Technical Data Sheet

WOOD STIKK ONE SHOT

WOODSTIKK® ONE SHOT IS A SINGLE COMPONENT PRE-CATALYSED UREA-FORMALDEHYDE POWDER RESIN, WHICH, WHEN MIXED WITH WATER, PROVIDES A GAP FILLING WATER RESISTANT ADHESIVE UNAFFECTED BY MOULDS AND FUNGI.

Woodstikk® One Shot is a single component pre-catalysed urea-formaldehyde powder resin, which, when mixed with water, provides a gap filling water resistant adhesive unaffected by moulds and fungi.

BENEFITS

- Good water resistance
- Quick curing
- Very strong bond
- Can be mixed up in small batches

TECHNICAL DATA	
Appearance:	Off-white powder
Viscosity (2:1 solution) @ 25°C	1800 - 3800 mPas

AVAILABLE SIZES		
Pail	3kg	30sqm coverage
Pail	6kg	60sqm coverage
Sack	25kg	250sqm coverage

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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. Some dense hardwoods may require sanding before bonding. For best results the moisture contents of the surfaces to be bonded should be in the range of 7 – 13%, but when pressing at temperatures above 105°C, moisture content should not exceed 10%. Moisture content variation between adjacent components should not be > 3%.

Woodstikk® One Shot should be mixed 2 parts by weight with 1 part by weight of water. It is not recommended that Woodstikk® One Shot is mixed by volume.

Use a dry container, preferably non-metallic, and add the water to the powder gradually, stirring to ensure the powder is evenly dispersed. Continue to stir until the solution is free from lumps. The mixed adhesive is then ready to use. Addition of too much water will seriously reduce the rate of setting, particularly at lower temperatures.

Woodstikk® One Shot should be applied evenly to one substrate using a brush, hand roller or mechanical roller. Adhesive coverage between 100 and 400g per square metre are suitable depending on the surfaces to be bonded. When bonding different timbers, such as teak and high-density hardwoods, the adhesive should be applied to both surfaces of the joint. It should be noted that adhesive spread has considerable influence on both assembly and setting times.

Lay the substrates to be bonded together within the workable time and press them for as long a time as is needed to achieve the required handling strength. The pressure should be high enough to ensure contact of the parts over the entire area of the joint. Clamping pressure on joints should be sufficient to ensure good contact between mating surfaces and should be maintained during the indicated clamping time.

Table 2 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.

HANDLING AND STORAGE

Clean machines, equipment and tools with water before the adhesive dries.

Woodstikk® One Shot should be stored in the original containers in a cool, dry place, at a temperature range of between 5°C and 30°C. The adhesive should be protected against humidity and direct sun light. Moisture ingress will damage the integrity of the unmixed adhesive. In these conditions it has a storage life of at least 12 months.

TABLE 1

Temperature of mixture:	10ºC	15ºC	20ºC	25ºC	30ºC
Pot-life:	2hrs30	1hr45	45mins	30mins	15mins

TABLE 2

Glue line temperature:	10ºC	15ºC	20ºC	25ºC	30ºC	35ºC
Minimum clamping time:	8hrs	4hrs	1hr30	1hr	30mins	15mins
Glue line temperature:	50ºC	60ºC	70ºC	80ºC	90ºC	100ºC
Minimum clamping time:	6mins	3mins30	1min45	1min	45secs	30secs

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