

## TECHNICAL DATA SHEET – OCTOBER 2017

### RAKOLL XL3 HV PLUS

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Version 2

17/10/2017

#### Characteristics:

RAKOLL XL3 HV PLUS is a high viscosity, high performance, one-part cross-linking PVA wood glue which when cured gives strong bonds in general carpentry, door pressing, veneering and floating floor bonding and profile applications. Its high viscosity makes it ideal to use on very porous substrates such as found in the manufacture of fire doors, and in vertical applications where a high viscosity, fast-setting adhesive is beneficial.

Bonds made with RAKOLL XL3 HV PLUS are sandable and exhibit good heat and water resistance and will conform to EN 204 – Group D3. It can therefore be used in high humidity areas such as bathrooms and laundries.

RAKOLL XL3 HV PLUS is classed as fast setting (faster than standard cross-linking PVAs) and responds well to RF curing.

Appearance	White creamy liquid
Dry Film	Tough and hard yet flexible
Viscosity	12,000 – 14,000 cPs
Total Solids Content	53 - 57 %
Specific Gravity	1.06 g/ml
pH	3 - 5

#### Application Information

##### Application Information

RAKOLL XL3 HV PLUS 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%.

- 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 (the time between applying glue film and mating with cover sheet substrate) should not exceed 5-10 minutes.
- Assembly time (the time mated substrates are formed into a dead stack, but yet to enter press) should not exceed 25-30 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). Alternatively cold press for 35-45 minutes at 20°C ambient, but ideally 3-4 hours if work cycle permits.

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- Ambient and timber temperatures should be above 15°C. Best results are obtained when operating in the temperature range of 12-23°C.

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#### Limitations

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

#### 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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