

## Technical Data Sheet

# Cascaphen Two Part Resin Wood Glue

This professional two part glue has been specially developed for waterproof exterior use. Developed for the marine industry this is the only completely waterproof adhesive that will withstand continual immersion in water. It can be used externally where extreme weathering will take place.

Bonding of difficult timber i.e. teak and Iroko · Fire resistant to class O · structural timber · laminated roof members · timber in constant contact with water · timber in contact with the ground · structural timber · laminated roof members · arches for bridge work · concrete formers · marine craft timber i.e. construction · bonding of preservative treated timber · bonds resinous timber · withstands extreme weathering · continuous immersion in water.



## Benefits

Class 0 fire certification	Suitable for cold press bonding
100% waterproof	Suitable for structural applications
Very strong bond	

## Technical Data

	Part A	Part B
Brookfield Viscosity	2000-4000 mPas	2000-9000 mPas
pH (25°C)	8.0-9.5	2.0-5.0
Specific gravity	1.3	1.23
Mixing ratio (by weight)	100 parts	15 parts
Colour	Dark brown	Brown
Coverage	125g per square metre	

## Available Sizes

670g kit

## Preparation and Application

General Application for jointing. To obtain the very best results the moisture content should be in the 12-14% range. Timber bought as kiln dried and stored under cover will present no problem. Perhaps as important as the glue is the preparation the joining surfaces, especially for Oak and oily timbers, Teak, Iroko etc.

Timber direct from machining has a slightly glazed surface and the surface fibres are compressed by rollers etc. It is essential that the surfaces to be joined should be riddled of this unwanted smoothness. Use a scouring plane (blade with fine points), hacksaw blade, or very coarse sandpaper. Plywood must be treated in the same manner. Dust with a bristle brush, oily timbers should be degreased with a pure solvent cleaner. The surface should be abraded as close to bonding as practically possible.

As important as preparation, is working in the correct temperature and that means, within reason, as warm as possible, 20°C is ideal. At higher temperatures, the glue becomes much less viscous, easier to apply and penetrates the timber instead of laying on the surface, resulting in a stronger glue line. For the best results both surfaces of the joint should be glued. Apply with brush, spreader or roller.

Surfaces once glued should not be exposed to the air for any length of time. Do not over clamp; as it's possible to starve a joint this way. A minimum of twenty minutes closed assembly time should be allowed before the application of pressure.

Bring the surfaces firmly into contact. This will enable the glue to penetrate the surface fibres of the timber and avoid excessive squeeze out. The removal of surplus glue is best carried out when the glue has reached a jelly like stage, just before it goes off.

## Technical Data

### Pot Life

Temperature	70°C	80°C	90°C
Time (Hours)	11	8	3

### Hot Press Time

Temperature	70°C	80°C	90°C
0.6mm substrate thickness	6hr	2hr 30min	1hr
3.6mm substrate thickness	14hr	5hr 30min	4hr
6.0mm substrate thickness	27hr	7hr 30 min	5hr 30 min

## Handling and Storage

Handle in accordance with good industrial hygiene and safety practice. Wash thoroughly after handling.

Use in well ventilated areas and avoid breathing of dust. Use an approved respirator if air is contaminated above acceptable levels.

When blended with water, the concentration of free formaldehyde of the reconstituted resin will increase to a value of 1 to 2 percent (w/w). The reconstituted product must therefore be considered to be Harmful for Supply, with the following risk phrases 'Possible risk of irreversible effect and May cause sensitisation by skin contact.

Storage life - Adhesive - 12 months at 20°C in well closed packaging. Hardener - 12 months at 20°C in well closed packaging. Test for curing after use by date. If the packaging is left open when not in use the glue is susceptible to skin formation on the surface. To avoid this the packaging should be closed when not in use.

Most suitable storage temperature is 15°C. The glue and the sensitivity hardener are not harmed by freezing. If frozen, the adhesive and the hardener should be slowly thawed, after which the products are ready to use. Do not expose the glue or the hardener to temperatures above +30°C.



DISCLAIMER: Due to the variation in materials likely to be handled by prospective users of this product, together with differences in production techniques and ultimate performance required, it is important that this product is thoroughly evaluated under production and end use conditions before being commercially adopted. Such an evaluation should incorporate an ageing test and this test should be repeated if the substrates on which the this product is used are changed in any way or are purchased from a different source. During the evaluation and testing of the product, it is the purchasers/end user's responsibility to carry out appropriate actions for the protection of the environment, the health and safety of its employees and purchasers of its products. No employee of Ureka Global Ltd has any authority to waive or change the forgoing provisions. The above recommendations are made in good faith for the guidance of users and are without liability. Any queries should be made in writing to the head office of Ureka Global Ltd.

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