

## TECHNICAL DATA SHEET – MARCH 2017

### RAKOLL XL3

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Version 1

01/03/2017

#### Characteristics:

RAKOLL XL3 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 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 is classed as fast setting and responds well to RF curing.

|                      |                             |
|----------------------|-----------------------------|
| Appearance           | White creamy liquid         |
| Dry Film             | Tough and hard yet flexible |
| Viscosity            | 6,000–8,000cPs              |
| Total Solids Content | 48 - 50 %                   |
| Specific Gravity     | 1.06 g/ml                   |
| pH                   | 3 - 5                       |

#### Application Information:

RAKOLL XL3 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.
- Apply enough adhesive to ensure the glue line is fully covered and wet-out when surfaces are pressed together.
- 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.

#### 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 5-10 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). Ambient and timber temperatures should be above 15°C. Best results are obtained when operating in the temperature range of 18-23°C.

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#### Limitations

Do not use RAKOLL XL3 below 10°C.  
RAKOLL XL3 is not suitable for exposed exterior or load bearing applications.

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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.

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