



Rakoll® D3

General Properties

Technology/Base	Polyvinyl acetate (PVAc), water borne, dispersion
Cross-linking Agent	Rakoll® GXL 3 Härter
Type of Product	Adhesive
Curing	Physical Chemical
Color	White
Fields of Application	Woodworking
Typical Applications	Veneering Surface gluing of decor-finish film and HPL/CPL in short cycle presses and cold laminating machines Bonding joints in boards and block gluing of softwoods and chipboard as well as hardwoods
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 High water resistance High heat resistance Fast setting speed Shorter pressing times at higher press temperature

Typical Technical Data

General

Physical Properties		
pH	3	Internal HBF Standard
Processing Guidelines and Parameters		
Processing Temperature	60 °F to 77 °F	
Viscosity	11,500 mPa·s	Brookfield, 70 °F, 20 rpm, Sp. 5
Recommended Conditions for Good Results		
Ambient Temperature	60 °F to 70 °F	
Moisture Content of Wood	8 % to 10 %	
Relative Humidity	40 % to 60 %	
Curing		
Curing Time	24 h	70 °F

With cross-linking agent

Processing Guidelines and Parameters		
Mixing Ratio (Part A : Part B) by weight	100 : 5	



Product Properties

Processing

Suitable Substrates	Wood Wood based materials
Consistency	Liquid
Application Method	Roll Roller Spreading machine Brush With notched trowel

Hints

Preparation	Rakoll® D3 must be stirred well before use
Undercooled adhesive	Please contact the Application Engineering.



Additional Information

Typical Packaging

Request information about packaging options available to our sales department.

Storage

Rakoll® D3 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

Please read our Safety Data Sheet (SDS) of each product before use.

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® D3 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 ± 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. 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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