

Rakoll Express™ DKN

Type of Product PVAc glue.

Product Characteristics

- very low viscosity
- suitable for low pressure automatic doweling machines

Typical Applications Mechanical dowel gluing in low pressure automatic doweling machines.

Suitable substrates Wood and wood-based materials.

Typical Properties

Property	Value
Base	Polyvinylacetate dispersion (PVAc)
Colour	white, dry, transparent
pH	approx. 7
White point	approx. +10°C
Viscosity (Brookfield RV, Sp2, 50rpm, at 20°C)	150 +/- 25 mPa.s
Shelf life	12 months

Application Instructions

Rakoll Express™ DKN is supplied ready for use.
The glue should be stirred thoroughly before use, e.g. filling the pressure container of an automatic doweling machine.

Recommended working conditions:

- Room-material and glue temperature: 18°C – 20°C
- Wood moisture content: 8 – 12%
- Relative air humidity: 40 – 70%

Machine settings:

The machine must be set up in accordance with the instructions of the manufacturer. Generally, a pressure of about 3,0 bar in the pressure containers is enough. It is helpful to clean the spray nozzles with a moist rag at the beginning of each break to avoid deflection of the spray caused by adherence of dried glue. As the viscosity of Rakoll Express™ DKN is temperature-dependent, the spray quantity should be checked at frequent intervals. If the quantity of injected glue is too small, it will result in reduced strength of the joints.

Dowels:

Wooden dowels should be made from sound, strong wood and be thoroughly dried. They must be produced to exact size and have a very fine fluting and fitting exactly into the intended holes.

The strength of the joint depends to a large extent on the fit accuracy of the dowel and the glue usage. If using plastic dowels, the adhesion depends on the composition and the surface texture of the dowel. As the conditions in the joint during setting are different from those for wooden dowels, which expand slightly and therefore achieve a higher initial strength, it is in any case recommended that adequate preliminary trials be carried out when using plastic dowels.

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Application Instructions	<p>Wood preparation: The parts should be cleanly drilled, mate well and be free from dust and grease. Excessive fit tolerances will lead to longer setting times and weaker bonds.</p> <p>Wood discolouration: Rakoll Express™ DKN 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.</p>
Cleaning Instructions	Clean the spray nozzles with water before the glue dries.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	Store in tightly closed original containers between +5°C and +35°C. Not reusable after warming.
Disposal Advice	Please refer to the MSDS for disposal instructions.
Safety Advice	Please refer to the MSDS for safety advice.

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