



Rakoll® express SR

Type of Adhesive Water-based, PVA adhesive.

- Product Benefits**
- low film formation temperature which sets within a moderate period of time and forms joints of high final strength
 - dries transparent and is kind to tools
 - the glue is somewhat thixotropic, which allows it to be used on vertical joints without running
 - classification according to DIN EN 204 - D 2

Typical Applications This product suitable for:

- frame gluing when average pressing times are required
- pencil manufacture
- manual dowel joining of frames

It can also be used for surface gluing of laminates and for doubling-up sheets.

Suitable substrates Wood, wood materials.

Typical Properties

| Property | Value |
|-------------|--|
| Basis | polyvinyl acetate dispersion (PVA) |
| Colour | white, transparent once dry |
| Viscosity | (Brookfield HB, spindle 3, 20 rpm, +20 C measured on the day of manufacture) approx. 13.000 mPa.s |
| White point | approx. 0°C |
| pH-Value | approx. 7°C |
| Shelf life | 12 months |



Application Instructions

The open time and the setting time are strongly influenced by the working conditions, e.g. humidity, absorbcency 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 adhesive temperature: 18-20°C
- Moisture content of the wood: 8-10%
- Relative humidity: 60-70%
- Coating weight: 120-200 g/m²
- Open time at 150 g/m²: 7-8 min
- Pressure for tension-free work-pieces: 0,1-0,5 N/mm²
- Minimum pressing times:
 - solid wood joints: 0-15 min
 - chipboard joints: 12-18 min
 - surface gluing of laminates at 20 °C and 150 g/m²: 14-18 min

Wood preparation

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

The evenly dried and acclimatised wooden parts should be planned on the day of gluing, as tolerances of fit can lead to prolonged setting times and reduced strength.

Glue spread

Apply this product evenly to one side using a brush, the glue bottle or another suitable spreading appliance.

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 dis-colouration 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.



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TECHNICAL DATA SHEET

| | |
|------------------------------|--|
| Cleaning Instructions | Clean tools with water before the adhesive dries. |
| 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. Protect from frost. |
| Disposal Advice | Please refer to the MSDS for disposal instructions. |
| Safety Advice | Please refer to the MSDS for safety advice. |

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H.B. Fuller Company

info-europe@hbfuller.com
www.hbfuller.com/
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