



### Rakoll® GXL 3

**Type of Adhesive**

PVAc adhesive, meets the requirements of class D 3 as a one-component product and mixed with Rakoll® GXL-3-Härter meets the requirements for D 4 standard DIN EN 204.

**Product Benefits**

- good water resistance
- quick setting time
- if heat is applied, very short pressing times can be achieved
- bonded joints with good high-temperature resistance
- classification according to EN 204: load group D4 as a two-component system (ift certified)
- classification according to EN 204: load group D3 as one-component system (ift certified)
- Adhesive strength according to DIN EN 14257 (WATT 91) as a one-component system (ift certified)

**Typical Applications**

This product can be used for a variety of applications including:

- surface gluing of decor-finish film
- veneering
- high-frequency bonding
- surface bonding of HPL/CPL in short cycle presses
- carcass and assembly gluing
- bonding joints in boards and block gluing of softwoods and chipboard as well as hardwoods

**Suitable substrates**

Wood and wood based material.

**Typical Properties**

Property	Value		
	Rakoll® GXL 3	Rakoll® GXL 3 Härter	Mixture
Basis	PVA Dispersion	Polyisocyanate	-
Colour	white	colourless	white
pH	approx. 3	-	approx. 3
White point	approx. 7°C	-	approx. 7°C
Viscosity (Brookfield HB, Sp3, 20rpm, +20°C)	approx. 13 000 mPa.s	-	approx. 11 500 mPa.s
Shelf life	9 months		



### Application Instructions

Apply the adhesive thinly and evenly to one side or, if a high degree of water resistance is required, to both sides, using a spreading machine, glue roller, serrated trowel, glue brush and another suitable device.

Good results will be achieved if the following conditions are observed:

- Room and material temperature: 18 – 20°C
- Moisture content of wood: 8 – 10%
- Relative humidity: 40 – 60%

Amounts of adhesive to apply:

- For surface bondings: 60 – 140 g/m<sup>2</sup>
- For assembly gluings: 160 – 180 g/m<sup>2</sup>

Open time at 150 g/m<sup>2</sup>: 8 – 10 minutes

Press pressure, depending on type of bonding: 0,1 – 0,8 N/mm<sup>2</sup>

Minimum pressing times:

Surface gluing of decor-finish film in short cycle presses: 5 – 10 seconds  
High-frequency bonding with longitudinal heating: from 15 seconds

Gluing:

- Surface gluing of HPL/CPL in short cycle presses at +70°C: from 45 sec.
- Assembly gluing: 8 – 15 minutes
- Boards and block gluing: 10 – 15 minutes

Mixing ratio:

- 100 parts by weight of Rakoll® GXL 3 with 5 parts by weight of Rakoll® GXL 3 Härter

Mix the adhesive and the hardener together thoroughly.

Pot life: approx. 12 hours at normal temperature. Temperatures above 20°C reduce the pot life.

### Open time / Setting time:

Strongly depend on working conditions such as temperature, humidity, absorbency of the materials being worked and amounts applied.

### Wood preparation:

All parts should mate well and be dust and grease free. Over tolerances will lead to longer setting times and weaker bonds. The joints should be cut shortly before bonding.



### Application Instructions

#### Presses:

Lay the items to be bonded together within the workable time and press them for as long a time as is needed to achieve the required initial firmness upon release. The pressure should be high enough to ensure contact of the parts over the entire area of the joint. Depending on the material and the type of bond being used, the mechanical firmness required for further processing of the parts is achieved within the shortest possible space of time. The higher levels of water resistance form more slowly and should be tested not earlier than 7 days after bonding.

#### Wood discoloration:

Because of the varied nature of wood components, e. g., depending on the area of growth and the type of pre-treatment, unpredictable discoloration may in some cases appear on different types of wood, such as beech, cherry and others. In addition, it is possible that iron together with the tannin in wood can cause discoloration, especially in the case of oak. We recommend you test this for yourself.

#### Advice:

Properties of storage tanks, pipelines and spreading devices made from steel, galvanised steel aluminium or other non-ferrous metals cannot be recommended due to the slightly acidic nature of the dispersion, as there is a danger of corrosion. For this reason, we recommend the use of storage tanks, pipes and spreading devices made from stainless steel or plastic (hard PVC, polyethylene, polyester resin).

### Cleaning Instructions

Clean machines and utensils with water before the adhesive dries.

### Typical Packaging

Please contact your local Sales Office for available packaging options.

### Storage Conditions

Store the adhesive away from frost in tightly closed original containers at above +5°C. Storage temperatures in excess of +25°C considerably reduces the minimal storage time. This product can thicken a little after prolonged storage. The adhesive should then be thoroughly mixed and is then ready for use again.

### Disposal Advice

Please refer to the MSDS for disposal instructions.

### Safety Advice

Please refer to the MSDS for safety advice.

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