

Rakoll® Express BL

Type of Adhesive

Dispersion adhesive.

Product Benefits

- long open time and low white point
- having a moderate setting time, it forms transparent joints with very good strength

Typical Applications

This product is suitable for:

- veneering using cold methods
- surface gluing of laminates in stack presses
- doubling-up of sheets in stack presses
- carcass and assembly gluing when particularly long open times are required
- gluing of joints in boards made from softwood, and chipboard
- manual assembly of box furniture and for pencil production

Suitable substrates

Wood and Wooden materials.

Typical Properties

Property	Value
Base	polyvinyl acetate dispersion (PVA)
Colour	white
Viscosity	approx. 15.000 mPa.s (Brookfield HB, Spindle 3, 20 rpm, 20 °C)
White point	approx. 0°C
pH value	approx. 6
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 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: 8 – 20 °C
- Moisture content of the wood: 8 – 12 %
- Relative humidity: 60 - 70 %
- Glue spread: 100 - 150 g/m²
- Open time at 150 g/m²: 18 - 20 min
- Press pressure for tension-free work-pieces: 0,1 - 0,5 N/mm²
- Pressing time:
 - for assembly gluing of chipboard: approx. 40 min
 - for surface gluing: approx. 30 - 40 min
 - for gluing joints in boards: approx. 25 - 30 min

Veneering at 60 °C – 70 °C: approx. 5 – 10 minutes

Wood preparation

All parts should mate well and be dust and grease free. Excessive thickness tolerances in the work-pieces can lead to uneven glue spread, causing longer pressing times and reduced strength.

Glue spread

Apply the product evenly to one side using a brush, trowel 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.



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 tightly closed original containers, protected from sun, between +5 °C and +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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