

TECHNICAL DATA SHEET – OCTOBER 2017

RAKOLL XL3 PLUS

Page 1 of 2
Version 2

17/10/2017

Characteristics:

RAKOLL XL3 PLUS is a high performance, one-part cross-linking PVA wood glue which is suitable for bonding expanded polystyrene foam to fibre cement sheet. It also gives very strong bonds in door pressing, veneering and absorbent panel applications.

Bonds made with RAKOLL XL3 PLUS are sandable and exhibit good heat and water resistance, conforming to EN 204 – Group D3.

RAKOLL XL3 PLUS 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 – 7,000 cPs |
| Total Solids Content | 51 - 54 % |
| Specific Gravity | 1.06 g/ml |
| pH | 3 - 5 |

Application Information

RAKOLL XL3 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%.
- Ambient and timber temperatures should be above 15°C. Best results are obtained when operating in the temperature range of 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 (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 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.

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

NOTE TO USER: by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

Australia
Tel: +61 1800 423 855
customer.service@hbfuller.com
China & Hong Kong
Tel: +86 20 82068291
cs.china@hbfuller.com
Indonesia
Tel: +62-21-5307232/33

Korea
Tel: +82 2 786 8296
cskorea@hbfuller.com
Malaysia
Tel: +603 3345 5200
New Zealand
Tel: +64 800 555 072
customer.service@hbfuller.com

Philippines
Tel: +63 2 5194073
Taiwan
Tel: +886 2 26033385
Thailand
Tel: +66 2 3757442
Vietnam
Tel: +84 8 22225588



H.B. Fuller

TECHNICAL DATA SHEET – OCTOBER 2017

RAKOLL XL3 PLUS

Page 2 of 2

Version 2

17/10/2017

Limitations

Do not use RAKOLL XL3 PLUS below 10°C.
RAKOLL XL3 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 Safety Data Sheet (SDS) for further information.

Made in Australia

Our Focus is Clear. Perfecting Adhesives.

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

NOTE TO USER: by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

Australia

Tel: +61 1800 423 855
customer.service@hbfuller.com

China & Hong Kong

Tel: +86 20 82068291
cs.china@hbfuller.com

Indonesia

Tel: +62-21-5307232/33

Korea

Tel: +82 2 786 8296
cskorea@hbfuller.com

Malaysia

Tel: +603 3345 5200

New Zealand

Tel: +64 800 555 072
customer.service@hbfuller.com

Philippines

Tel: +63 2 5194073

Taiwan

Tel: +886 2 26033385

Thailand

Tel: +66 2 3757442

Vietnam

Tel: +84 8 2225588



H.B. Fuller