



### Rakoll Express™ 15

**Type of Adhesive** General wood assembly adhesive.

**Product Benefits** Sets quickly in accurately fitting joints reaching a good final strength.

**Typical Applications** Bench glue for joiner's shops, carcass and assembly gluing with average pressing times, bonding joints in boards made from softwood and chipboard, stationary edge banding using veneers, and solid wood strips, veneering using cold methods, manual gluing of box furniture.

**Suitable substrates** Different kind of woods and wooden substrates.

#### Typical Properties

Property	Value
Base	polyvinyl acetate dispersion (PVAc)
Colour	white
pH	approx. 6
White point	approx. 9°C
Viscosity (Brookfield HBT, Sp3, 20rpm, at 20°C)	approx. 12 000 mPa.s
Shelf life	12 months



### Application Instructions

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

#### Good results will be achieved under the following conditions:

- Room and material temperature: 18 – 20°C
- Moisture content of the wood: 8 – 10%
- Relative humidity: 60 – 70%

#### Glue spread:

- for assembly gluing: 160 – 180 g/m<sup>2</sup>
- for surface gluing: 100 – 140 g/m<sup>2</sup>
  
- Open time at 150 g/m<sup>2</sup>: 4 – 5 minutes

Press pressure for tension free work-pieces: 0,1 – 0,5 N/mm<sup>2</sup>

#### Minimum pressing times:

- for assembly gluing: from 6 minutes
- pre-heated on one side (+50°C): from 3 – 4 minutes

#### Wood preparation:

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

#### Glue spread:

Apply this glue evenly to one side using the glue bottle, brush or other 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 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.



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## TECHNICAL DATA SHEET

**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. Protect from frost.

**Disposal Advice** Please refer to the MSDS for disposal instructions.

**Safety Advice** Please refer to the MSDS for safety advice.

### Our Focus is Clear. Perfecting Adhesives.

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