

# Express 25 D

## Universal hardwood glue for seating furniture and other joints subjected to high loads

### Properties

RAKOLL®-Express 25 D is a high-quality PVA glue which reaches a very good final strength on setting. Joints glued using RAKOLL®-Express 25 D are characterised by good resistance to dynamic loading, while at the same time displaying good static load-bearing capabilities.

### Classification according to DIN EN 204 - D 2

### Application

- Manual doweled gluing of upholstered furniture frames
- Gluing of joints in boards and block gluing of hardwood
- Gluing of joints in boards and block gluing of softwood and chipboard
- Carcass and assembly gluing when average pressing times are required

### Instructions for use

The open time and the setting time are strongly influenced by the working conditions, e.g. 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 glue temperature	18 ... 20 °C
Moisture content of the wood	8 ... 10 %
Relative humidity	60 ... 70 %

Glue spread:

for assembly gluing	140 ... 200 g/m <sup>2</sup>
for surface gluing	80 ... 140 g/m <sup>2</sup>

Open time at 150 g/m<sup>2</sup> 6 ... 9 min

Press pressure for tension-free work-pieces

0,1 ... 0,5 N/mm<sup>2</sup>

Minimum pressing times:

Doweled and dovetail joints in hardwood	10 min
depending on fit of joints	
Block gluing of hardwoods	12 ... 15 min
Joints in softwoods and chipboard	8 ... 13 min

### Wood preparation

In the case of hardwoods, the moisture content of the wood must be strictly within the specified range of 8 ... 10 %.

Cutting out the joints, joining and gluing should preferably be carried out on the same day.

### Glue spread

RAKOLL®-Express 25 D is normally applied evenly to one side using a brush or other suitable spreading appliance.

### 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

RAKOLL®-Express 25 D does not cause discolouration of the wood. 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.

## Labelling

RAKOLL®-Express 25 D is not subject to marking regulations pursuant to the Dangerous Goods Act in its present version.

## Storage

Store RAKOLL®-Express 25 D in tightly closed original containers protected from frost. The shelf life is at least 12 months.

## Chemical-technical data

RAKOLL®-Express 25 D

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Basis: Polyvinyl acetate dispersion (PVA)

Colour: yellowish,  
dries to light brown translucent

Viscosity: approx. 16.000 mPa.s  
(Brookfield HB, spindle 3, 20 rpm, +20 °C measured at on the day of manufacture)

White point: approx. +3 °C

pH value: approx. 7

### Technical stage of development: March 2006

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



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