

GENERAL DESCRIPTION

421 is a new generation urea-formaldehyde resin with low formaldehyde content. Characterized by high yield value, good solubility and no oozing, it is used in the wood industry for cold and hot-setting and high frequency bonding. It is suitable for obtaining E1 class products.

APPLICATIONS

421 resin is used to produce plywood, cored panels, chipboard and furniture required to have low formaldehyde emission. If a reduction in setting time is needed, PVA glue NUNIVIL 1000 can be added (max. 20%).

CHARACTERISTICS

FORM	white or walnut coloured powder
SPECIFIC GRAVITY	0,5 g/cm ³
VISCOSITY Brookfield at 20°C g3/5rpm (solution 2:1 in water)	2500 - 6000 mPa*s
pH at 20°C	5 - 6

DIRECTIONS

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

RESIN 421	10	10	kg
COLD WATER (15-20°C)	5	5	kg
NUNIVIL 1000		2	kg

POT LIVES AT:

15°C	8	3	hours
20°C	5	2	hours
30°C	3	1	hours

HARDENING TIMES AT:

60°C	13	4	minutes
80°C	140	60	seconds
100°C	60	35	seconds

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

COATING AND PRESSING

Apply using a glue applicator with rollers, spatula or brush. Glue quantity must be spread according to the type of the materials (generally between 100 and 200 g/m²). **In order 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 PRODUCT SPECIFICATION -