

# Rakoll® GXL 3 ZF

<b>General Properties</b>	Technology/Base	Polyvinyl acetate (PVAc), water borne, dispersion
	Cross-linking Agent	Rakoll® GXL 3 Härter
	Type of Product	Adhesive
	Curing	Physical Chemical
	Colour	White
	Product Benefits	Classification according to EN 204: load group D3 as one-component system Classification according to EN 204: load group D4 as a two-component system Tensile strength as per DIN EN 14257 (WATT 91) Low emission/low VOC EMICODE EC 1 <sup>PLUS</sup> certified High water resistance Shorter pressing times at higher press temperature No discolouration of the glue line due to the influence of process heat Can be used also on high frequency presses Fast setting

## Typical Technical Data

### General

<b>Physical Properties</b>		
pH	4.5	
Chalk Point	5 °C	
<b>Processing Guidelines and Parameters</b>		
Storage Temperature	5 °C to 25 °C	
Processing Temperature	18 °C to 25.0 °C	
Viscosity	13,000 mPa·s	Brookfield HB, 20 °C, 20 rpm, Sp. 3
<b>Recommended Conditions for Good Results</b>		
Moisture Content of Wood	8% to 10%	
Relative Humidity	40% to 60%	

### With cross-linking agent

<b>Processing Guidelines and Parameters</b>		
Mixing Ratio (Part A : Part B) by Weight	100 : 5	
Potlife	12 h	

### Product Properties

<b>Applications</b>	Fields of Application	Woodworking
	Typical Applications	Veneering Veneer jointing Carcase, assembly and finger jointing Bonding joints in boards and block gluing of softwoods and chipboard as well as hardwoods High-frequency bonding Surface gluing of decor-finish film
<b>Processing</b>	Suitable Substrates	Wood based materials Wood
	Consistency	Liquid
	Application Method	By roller Spreading machine With notched trowel
	Product is free of	Aldehydes
<b>Hints</b>	Stir Well Before Use	<b>Rakoll® GXL 3 ZF must be stirred well before use</b>
	Undercooled adhesive	Please contact the Application Engineering.



## Additional Information

### Typical Packaging

Request information about packaging options available to our sales department.

### Storage

Rakoll® GXL 3 ZF should be used within the shelf life specified on the packaging. The storage stability applies to material stored under appropriate conditions only (original unopened containers, recommended storage temperature). This Product should be stored unopened in a cool, dry place out of direct sunlight. Refer to the Technical Data section of this document for optimum storage temperatures.

### Safety

For safe handling information on this product, consult the Safety Data Sheet (SDS).

### Preparation

Over tolerances in the wood will lead to longer setting times and weaker bonds. The wood should be joined shortly before bonding.

### Processing

**Applying the adhesive** Apply Rakoll® GXL 3 ZF thinly and evenly to one side or, if a high degree of water resistance is required, to both sides.

**Pressing** Lay the parts together within the open time and maintain the pressing pressure until the required initial strength is achieved. The pressure should be high

enough to achieve joint closure in the entire joint area (depending on the substrates used). Woods containing resin require longer pressing times.

**Laminating of wooden window profiles** In accordance with the Quality Guidelines of i.f.t. Rosenheim, Laminated Profiles for Wooden Windows, the wood moisture content must be (  $13 \pm 2$  ) %. The room temperature and the wood temperature must be at least 15 °C.

### Compatibility

Due to the different composition of wood constituents, unpredictable discoloration may occur in individual cases with different types of wood. In addition, iron in combination with the tannic acid of the wood can cause color changes, especially in oak. We recommend carrying out your own tests.

### Compatibility

To avoid the risk of corrosion, we recommend using storage tanks, pipes and spreading equipment made of stainless steel or plastic (rigid PVC, polyethylene, polyester resin).

### Cleaning

Clean machines and utensils with water before the adhesive dries.

### Disposal

Please refer to the Safety Data Sheet (SDS) for disposal instructions.

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