

TECHNICAL DATA SHEET – OCTOBER 2017

RAKOLL XL3 HV LOT

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Version 2

17/10/2017

Characteristics:

RAKOLL XL3 HV LOT is a high performance, one-part cross-linking PVA wood glue which when cured gives strong bonds in general carpentry, door pressing and veneering applications.

Bonds made with RAKOLL XL3 HV LOT exhibit good heat and water resistance and will conform to EN 204 – Group D3. It is therefore ideal for use in high humidity areas such as bathrooms and laundries.

RAKOLL XL3 HV LOT is a long open time product particularly suited to cold press operations

Appearance	White creamy liquid
Dry Film	Tough and hard yet flexible
Viscosity	12,000 – 14,000 cPs
Total Solids Content	41 - 44 %
Specific Gravity	1.06 g/ml
pH	3 - 5

Application Information

RAKOLL XL3 HV LOT is designed to be used by squeeze bottle or roller. Dilution is not recommended. Ensure substrates are free from oils dirt or grease.

Woodworking

- Timber moisture content should be between 10% and 12%.
- Ambient and timber temperatures should be above 15°C. Best results are obtained when operating in the temperature range of 18-23°C.

- Adhesive should be applied as a thin, even coating to one surface only. Apply enough adhesive to ensure the glue line is fully covered and wet-out when surfaces are pressed together.
- 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.

Door Pressing and Veneering

- Application rate should be tested on each species of veneer. It will vary depending upon absorption rates but an indicative norm to achieve good bonds is 190-240 gsm.
- Open time should not exceed 15-20 minutes.
- Assembly time should not exceed 20 minutes.
- Best results are obtained by a pressing platen temperature of 90-105°C for approximately 45-60 seconds using a pressure of 400 – 600 kPa (4 – 6 bar).

Our Focus is Clear. Perfecting Adhesives.

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Limitations

Do not use RAKOLL XL3 HV LOT below 10°C.
RAKOLL XL3 HV LOT is not suitable for exposed exterior or load bearing applications.
If a faster setting or sandable cross-linking PVA is required, try RAKOLL XL3 PLUS.
Lower viscosities can be obtained with RAKOLL XL3.

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Cleaning

Clean up adhesive while wet with warm water.

Storage

Product should be stored in the original container out of direct sunlight between 5°C and 30°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 Material Safety Data Sheet (MSDS) for further information.

Made in Australia

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