

RAKOLL®

Woodworking Adhesives

PRODUCT INFORMATION

RAKOLL GXL-3P - D3

LAMINATION

FOR INDUSTRIAL USE. ONE COMPONENT, PVA GLUE VERY STRONG FOR WOODLAMINATION. MOISTURE RESISTANT BONDING. EUROPEAN STANDARD QUALITY (DIN EN 204-D3 SOLID CONTENT 50% MINIMUM)

Characteristic

RAKOLL GXL-3P is a PVA Glue with good water resistance properties, which meets D3 standard, and when mixed with RAKOLL GXL-3P Hardener can achieve D4 standard according to EN 204 testing.

RAKOLL GXL-3P mixed with the hardener sets quickly, providing shortest pressing time under the influence of heat. The glued joints are very strong and have excellent resistance to heat and water.

Strain Group according to DIN EN 204

Without hardener D3 (expert's report WKI)

Fields of Application

- Moisture resistant gluing of windows, doors, and stairs according to EN204-D3
- Surface gluing of decorative papers.
- High frequency gluing.
- Stationary edge gluing with veneers, plastics laminates and solid wood strips.
- Surface gluing of decorative high pressure laminates in short-cycle press.
- Cabinets and assembly gluing with medium pressing times and preheating devices.
- Board join and block gluing of softwood, hardwoods and chipboards

Instruction for use

The open assembly and setting times largely depend upon the working conditions as such temperatures, moistures, absorbency and materials, glue spreads and tensions of the materials. Good results are obtained under the following conditions:

Room, material and glue temperature	18-20°C
Wood, moisture	8-10 %
Relative Humidity	60-70%
Glue spread: for surface gluing	80-140 g/m ²
for assembly gluing	160-180 g/m ²
Open assembly time for 150 g/m ²	8-10min.
Pressure depending on type of gluing	0, 1-0, 8 N/mn ²

Minimum press times:	
Surface gluing of decorative papers	from 10 sec.
High frequency gluing with longitudinal heating	from 20 sec.
Surface gluing of high-pressure laminates in Short-cycle presses (+40°C)	from 60 sec
Assembly gluing	30 mins.
Board joint and blocks gluing	45 mins.

FOR ALL TYPES OF JOINTS LAMINATIONS:



FOR MORTISE & TENON JOINTING



FOR DOWEL & DOVETAIL JOINTING



Preparing the wood

The parts should fit exactly and be free from dust and grease. Variations in thickness cause prolonged setting times and reduces bond strengths.

Application of glue

Apply RAKOLL GXL-3P in a thin and uniform coating to one surface. If higher water resistance is required, apply to both surfaces. RAKOLL GXL-3P can be applied using glue spreaders and rollers. Notched trowels, brushes or other appropriate tools.

Pressing

Join the parts within the open assembly time and press until a sufficient initial strength is obtained. The pressure should be as high as necessary to ensure a close contact between the surfaces to be bonded.

Discoloration of Wood

RAKOLL GXL-3P does not cause any discoloration. Iron, however, can react with the staining on wood; especially Oak, and produces a dark stain.

Cleaning up

Water may be used as cleaning agent. Whenever possible to clean up the adhesive before it dries. Use a damp cloth to wipe off excess, the cloth may be re-used provided it is rinsed before the adhesive dries.

Technical Data Sheet

Type	Homopolymer Emulsion
Base	PVA dispersion
Color	White
Odor	Characteristics
Ph-value Acid	2.5 - 4.0
Viscosity	8,000 - 13,000 cps
Total Solid	50.0% minimum

The viscosity is measured with the Brookfield viscometer at +20 degree C. The values apply to the day of production.

Marking

RAKOLL GXL-3P needs not be marked as required by the regulation on hazardous products.

Safety recommendation

If RAKOLL GXL-3P comes into contact with the eyes, wash thoroughly with water and seek medical advice immediately. Prolonged or repeated contact with skin may cause irritation.

Handling and Storage

Store in tightly closed original containers and protect from frost and direct sunlight. After a prolonged storage RAKOLL GXL-3P can slightly thicken, therefore, the glue should well before use, especially when stored for an extended period of time. For best result, use product within 6 months.

Observations

All the information, whether written or verbal regarding our products, their applications and uses, is given in good faith and based upon the test made by us. Results of our research work and practical experience.

Whilst we guarantee the constant quality of our products, we cannot be responsible for the results obtained using our products, and recommend that tests should be made to determine the suitability of a particular product for a specific purpose before production is commenced. Otherwise the general terms of sales and delivery are valid.

IMPORTANT - The information contained herein is based on data available to use and is believed to be reliable. Since this information may have been obtained in part from independent laboratories or other sources not under direct supervision, no representation is made that the information is accurate, reliable, complete or representative. We make no guarantee that the health and safety precautions we have suggested will be adequate for all individuals and/or situations involving its handling and use. Our only obligation shall be to replace or pay for any material proved defective. Beyond the purchase price of the material supplied by us, we assume no liability for damages of any kind and the user accept the product "as is" and without warranties expressed or implied. The suitability of the product for an intended use shall be solely up to the user. User assumes all risk and liability whatsoever in connection herewith.

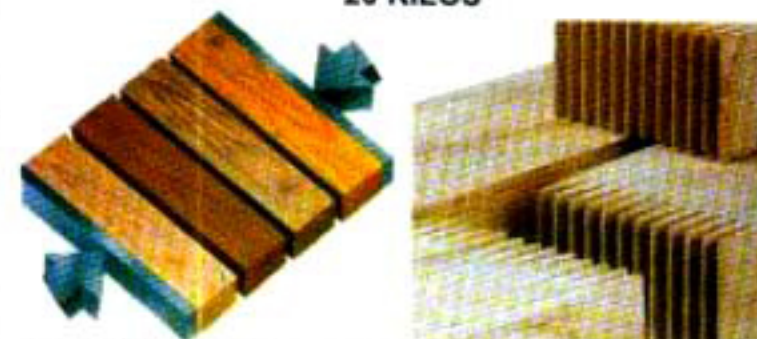
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FOR EDGE TO EDGE LAMINATIONS & FINGER JOINTING

OTHER JOINTS CAN BE ACHIEVED W/ THIS GLUE:

- Laminated joints
- Butt
- Splines
- Tongue & groove
- Surface to Surface Laminations
- Mitre joints
- Flat mitre with dowels joint
- Or any other joints