

## Rakoll Express™ 45 N

<b>Type of Product</b>	High viscous PVA adhesive.
<b>Product Characteristics</b>	Sets quickly at normal temperatures and faster still under the influence of heat.
<b>Typical Applications</b>	Gluing HPL in short-cycle presses; carcass and assembly gluing; gluing joints in hardwood and softwood and any other wooden materials.
<b>Suitable substrates</b>	Wood and wooden based materials.

### Typical Properties

Property	Value
Base	Polyvinyl acetate dispersion (PVAc)
Colour	white
pH	approx. 6
White point	approx. +6°C
Viscosity (Brookfield HB, Sp3, 20rpm, at 20°C)	approx. 22 000 mPa.s
Shelf life	6 months

**Application Instructions**

The open time and the setting time are very dependent on working conditions, e.g. temperature and humidity, absorbcency of the materials being used, amount applied and tension in the material.

Good results will be achieved if the following conditions are observed:

- Room, material and adhesive temperature: 18°C – 20°C
- Wood moisture content: 8 – 10%
- Relative humidity: 40 – 60%

Amounts of adhesive to apply:

- for surface gluings: 80 – 120 g/m<sup>2</sup>
- for assembly gluings: 150 – 180 g/m<sup>2</sup>

Open time at 150 g/m<sup>2</sup> (on chipboard): 7 – 9 minutes

Press pressure for tension-free workpieces:

- Assembly gluing: 0,1 – 0,5 N/mm<sup>2</sup>

**Minimum pressing times:**

Surface gluing of HPL on chipboard in short-cycle presses at 60°C:

- approx. 45 seconds at 80 g/m<sup>2</sup> applied
- approx. 60 seconds at 100 g/m<sup>2</sup> applied

Assembly gluing at +20°C: 10 – 12 minutes

**Wood preparation:**

All parts should fit well and be free from dust and grease. Excessive fit tolerance will lead to longer setting times and weaker bonds.

The joints should be made shortly before bonding.

**Glue spread:**

Apply this adhesive evenly to one side using a glue spreading machine, a serrated spatula or any other suitable device.

**Pressing:**

Lay the items to be bonded together within the workable time and press them for as long a time as is needed to achieve sufficient initial strength.

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<b>Application Instructions</b>	<b>Wood discolouration:</b> This adhesive 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.
<b>Cleaning Instructions</b>	Please contact your local Sales Office for available cleaning solutions.
<b>Typical Packaging</b>	Please contact your local Sales Office for available packaging options.
<b>Storage Conditions</b>	In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above +5°C and below +35°C. Protect from frost.
<b>Disposal Advice</b>	Please refer to the MSDS for disposal instructions.
<b>Safety Advice</b>	Please refer to the MSDS for safety advice.

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