

Product Information

1341

General

1341 is self-hardening Urea-Formaldehyde powder with very low free formaldehyde emission, medium-fast reactivity and high filling properties.

The use of 1341 allows to get veneers gluing on E1 panels, without changing the emission class and plywoods that fulfil the specification according to EN 1084 Class A (formaldehyde emission $\leq 3,5\text{mg/m}^2\cdot\text{h}$; EN717-2 "gas analysis")

Use

1341 are suitable for gluing of veneers, doors, plywoods, blockboards and furniture parts with press heated with traditional system or HF.

Glue line quality

1341 allow to obtain glue line that will fulfil the specification according to DIN 68705 IF, BS 1455 INT and EN 314-2 Class1.

Characteristics

Chemical nature: Formulated product based on urea-formaldehyde condensate

Aspect: Powder

Colour: 1341 - White

Bulk density: approx. 600 kg/m^3

Free formaldehyde: $< 0,1\%$ (method of analysis EN 1243)

Storage life 6 months at $20\text{ }^\circ\text{C}$.

It is recommended to store the product under dry and cool conditions in well sealed bags

Directions for use

Dispersion preparation: 1341, as supplied, contain fillers and hardeners, so they are used in water dispersion with the following ratio:

1341 - 1342	100 parts by weight
Water	50 ÷ 80 parts by weight

For the preparation of the glue mixture it is advisable to disperse the powder glue in about 2/3 of the total quantity of water; when an homogeneous mixture without lumps is obtained add the remaining quantity of water until is achieved the requested viscosity. The glue mixtures so obtained have the following characteristics:

Pot life at 20 °C	4 hours
Pot life at 30 °C	1,5 hours

Basic setting time at:	70 °C	4 minutes
	80 °C	2 minutes
	90 °C	60 seconds
	100 °C	40 seconds

Glue spread:

The glue spread is depending on: wood species, uniformity of the thickness of the veneers and conditions of the surfaces. Rough and porous surfaces need viscous glue mixtures and abundant spreading; smooth and close surfaces need more fluid glue mixtures and lower spreading.

The glue spread (single face) is indicatively:

Veneers	80 ÷ 120 g/ m ²
Plywoods and doors	160 ÷ 200 g/ m ²
Solid wood	200 ÷ 250 g/ m ²

Wood moisture:

The wood moisture content shall be 8 ÷ 12 %.
Wood too dry or too wet gives unsatisfactory gluing.

Pressing times:

The pressing time is the result of the addition of basic setting time and the heat penetration time that depends mainly on press temperature, wood density, thickness of the veneers and their moisture content. The heat penetration time in minutes/mm is calculated until the reaching of innermost glue line. Indicatively the heat penetration time is:

Press temperature °C	70	90	110	120
Heat penetration time				

The information is based on laboratory tests and a long practical experience. It is introductory and intended to help the user find the most suitable method of working. Since the user's production conditions are beyond our control, we cannot be held responsible for the results of the work which is affected by local circumstances. In each particular case testing and continuous control are recommended.