

## GENERAL DESCRIPTION

474 is an urea formaldehyde based resin with special flours added. It is used in the wood industry for hot-setting bonding. It is characterized by high tenacity and good pot life.

## APPLICATIONS

474 resin is used on plywood, cored panels, paper and veneers.

## CHARACTERISTICS

FORM	white or walnut coloured powder	
SPECIFIC GRAVITY	approx. 0.5	g/cm <sup>3</sup>
VISCOSITY Brookfield at 20°C s3/5rpm (solution 2:1 in water)	2000 - 7000	mPa*s

## DIRECTIONS

The product must be diluted in water at approx. 65% of solid content as in the following formulation:

RESIN 474	10	kg
COLD WATER (15-20°C)	5	kg

## POT LIVES AT:

15°C	7	hours
20°C	4	hours
30°C	2	hours

## HARDENING TIMES AT:

60°C	8	min.
80°C	100	seconds
100°C	50	seconds

When applying the product, hardening time must be increased by one minute for each millimetre of wood thickness.

## COATING AND PRESSING

Apply using an applicator with rollers, spatula or brush. Glue quantity must be spread according to the type of the materials involved (generally between 100 and 200 g/m<sup>2</sup>).

The press operating pressure depends on the materials used, ranging from 0,8 to 2 kg /cm<sup>2</sup>.

## WARNING

Check frequently that the glue still feels damp and sticky when pressing it.

Woods like birch, rosewood, teak, fir-wood and briars in general may sometimes require a special formulation.

The gluing mixture should preferably be prepared in non-metallic vessels, or in stainless steel recipient.

## PACKAGING

Paper-bags of 25 kg.

## STORAGE

Shelf life: 6 months at 20°C in original closed packages.

Storage above 30°C and below 10°C may deteriorate the product. This product is hygroscopic and must be preserved from contact with humidity. Contact with humidity may lead to formation of blocks and the glue may become unusable.

The above data are the results of our experiences and they have to be considered as suggestions, due to the variety of the working conditions.

Date: October'12 version n° 04

- THIS TECHNICAL SHEET HAS NOT TO BE CONSIDERED AS PRODUCT SPECIFICATION -