

Rakoll[®]lackleim 8551

Type of Product Water based dispersion adhesive.

Product Characteristics

- medium viscosity
- good adhesion properties
- fast setting speed

Typical Applications Bonding of absorbent wood materials with painted surfaces as well as plastic surfaces.

Suitable substrates

- wood and wood-based materials
- painted surfaces
- plastic surfaces such as PVC, ABS

Typical Properties

Property	Value
Base	copolymer dispersion
Colour	white, transparent when dry
pH	approx. 8.5
White point	approx. 0°C
Viscosity (Brookfield HB, Sp3, 20rpm, at 20°C)	approx. 8 000 mPa.s
Shelf life	12 months

Application Instructions

The open time and setting time of the glue are strongly influenced by the conditions prevailing during working, e.g. temperature, humidity and, above all, the structure of the painted surface as well as the absorbency of the work pieces. The amount of glue applied and any tension in the materials have a large effect when gluing on paint.

Good gluing results will be achieved under the following conditions:
Room, material and adhesive temperature: 18°C – 20°C
Material moisture content: 8 – 10%
Relative humidity: 40 – 60%

Adhesive spread: approx. 150 g/m²
Open time at 150 g/m²: 3 – 6 minutes
Press pressure for stress-free work-pieces: 0,1 – 0,5 N/mm²
Minimum pressing time: from 3 minutes

Paint from individual manufacturers can have very different properties which influence the setting time and, above all, the joint strength. Preliminary trials over a minimum setting time of 24 hours should be carried out in any case.

Material preparation:

The surfaces to be glued should be free from dust and grease. The strip to be glued should be straight and free from tension. The joints should fit together exactly. An inaccurate fit will prolong the setting time and cause a reduction in strength.

Glue spread:

Apply the glue in a thin, even layer on the more suitable surface using a glue bottle, brush or roller.

Pressing:

Place the work-pieces together within the open time and press for as long as is needed to achieve sufficient initial strength. The pressure should be intense enough to ensure that the surfaces to be joined are brought tightly together.

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Cleaning Instructions	Clean working appliances with water before the glue 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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