

Rakoll®duplit AL Neu

with Rakoll®duplit Härter Farblos

Type of Product Two-component PVAc glue.

Product Characteristics

- durability class D4 according to DIN EN 204 (ift certified)
- complies with EN 14257 (WATT 91 – ift certified)
- heavy metal free hardener

Typical Applications

- gluing of window scantlings
- gluing HPL to chipboard
- bonding joints in boards and block gluing of softwoods and chipboard
- parquet bonding
- bonding of one or more plies
- finger jointing

Suitable substrates Wood and wood-based materials.

Typical Properties

Property	Value		
	Rakoll®duplit AL Neu	Rakoll®duplit Härter Farblos	Glue mix
Base	polyvinyl acetate (PVAc)	inorganic metal salt solution	-
Colour	white	colourless	white
Viscosity (Brookfield HB, Sp3, 20rpm)	approx. 8 500 mPa.s	water-like	approx. 4 500 mPa.s
Shelf life	12 months		Pot life: 3 – 5 days

Application Instructions

This adhesive should be used as a two-component adhesive. The setting process is a physical process in the first phase, i. e. setting takes place through migration of the water into both sides of the joint. The higher degree of water resistance is obtained after a few days. As for all normal PVAc adhesives, the workable time and the temperature, humidity, absorbency of and tension in the materials to be bonded and the amount of adhesive applied.

Thoroughly mix this adhesive with the hardener. The mixing time should be at least 2 minutes. Mixing is best performed using motor-driven agitating vanes or cages.

Mixing ration	
Rakoll®duplit AL Neu	Rakoll®duplit Härter Farblos
100 parts by weight	5 parts by weight

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

- Room-, material- and adhesive temperature: 18°C – 20°C
- Moisture content of wood: 8 – 10%
- In accordance with the guide-lines of the ift, Rosenheim, for laminated wooden window profiles: 11 – 15%
- Relative humidity: 40 – 60%

Application quantity for:

- Surface bonding: 80 – 140 g/m²
- Constructional gluing: 150 – 180 g/m²
- Gluing of window scantlings: 180 – 200 g/m²

Open time: approx. 8 minutes

Press pressure for stress-free work pieces: 0,1 – 0.5 N/mm²

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Application Instructions

Minimum pressing time (depending on tension):

- Constructional gluing: 10 – 15 minutes
- Lamination bonding: 20 – 40 minutes
- Window scantlings:
 - Spruce: from 20 minutes
 - Larch: from 40 minutes

Prolonged processing times will result in a higher water resistance, so that the minimum pressing time should be exceeded if possible.

Wood preparation:

All parts should fit well and be dust and grease free.

Excessive fit tolerances will lead to longer setting times and weaker bonds. When bonding laminates of window profiles, the wooden parts should be planed shortly before bonding to avoid distortion of the laminating sheet. During the lamination bonding process of window scantlings, the wood parts should be planed just before the bonding. That will prevent the warp of the lamination.

Pressing:

Lay the items to be bonded together within the workable time and after a brief closed period press them for as long as is needed to achieve adequate initial strength.

As the reaction between this adhesive and the hardener which produces good water resistance is of longer duration, tests for water resistance should be carried out only after an intermediate storage of 7 days.

Wood Discolouration:

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.

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Application Instructions	Hazard warning: Rakoll®duplit Härter Farblos is strongly acidic. Take appropriate precautions when handling.
Cleaning Instructions	Clean application tools with water before the adhesive dries. Please, contact your local Sales Office for further information.
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. Clean and dry conditions above +5°C and below +35°C. This product gets damaged when stored below +5°C, this means that it's 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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