

Express BL

PVA glue with long open time

Properties

RAKOLL®-Express BL is a dispersion glue with a particularly long open time and low white point. This provides a wide operating latitude for gluing in the joiner's shop. Having a moderate setting time, it forms transparent joints with very good strength. It is not damaging to tool cutting edges.

Classification according to DIN EN 204 - D 2

Application

- 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

RAKOLL®-Express BL is also suitable for the manual assembly of box furniture and for pencil production.

Instructions for use

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 ... 10 %
Relative humidity	60 ... 70 %
Glue spread	100 ... 150 g/m ²
Open time at 150 g/m ²	18 ... 20 min
Press pressure for tension-free work-pieces	0,1 ... 0,5 N/mm ²

Pressing times: for assembly gluing of chipboard	approx. 40 min
for surface gluing	30 ... 40 min
for gluing joints in boards	approx. 25 min

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 RAKOLL®-Express BL 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

RAKOLL®-Express BL 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 tools with water before the adhesive dries.

Labelling

RAKOLL®-Express BL is not subject to marking regulations pursuant to the Dangerous Goods Act in its present version.

Storage

Store RAKOLL®-Express BL in tightly closed original containers protected from frost.

The shelf life is at least 12 months.

Chemical-technical data

RAKOLL®-Express BL

Basis:	Polyvinyl acetate dispersion (PVA)
Colour:	white
Viscosity: (Brookfield HB, Spindle 3, 20 rpm, +20 °C on the day of manufacture)	approx. 15.000 mPa.s
White point:	approx. 0 °C
pH value:	approx. 6

Technical stage of development: March 2006

The data in former leaflets which differ from this version are no longer valid.



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