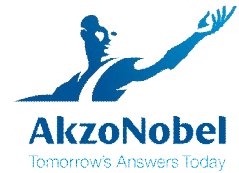


Product Information



1360

General

1360 are self-hardening Urea-Formaldehyde powder with fast reactivity.

Use

1360 are suitable for gluing of veneers, doors, plywoods, blockboards and furniture parts with press heated with traditional system or HF.

Glue line quality

1360 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: 1360 - White

Bulk density: approx. 500 kg/m³

Storage life 6 months at 20 °C.

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

Casco Adhesives

Stockholm, Sweden +46 8 743 40 00
Paderno Dugnano, Italy +39029947941
www.cascoadhesives.com

Directions for use

Dispersion preparation: 1360, as supplied, contain fillers and hardeners, so they are used in water dispersion with the following ratio:

1360	100 parts by weight
Water	50 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	2,5 hours
Pot life at 30 °C	45 minutes
Basic setting time at:	
20 °C	4,5 hours
40 °C	50 minutes
60 °C	6 minutes
80 °C	2 minutes
90 °C	70 seconds
100 °C	40 seconds
110 °C	35 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:

Casco Adhesives

Stockholm, Sweden +46 8 743 40 00
Paderno Dugnano, Italy +39029947941
www.cascoadhesives.com

Press temperature °C	70	90	110	120
Heat penetration time minutes / mm	2	1	0,5	0,25

Pressure: The required pressure depends mainly on the wood species, wood density, article type and used apparatus, indicatively is 0,1 ÷ 0,8 MPa.

Advice: Alkaline or acid substances as soda, gypsum, residue of casein glue, soap, etc. if come into contact with the glue or the materials to glue can give unsatisfactory gluing.
The preparation of glue mixtures could be done in container of stainless steel, glass, plastic, ceramic, wood; iron, copper and brass are not suitable.
Possible glue mixture bleeding can be eliminated with reduction of the glue spread or by adding filler (e.g. wheat flour) and sometimes adding 10 ÷20% of PVAc adhesive carbonate free.

Cleaning: The glue contains small amounts of free formaldehyde that may cause skin irritation, so is necessary to use gloves and safety glasses.
Soap and water is used for the removal of glue from the skin.
Glue spreader and other material can be washed with warm water before the glue has hardened.

Health and safety

The information regarding health and safety is found in the Materials Safety Data Sheet. Make sure always to study this information carefully.

ONLY FOR PROFESSIONAL USE

Last revision: February 2004

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.

Casco Adhesives

Stockholm, Sweden +46 8 743 40 00
Paderno Dugnano, Italy +39029947941
www.cascoadhesives.com