

GENERAL DESCRIPTION

483 is a new generation urea-formaldehyde based resin with low formaldehyde content, characterized by high yield value, good solubility and no oozing .

APPLICATIONS

483 is used in the wood industry for cold and hot-setting and high frequency bonding. It is used on plywood, cored panels, chipboard and furniture.

CHARACTERISTICS

FORM	white or walnut coloured powder
SPECIFIC GRAVITY	approx. 0.5 g/cm ³
VISCOSITY Brookfield at 20°C g3/5rpm (solution 2:1 in water)	2000 - 8000 mPa*s
pH a 20°C	5 - 6

DIRECTIONS

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

RESIN 483,	10	kg
COLD WATER (15-20°C)	5	kg

POT LIVES AT:

20°C	6	hours
30°C	3,5	hours

HARDENING TIMES AT:

60°C	10	min.
80°C	120	seconds
100°C	60	seconds

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

COATING AND PRESSING

By glue applicator with rollers, spatula or brush. Glue quantity must be spread according to the type of materials involved (generally between 100 and 200 g/m²).

The press operating pressure depends on the materials used, ranging from 0,8 to 2 kg /cm².

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.

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