Technical Data Sheet

WOODSTIKK UF VENEER & LAMINATE ADHESIVE FAST CURE WINTER GRADE

WOODSTIKK® UF VENEERING ADHESIVE SYSTEMS CAN BE USED FOR ALL VENEERING AND LAMINATING WORK. WHETHER IT IS COLD PRESS, HOT PRESS OR FORM PRESSING, THE LIQUID/POWDER COMBINATION IS THE MOST VERSATILE RESIN SYSTEM FOR ANY WORKSHOP. WOODSTIKK® UF VENEERING ADHESIVE SYSTEMS ARE USED FOR SMALL ASSEMBLY, VENEERING AND LAMINATING APPLICATIONS IN THE TIMBER PROCESSING AND FURNITURE INDUSTRY.

THIS SYSTEM INCORPORATES A LIQUID RESIN AND A POWDER HARDENER WHICH ARE MIXED TOGETHER AND THEN APPLIED TO THE SUBSTRATES TO BE BONDED. THE FAST CURING WINTER GRADE IS IDEAL FOR COLDER ENVIRONMENTS OR FOR WHERE A FASTER CURE TIME IS NEEDED.

This system is suitable for use in a variety of assembly applications, and in conjunction with low-voltage or radio-frequency heating, for lipping and edge-banding. This system mees the requirements of BS 1203 (type MR), BS 1204: Part 2 (Type MR) and BS EN 12765 (Class C3). bearing structures (EN 301 and EN 302).

BENEFITS

- Water resistant
- Can be hot or cold cured
- High bond strength
- Cures to give an opaque glueline
- Meets requirements of EN301 and EN302 Type I
- Cures with radio frequency equipment
- Ideal for use in vacuum presses

TECHNICAL DATA

	Resin (Part A)	Hardener (Part B)
Appearance:	Semi-opaque liquid	Off-white powder
Viscosity @ 25ºC (mPas):	1000 - 2200	3000
Specific gravity @ 25ºC:	1.28 - 1.30	
pH:	7.0 - 8.5	
Solids content:	63 +/- 2	

AVAILABLE SIZES	COVERAGE
3.45kg kit	25sqm
5.75kg kit	40sqm
11.5kg kit	80sqm
28.75kg kit	200sqm

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PREPARATION AND APPLICATION

Ensure that the surfaces to be bonded are smooth, clean and free from dust or other deposits. Wood, plywood, laminated plastics should be of uniform thickness. To avoid wetting difficulties that may arise through case hardening it is good practice to sand plywood before gluing even though it may appear to have been sanded at manufacture.

The resin (part A) should be mixed by weight with the hardener (part B) to the mix ratios shown below, and then applied to the substrate to be bonded, preferably by a manual or mechanical roller. It is generally adequate to apply the mixture to one of the surfaces only. Using a mechanical spreader, spreads of 100 – 150 grams per square metre are obtainable.

If the mixture needs to be thickened to reduce the risk of bleed through of the veneer, then Woodstikk UF Filler Extender can be added. See separate technical data sheet for further details.

The following table gives an indication of cure times based on ambient and hot press temperatures. The basic setting times stated refer to glue line temperatures only and allowance must be made for the heat to travel from the press platen. Heat penetration time will vary according to the density of the wood, moisture content and distance to the farthest glue line. The pressing times apply when bonding absorbent materials such as low and medium density wood. The pressing time must be considerably extended when bonding less absorbent, or high-density materials. Table 4 is a guide to the additional time required for low and medium density timbers.

HANDLING AND STORAGE

The mixing and spreading equipment must be cleaned at the end of the working day. If the glue thickens in the application equipment, the equipment must be immediately emptied and cleaned, otherwise there is a risk that the glue will cure. Cured glue is insoluble and must be scraped off. Warm water (40 – 60°C) is recommended for cleaning.

The resin (part A) and hardener (part B) should be stored firmly sealed in their original containers in a cool dry place (ideally 5°C – 20°C). Shelf life under these conditions is at least 4 months for the resin (Part A) and hardener (Part B), but will be significantly longer the cooler the temperature is.

TABLE 1: HARDENER ADDITION AND POT LIFE

Hardener Addition: Parts by weight per 100		Pot-life (in hours): Temperature of mixture			
		15ºC	20ºC	25ºC	30ºC
Hardener	15	1-1hr30	45mins-1hr	30-45mins	15-30mins

TABLE 2: COLD AND WARM PRESSING TIMES

Glue line temperature:	15ºC	20ºC	25ºC	30ºC	40ºC
Pressing time:	1hr30	1hr	45mins	30mins	10mins

TABLE 3: HOT PRESSING TIMES

Glue line temperature:	55ºC	60ºC	65ºC	70ºC	75ºC	80ºC
Pressing time:	4mins30	3mins	2mins	1min30	1min15	1min

TABLE 4: HEAT PENETRATION

Heat penetration time in minutes per mm distance from the glue line. Distance to glue line:	Platen Temperature (ºC)				
	80ºC	90ºC	100ºC	110ºC	120ºC
0.4 - 5mm	1.2	1.0	0.9	0.8	0.8
5 - 10mm	1.7	1.4	1.2	1.1	1.1
More than 10mm	2.0	1.7	1.4	1.3	1.2

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Woodstikk UF is from the Prefere adhesive range.

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