

## Technical Data Sheet



# 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 meets 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 @ 25°C (mPas):	1000 - 2200	
Specific gravity @ 25°C:	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



## 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 weight per 100		Pot-life (in hours): Temperature of mixture				
		15°C	20°C	25°C	30°C	35°C
Hardener	50	22-24hrs	12-14hrs	5-6hrs	2-3hrs	1hr30

**TABLE 2: COLD AND WARM PRESSING TIMES**

Glue line temperature:	80°C	85°C	90°C	95°C	100°C	105°C	110°C	115°C	120°C
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 (°C)				
	80°C	90°C	100°C	110°C	210°C
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.

**DISCLAIMER:** Due to the variation in materials likely to be handled by prospective users of this product, together with differences in production techniques and ultimate performance required, it is important that this product is thoroughly evaluated under production and end use conditions before being commercially adopted. Such an evaluation should incorporate an ageing test and this test should be repeated if the substrates on which this product is used are changed in any way or are purchased from a different source. During the evaluation and testing of the product, it is the purchasers/end user's responsibility to carry out appropriate actions for the protection of the environment, the health and safety of its employees and purchasers of its products. No employee of Ureka Global Ltd has any authority to waive or change the foregoing provisions. The above recommendations are made in good faith for the guidance of users and are without liability. Any queries should be made in writing to the head office of Ureka Global Ltd.

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