

RAKOLL® LP 8022

As a one-component product conforms with D 3, and with D 4 when mixed with hardener

Properties

RAKOLL®-LP 8022 is a PVAc adhesive with good water resistance which 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.

RAKOLL®-LP 8022 sets very quickly. If heat is applied, very short pressing times can be achieved. The bonded joints are characterised by a good high-temperature resistance.

Machining the joints causes very little wear on the tools.

Durability Class in accordance to DIN EN 204

single component: D 3

mixed with RAKOLL® GXL 3 Härter: D 4
GXL-3-Hardener

Applications

Examples of climatic conditions and areas of application:

D 3: Interior with frequent short-term exposure to running or condensed water and/or heavy exposure to high humidity.
Exterior not exposed to weather.

D4: Interior with frequent long-term exposure to running or condensed water.
Exterior exposed to weather but with adequate protection by a surface coating.

- Surface gluing of decor-finish film

- High-frequency bonding
- Stationary edge-banding with veneers, plastic laminates and solid wood strips
- Surface bonding of HPL/CPL in short cycle presses
- Carcase and assembly gluing
- Bonding joints in boards and block gluing of softwoods and chipboard as well as hardwoods

Instructions for use

The open time and setting time depend strongly on working conditions such as temperature, humidity, absorbency of the materials being worked and amounts applied.

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

Room,- material and adhesive temperature 18 ... 20 °C

Moisture content of wood 8 ... 10 %

Relative humidity 60 ... 70 %

Amounts of adhesive to apply:
for surface bondings 80 ... 140 g/m²
for assembly gluings 160 ... 180 g/m²

Open time at 150 g/m² 8 ... 12 min

Press pressure, depending on type of bonding 0,1 ... 0,8 N/mm²

Minimum pressing times:
Surface gluing of decor-finish film in short cycle presses 5 ... 10 sec
High-frequency bonding with longitudinal heating from 15 sec

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

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 ± 2 %. The room temperature and the wood temperature must be at least +15 °C.

Mixing ratio

100 parts by weight RAKOLL®-LP 8022 with
5 parts by weight RAKOLL®-GXL 3 Härter

Mix the adhesive and the hardener together thoroughly.

Pot life

Approx. 24 hours at normal temperature.
Temperatures above 20 °C reduce the pot life.

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.

Applying the adhesive

Apply RAKOLL®-LP 8022 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 or another suitable device.

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.

Cleaning

Clean machines and utensils with water before the adhesive dries.

Chemical-technical data

RAKOLL® LP 8022 and RAKOLL® GXL 3 Härter

	RAKOLL® LP 8022	RAKOLL® GXL 3 Härter	Mixture
Basis:	PVA dispersion	Polyiso-cyanate	
Colour	white	colour-less	white
Viscosity	approx. 13.500 mPa.s	—	approx. 11.500 mPa.s
(Brookfield HB, Spindle 3, 20 rpm, +20 °C on the day of production)			
White point	approx. +7 °C	—	approx. +7 °C
pH value	approx. 3	—	approx.3

General Hints

Properties of storage tanks, pipelines and spreading devices made from steel, galvanised steel aluminium or other non-ferrous metals cannot be re-commended on account of 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).

Labelling

RAKOLL®-LP 8022 is not subject to the marking regulations in accordance with the Dangerous Goods Act in its present version.

RAKOLL®-Vernetzer D4 is not subject to the marking regulations in accordance with the Dangerous Goods Act in its present version, but it does contain a small amount of isocyanate.

Safety advice

Please observe the information given on our EC-safety data sheets! (Please request).

Storage

Store RAKOLL®-LP 8022 away from frost in tightly closed original containers. Storage temperatures in excess of 25 °C considerably reduces the minimal storage time.

Shelf life is at least 9 months.

Technical stage of development: December 2006

The data in former leaflets which differ from this version are no longer valid.



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OBSERVATIONS

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