

## TECHNICAL DATA SHEET

### RAKOLL 45D

Page 1 of 1  
Version 2  
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#### Characteristics:

RAKOLL 45D is a high performance D2 wood glue which, when cured, gives strong bonds in general carpentry applications.

RAKOLL 45D has a medium set speed and is suitable for many of the timber substrates (both hardwoods and softwoods) used by professional carpenters and woodworking trade professionals.

Appearance	White creamy liquid
Viscosity	4,500–5,500cPs
Total Solids Content	43 - 46 %
Specific Gravity	1.06 g/ml
pH	3 - 5

#### Woodworking

- Timber moisture content should be between 10% and 14%.

#### Limitations

- Ambient and timber temperatures should be above 15°C. Best results are obtained when operating in the temperature range of 18-23°C.
- Apply enough adhesive to ensure the glue line is fully covered and wet-out when surfaces are pressed together.
- Do not use below 10°C.
- Not suitable for exterior or load bearing applications

- Adhesive should be applied as a thin, even coating to one surface only. Parts should be combined, while the adhesive is wet, using good even pressure; 200-900 kPa (30 to 130 psi) is recommended.
- Parts should be clamped for 3 to 4 hours and will reach full strength in 24 to 48 hours, depending on the moisture content of the timber, ambient temperature and humidity.

#### Cleaning

Clean up adhesive while wet with warm water.

#### Storage

Product should be stored out of direct sunlight between 15°C and 35°C and protected from freezing. Rotate stock using oldest batches first. Close containers air tight after use.

For best performance use product within 12 months.

#### Safety & Disposal

This material is non-hazardous. Refer to the Safety Data Sheet (SDS) for further information.

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