

Rakoll® Eco 3 ZF

Type of Product PVAc adhesive, meets the requirements of class D 3 as a one-component product, standard DIN EN 204.

Product Characteristics

- Formaldehyde free adhesive
- Low VOC (Volatile Organic Content)
- Good water resistance
- Quick setting time
- Bonded joints with good high-temperature resistance
- Does not discolour at high temperatures

Typical Applications This product can be used for a variety of applications including:

- surface gluing of décor finish film
- high-frequency bonding
- surface bonding of HPL/CPL in short cycle presses

Suitable substrates Wood and wood-based materials; décor finish foils

Typical Properties

Property	Value
Colour	white
pH	approx. 4.5
White point	approx. 5 °C
Viscosity (Brookfield RV, spindle 4, 20 rpm at 20 °C)	approx. 7.000 mPa.s
Shelf life	12 months

Application Instructions

Apply this product thinly and evenly to one side or, if a high degree of water resistance is required, to both sides, using a spreading machine, glue roller, serrated trowel, glue brush or another suitable device.

Good results will be achieved if the following conditions are observed:

Room and material temperature	18 °C – 20 °C
Moisture content of wood	8 – 10 %
Relative humidity	40 – 60 %
Amounts of adhesive to apply:	
For surface bonding	30 – 120 g/m ²
For assembly gluing	160 – 180 g/m ²
Open time at 150 g/m ²	8 – 9 minutes

Open time and setting time: strongly depend on working conditions such as temperature, humidity, absorbency of the materials being worked, and amounts applied.

The room temperature and the wood temperature must be at least +15 °C.

Wood preparation:

All parts should mate well and be dust and grease free. Over tolerances will lead to longer setting times and weaker bonds. The joints should be cut shortly before bonding.

Presses:

Lay the items to be bonded together within the workable time and press them for as long a time as is needed to achieve the required initial firmness upon release. The pressure should be high enough to ensure contact of the parts over the entire area of the joint. Depending on the material and the type of bond being used, the mechanical firmness required for further processing of the parts is achieved within the shortest possible space of time. The higher levels of water resistance form more slowly and should be tested not earlier than 7 days after bonding.

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Press pressure, depending on type of bonding: 0,1 – 0,8 N/mm²

Minimum pressing times:

- surface gluing of veneer film in short cycle presses:
45 seconds at +70 °C
- high-frequency bonding with longitudinal heating:
from 15 seconds

Surface gluing of HPL/CPL in short cycle presses at 70 °C: from 60 seconds

Assembly gluings: 8 – 15 minutes

Boards and block gluing: 10 – 15 minutes

Cleaning Instructions	Clean machine and tools with warm water before the adhesive dries.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	In original sealed packaging in clean and dry conditions above +5 °C and below +35 °C. Store this product away 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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