

Rakoll Express™ TO 50

Type of Product PVAc glue.

Product Characteristics After setting, the joints are firm, but still sufficiently flexible to permit cores to be transported.

Typical Applications

- gluing of block and strip cores
- surface gluing of HPL and CPL in short cycle presses
- carcass and assembly gluing when short pressing times are required, particularly when the parts are pre-heated
- gluing joints in boards and block gluing of softwoods and chipboard
- manual doweled gluing of box furniture

Suitable substrates Wood and wood-based materials.

Typical Properties

Property	Value
Base	polyvinyl acetate dispersion (PVAc)
Colour	white
pH	approx. 7
White point	approx. 3°C
Viscosity (Brookfield HB, Sp3, 20rpm, at 20°C)	approx. 14 000 mPa.s
Shelf life	9 months

Application Instructions

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

Good results will be achieved under the following conditions:

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

Glue spread:

- Guide value for gluing cores: 35 – 45 g/m²
- Surface gluing in short cycle presses: 80 – 100 g/m²
- Carcase and assembly gluing: 160 – 180 g/m²

Open time at 150 g/m²: 3 – 4 minutes

Press pressure: 0,2 – 0,5 N/mm²

Pressing times:

Pressing times depend on temperature conditions and the process rate, which depends on the width material.

Surface gluing of HPL sheets – minimum pressing times of +70°C, 1 minute is required.

Carcass and assembly gluing:

- at normal temperature: from 3 minutes
- pre-heated on one side: from 45 seconds

Wood preparation:

All parts should fit well and be dust and grease free. In the case of cores, generally saw-rough core strips are used, but these should be as straight as possible and cut exactly to size.

Glue spread:

Apply Rakoll Express™ TO 50 evenly to one side using a glue spreading machine, a toothed spatula or any other suitable device.

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Application Instructions	<p>Pressing: Lay the items to be bonded together within the open time and press for as long as is required to obtain enough initial strength.</p> <p>Wood discolouration: Iron in combination with the tannic acid of the veneer can however lead to changes of colour, particularly in the case of oak.</p>
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 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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