



RESIN 404

GENERALITIES

Resin 404 is one of a new generation of urea-formaldehyde resins with low formaldehyde content. It has a high yield value, good solubility, high specific adhesion and low oozing.

It is suggested for productions required to get the E1 class formaldehyde emission.

APPLICATIONS

It is used in the wood industry for hot-setting and high frequency bonding.

404 resin is used for veneering, to produce plywood, cored panels, chipboard and furniture required to have high tenacity and resistance.

CHARACTERISTICS

FORM	white or brown powder
SPECIFIC GRAVITY	0,5 g/cm ³
VISCOSITY Brookfield at 20°C g3/5rpm (solution 2:1 in water)	4200 - 8000 mPa·s
pH at 20°C	5.0 - 6.5

DIRECTIONS

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

RESIN 404	10	kg
COLD WATER (15-20°C)	5	kg
POT LIVES AT:	20°C	8 hours
	30°C	4 hours
HARDENING TIMES AT:	60°C	15 minutes
	80°C	180 seconds
	100°C	65 seconds

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

COATING AND PRESSING

By means of a glue applicator with rollers, spatula or brush. The glue quantity must be spread according to the type of materials (generally between 100 and 200 g/m²). **To get class E1, the glue quantity may not exceed 100 g/m².**

The operating pressure of the press 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.

When bonding cherry wood do not add PVA glue.

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 A PRODUCT SPECIFICATION -