

## Rakoll Express® 25 Plus

**Type of Adhesive** Water-based adhesive.

**Product Benefits**

- very good final strength on setting
- joints glued using this adhesive are characterised by good resistance to dynamic loading, while at the same time displaying good static load-bearing capabilities

**Typical Applications** Frame gluing, manual doweled gluing of upholstered, furniture frames, gluing of joints in boards and block gluing of hardwood, gluing of joints in boards and block gluing of softwood and chipboard, carcass and assembly gluing when average pressing times are required.

**Suitable substrates** Various type of woods and wooden substrates.

### Typical Properties

Property	Value
Base	polyvinyl acetate dispersion (PVA)
Colour	yellowish, dries to light brown translucent
pH	approx. 4.5
White point	approx. 5°C
Viscosity (Brookfield RV, Sp5, 20 rpm, at 20°C)	approx. 20.000 mPa.s
Shelf life	12 months

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### **Application Instructions**

The open time and the setting time are strongly influenced by the working conditions, e.g. 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: 18 – 20°C
- Moisture content of the wood: 8 – 10%
- Relative humidity: 60 – 70%
- Glue spread:
  - for assembly gluing: 140 – 200 g/m<sup>2</sup>
  - for surface gluing: 80 – 140 g/m<sup>2</sup>
- Open time at 150 g/m<sup>2</sup>: 6 – 9 min
- Press pressure for tension-free work-pieces:
  - 0,1 – 0,5 N/mm<sup>2</sup>

Minimum pressing times:

- Doweled and dovetail joints in hardwood depending on fit of joints: 10 min
- Block gluing of hardwoods: 12 – 15 min
- Joints in softwoods and chipboard: 8 – 13 min

### **Wood preparation:**

In the case of hardwoods, the moisture content of the wood must be strictly within the specified range of 8 – 10%.

Cutting out the joints, joining and gluing should preferably be carried out on the same day.

### **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:**

This product 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.



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TECHNICAL DATA SHEET

## Rakoll Express® 25 Plus

**Cleaning Instructions** Please contact your local Sales Office for available cleaning solutions.

**Typical Packaging** Please contact your local Sales Office for available packaging options.

**Storage Conditions** In original sealed packaging protected from sun, dust, moisture and high temperatures in clean and dry conditions.  
Protect from frost.

**Disposal Advice** Please refer to the MSDS for disposal instructions.

**Safety Advice** Please refer to the MSDS for safety advice.

Our Focus is Clear. **Perfecting Adhesives.**

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