

Suitable substrates Wood and wood-based materials.

Typical Properties

Property	Value
Base	polyvinyl acetate dispersion (PVA)
Colour	yellowish, dries to light brown translucent
pH	approx. 7
White point	approx. 3°C
Viscosity (Brookfield HB, Sp3, 20rpm, at 20°C)	approx. 16 000 mPa.s
Shelf life	12 months

Application Instructions

The open time and the setting time are strongly influenced by the working conditions, e.g. humidity, absorbency of the materials as well as the quantities applied and tension in the material.

Good results will be achieved under the following conditions:

- Room, material and glue temperature: 18°C – 20°C
- Moisture content of the wood: 8 – 10%
- Relative humidity: 40 – 60%

Glue spread:

- for assembly gluing: 140 – 200 g/m²
- for surface gluing: 80 – 120 g/m²

Open time at 150 g/m²: 6 – 9 minutes

- Press pressure for tension free work-pieces:
– 0,1 - 0,5 N/mm²

Minimum pressing times:

- Block gluing of hardwoods: 12 – 15 minutes
- Joints in softwoods and chipboard: 8 – 13 minutes

Wood preparation:

In the case of hardwoods, the moisture content of the wood must be strictly within the specified range of 8 – 10%.

Cutting out the joints, joining and gluing should preferably be carried out on the same day.

Glue spread:

This product is normally applied evenly to one side using a brush or other suitable spreading appliance.

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Application Instructions**Pressing:**

Lay the items to be bonded together within the open time and press for as long as is required to obtain sufficient initial strength.

Wood discolouration:

This product does not cause discolouration of the wood. Iron in combination with the tannic acid of the veneer can however lead to changes of colour, particularly in the case of oak.

Cleaning Instructions

Please contact your local Sales Office for available cleaning solutions.

Typical Packaging

Please contact your local Sales Office for available packaging options.

Storage Conditions

In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above +5°C and below +35°C. Remaining below the recommended temperature, this product is not reusable after warming.

Disposal Advice

Please refer to the MSDS for disposal instructions.

Safety Advice

Please refer to the MSDS for safety advice.

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