



### Rakoll<sup>®</sup> express TO 50

**Type of Adhesive** High-quality PVA glue.

**Product Benefits**

- fast setting glue for fast processing
- glue pressed out, can be removed easily with a lathe tool
- after setting, the joints are firm, but still sufficiently flexible to permit cores to be transported

**Typical Applications** Gluing of block and strip cores, surface gluing of HPL and CPL in short cycle presses, carcass and assembly gluing when short pressing times are required, particularly when the parts are pre-heated, edge banding in stationary presses with veneers, plastic laminates and solid wood strips, gluing joints in boards and block gluing of softwoods and chipboard, manual doweled gluing of box furniture.

**Suitable substrates** Wood and wood based materials.

#### Typical Properties

Property	Value
Base	polyvinyl acetate dispersion (PVA)
Colour	white
pH	approx. 7
White point	approx. 3°C
Viscosity at 20°C	Brookfield HB; spindle 3; 20 rpm approx. 14.000 mPa.s
Shelf life	6 months



### Application Instructions

The open time and the setting time are strongly influenced by the working conditions, e.g. temperature, 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:
  - Guide value for gluing cores: 35 – 45 g/m<sup>2</sup>
  - Surface gluing in short cycle presses: 80 – 100 g/m<sup>2</sup>
  - Carcase and assembly gluing: 160 – 180 g/m<sup>2</sup>
  - Open time at 150 g/m<sup>2</sup>: 3 – 4 min
  - Press pressure: 0,2 – 0,5 N/mm<sup>2</sup>

### Pressing times:

Pressing times depend on temperature conditions and throughput speed, which in turn depends on the strip width.

Surface gluing of HPL sheets - minimum pressing times:

Amount applied g/m <sup>2</sup>	Guide value for pressing time (min)			Using pressing method
	20°C	40°C	60°C	
80	-	1,0	0,7	only short cycle press
100	from 6,3	1,5	1,1	short cycle and multi stage press
120	from 8,4	2,5	-	multi stage press
140	from 12,0	4,0	-	stacking press

*Carcase and assembly gluing:*

- *at normal temperature: from 3 min*
- *pre-heated on one side: from 45 sec*

### Wood preparation:

All parts should fit well and be dust and grease free. In the case of cores, generally saw-rough core strips are used, but these should be as straight as possible and cut exactly to size.

**Glue spread:**

Apply this product evenly to one side using a glue spreading machine, a serrated spatula or any other suitable device.

**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:**

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.

**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. 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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