JAHN PIANOTEILE

RAKOLL®- Express 45 N

Fast-setting PVA Glue

Properties
RAKOLL®-Express 45 N is a high viscous PVA glue which sets quickly at normal temperatures and faster still under the influence of heat.

Classification according to

DIN EN 204 - D 2

Applications
- Gluing HPL in short-cycle presses
- Carcase and assembly gluing
- Gluing joints in hardwood and softwood and any other wooden materials

Instructions for use
The open time and the setting time are very dependent on working conditions, e. g. temperature, humidity, absorbency of the materials being used, amount applied and tension in the material.

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

Room, material and adhesive temperature	18 ... 20 °C
Wood moisture content	8 ... 10 %
Relative humidity	60 ... 70 %
Amounts of adhesive to apply:	
for surface gluings	80 ... 120 g/m²
for assembly gluings	150 ... 180 g/m²
Open time at 150 g/m² (on chipboard)	7 ... 9 min
Press pressure for tension-free workpieces:	
Assembly gluing	0,1 ... 0,5 N/mm²

Minimum pressing times
- Surface gluing of HPL on chipboard in short-cycle presses at 60 °C:

  approx. 45 s at 80 g/m² applied
  approx. 60 s at 100 g/m² applied

- Assembly gluing at + 20 °C 10 ... 12 min

Wood preparation
All parts should fit well and be free from dust and grease. Excessive fit tolerance will lead to longer setting times and weaker bonds.

The joints should be made shortly before bonding.

Glue spread
Apply RAKOLL®- Express 45 N evenly to one side using a glue spreading machine, a serrated spatula or any other suitable device.

Pressing
Lay the items to be bonded together within the workable time and press them for as long a time as is needed to achieve sufficient initial strength.

Wood discolouration
RAKOLL®- Express 45 N 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
Clean work utensils with water before the adhesive dries.

Alle Angaben und technischen Daten zum Zeitpunkt der Drucklegung 07/01. Änderungen vorbehalten. Alle Preise freibleibend, netto ab Lager zuzüglich Mehrwertsteuer.
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Chemical/Technical data

Base:	Polyvinyl acetate dispersion (PVA)
Colour:	white
Viscosity: (Brookfield HBT Spindle 3, 20 rpm @ + 20 °C on the day of production)	approx. 22.000 mPa.s
White point:	approx. + 6 °C
pH value:	approx. 6

Marking

RAKOLL®- Express 45 N is not subject to the mar-king regulations pursuant to the Dangerous Goods Act in its present version.

Storage

Store away from frost in tightly closed original containers.

Technical stage of development: July 2001
The data of former leaflets which differ from this version are no longer valid.

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