Technical Data Sheet

CASCAPHEN

TWO PART RESIN GLUE - STRUCTURAL

This professional, two part glue has been specially developed for waterproof exterior use. Developed for the marine industry this is the only completely waterproof adhesive that will withstand continual immersion in water. It can be used externally where extreme weathering will take place.

Bonding of difficult timber i.e. teak and Iroko • Fire resistant to class 0 • structural timber • laminated roof members • timber in constant contact with water • timber in contact with the ground • structural timber • laminated roof members • arches for bridge work • concrete formers • marine craft timber i.e. construction • bonding of preservative treated timber • bonds resinous timber • withstands extreme weathering • continuous immersion in water.

BENEFITS

- Class 0 fire certificaiton
- 100% waterproof
- Very strong bond
- Suitable for structural applications
- Suitable for cold press bonding

AVAILABLE SIZES

670g kit

TECHNICAL DATA

Brookfield Viscosity (25°C)	2000 – 4000 mPas	2000 – 9000 mPas
pH (25°C)	8.0 – 9.5	2.0 – 5.0
Specific gravity	1.3	1.23
Mixing ratio (by weight)	100 parts	15 parts
Colour	Dark brown	Brown
Coverage	125g per square metre	

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PREPARATION AND APPLICATION

General Application for jointing. To obtain the very best results the moisture content should be in the 12-14% range. Timber bought as kiln dried and stored under cover will present no problem. Perhaps as important as the glue is the preparation the joining surfaces, especially for Oak and oily timbers, Teak, Iroko etc.

Timber direct from machining has a slightly glazed surface and the surface fibres are compressed by rollers etc. It is essential that the surfaces to be joined should be ridded of this unwanted smoothness. Use a scouring plane (blade with fine points), hacksaw blade, or very coarse sandpaper. Plywood must be, treated in the same manner. Dust with a bristle brush, oily timbers should be degreased with a pure solvent cleaner. The surface should be abraded as close to bonding as practically possible.

As important as preparation, is working in the correct temperature and that means, within reason, as warm as possible, 20°C is ideal. At higher temperatures the glue becomes much less viscous, easier to apply and penetrates the timber instead of laying on the surface, a better glue line results. For the best results both surfaces of the joint should be glued. Use good quality brushes.

Surfaces once glued should not be exposed to the air for any length of time. Do not over cramp; as it's possible to starve a joint this way A minimum of twenty minutes closed assembly time should be allowed before the application of pressure.

Bring the surfaces firmly into contact. This will enable the glue to penetrate the surface fibres of the timber and avoid excessive squeeze out. The removal of surplus glue is best carried out when the glue has reached a jelly like stage, just before it goes off.

HANDLING AND STORAGE

Handle in accordance with good industrial hygiene and safety practice. Wash thoroughly after handling.

Use in well ventilated areas and avoid breathing of dust. Use an approved respirator if air is contaminated above acceptable levels.

When blended with water, the concentration of free formaldehyde of the reconstituted resin will increase to a value of 1 to 2 percent (w/w). The reconstituted product must therefore be considered to be Harmful for Supply, with the following risk phrases 'Possible risk of irreversible effect and May cause sensitisation by skin contact.

Storage life - Adhesive - 12 months at 20°C in well closed packaging. Hardener - 12 months at 20°C in well closed packaging. Test for curing after use by date. If the packaging is left open when not in use the glue is susceptible to skin formation on the surface. To avoid this the packaging should be closed when not in use.

Most suitable storage temperature is 15°C. The glue and the sensitivity hardener are not harmed by freezing. If frozen, the adhesive and the hardener should be slowly thawed, after which the products are ready to use. Do not expose the glue or the hardener to temperatures above +30°C.

POT LIFE

Temperature (°C)	15°C	20°C	30°C
Time (hrs)	11	8	3

PRESSING TIMES

HOT PRESS TIME

Temperature (°C)	70°C	80°C	90°C
0.6mm substrate thickness	6 hr	2 hr 30 min	1 hr
3.6mm substrate thickness	14 hr	5 hr 30 min	4 hr
6.0mm substrate thickness	27 hr	7 hr 30 min	5 hr 30 min

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