

Technical Data Sheet



UF VENEER AND LAMINATE ADHESIVE SUMMER GRADE SLOW CURE



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 Slow Curing Summer grade is ideal for warmer environments or for where a slower 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 meets the requirements of BS 1203 (type MR), BS 1204: Part 2 (Type MR) and BS EN 12765 (Class C3)

BENEFITS

- Water resistant
- Can be hot or cold cured
- 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 @ 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

3.45kg kit	25sqm
5.75kg kit	40sqm
11.5kg kit	80sqm
28.75kg kit	200sqm

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 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				
		10°C	15°C	20°C	25°C	30°C
Hardener	15	7-8hrs	4-5hrs	3-4hrs	1-2hrs	45mins-1hr15

TABLE 2: COLD AND WARM PRESSING TIMES

Glue line temperature:	10°C	15°C	20°C	25°C	30°C	40°C
Pressing time:	8hrs	5hrs	3hrs	2hrs	1hr15	40mins

TABLE 3: HOT PRESSING TIMES

Glue line temperature:	55°C	60°C	65°C	70°C	75°C	80°C
Pressing time:	5mins	3mins30	3mins	2mins	1min45-2mins	1min

TABLE 4: 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 the 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 forgoing 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.

Revision date: February 2021

