Technical Data Sheet

WOOD STIKK

UF VENEER AND LAMINATE ADHESIVE

ALL DAY POT LIFE

HOT PRESS

WOODSTIKK® UF VENEERING ADHESIVE SYSTEMS CAN BE USED FOR ALL VENEERING AND LAMINATING WORK.

THE HOT PRESS BONDING GRADE PROVIDES A SUITABLE ADHESIVE FOR VENEERING, DOOR CONSTRUCTION AND OTHER WOOD ASSEMBLY APPLICATIONS.

The Hot Press Bonding grade incorporates a liquid resin (part A) and a filled powder hardener (part B) which are mixed together and then applied to the substrates to be bonded. The Hot Press Bonding grade is ideal for use with a heated platen press and gives the operator an all-day pot life once the resin and hardener are mixed. The hardener incorporates a filler which reduces the potential of adhesive bleed-through through the veneer.

This system mees the requirements of BS 1203 (type MR) and BS EN 12765 (Class C3)

BENEFITS

- Water resistant
- Filled hardener - reduces bleed through
- Ideal for hot pressing bonding
- All day pot life

TECHNICAL DATA		
	Resin (Part A)	**Hardener (Part B)**
Appearance:	Semi-opaque liquid	Off-white powder
Viscosity @ 25ºC (mPas):	1000 - 2200	
Specific gravity @ 25ºC:	1.28 - 1.30	
pH:	7.0 - 8.5	
Solids content:	66 +/- 2	

AVAILABLE SIZES	COVERAGE
4.5kg kit	30sqm
7.5kg kit	50sqm
15kg	100sqm
37.5kg	250sqm

UREKA
THE NAME THAT STICKS

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 80 – 150 grams per square metre are obtainable.

The following table gives an indication of cure times based on hot press temperatures. This system is not suitable for bonding at cold or ambient 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 3 is a guide to the additional time required for low and medium density timbers.

HANDLING AND STORAGE

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 3 months for the resin (Part A) and considerably longer for the hardener (Part B).

TABLE 1: HARDENER ADDITION AND POT LIFE

Hardener Addition: Parts by wieght per 100		Pot-life (in hours): Temperature of mixture				
		15ºC	20ºC	25ºC	30ºC	35ºC
Hardener	50	22-24hrs	12-14hrs	5-6hrs	2-3hrs	1hr30

TABLE 2: COLD AND WARM PRESSING TIMES

Glue line temperature:	80ºC	85ºC	90ºC	95ºC	100ºC	105ºC	110ºC	115ºC	120ºC
Pressing time:	140secs	120secs	100secs	75secs	55secs	45secs	40secs	30secs	25secs

TABLE 3: HEAT PENETRATION.
Heat penetration time in minutes per mm distance from the glue line.

Distance to glue line	Platen Temperature (0C)				
	80ºC	90ºC	100ºC	110ºC	210ºC
0.4 - 5mm	1.4	1.2	1.0	0.9	0.8
5 - 10mm	1.7	1.4	1.2	1.1	1.0
More than 10mm	2.0	1.7	1.4	1.3	1.2

Woodstikk UF is from the Prefere adhesive range.

Revision date: September 2023