

Technical Data Sheet

Cascamite Accelerator

Cascamite Accelerator is used with Cascamite powdered resin glue and enables the rapid gluing of close fitting joints particularly where specialised heating equipment is not available. It is also suitable for use as a separate application when using a liquid UF Resin.

When used with Cascamite weatherproof glue, this accelerator cures the mixed glue to a handling strength in approximately 25 minutes. Ideal for use when you have urgent jobs or small assembly joints which need further processing in a quick frame time.



Benefits

Interior or exterior use	Stronger than the wood itself when used with °Cascamite
Easy to apply	
Mould resistant	
Fast Curing	

Available Sizes

250ml	1ltr
-------	------

Preparation and Application

Ensure that the surfaces to be bonded are smooth, clean and free from dust or other deposits. Plywood veneers, lippings etc. should be of uniform thickness. To avoid wetting difficulties that may arise through case-hardening, it is good practice to sand plywood before gluing even though it may appear to have been sanded at manufacture.

For best results with °Cascamite Accelerator the moisture content of the surfaces to be bonded should be within the range 7-13%, but when pressing at temperatures above 105°C moisture content should not exceed 10%. Variation between the adjacent surfaces should not be greater than 3% moisture content.

Except where it is part of the prescribed gluing process, contact between accelerator and resin must be carefully avoided. For example, if the applicator used to spread the hardener is dipped into the resin container, the resin immediately starts to thicken and set and becomes useless.

Spread the °Cascamite wood glue, by means of a conventional glue-spreader, wooden rod or clean brush* on one of the surfaces to be joined. Apply the °Cascamite Accelerator to the other surface, using a clean brush*, felt pad, sponge or similar iron-free applicator. The surface should be just moistened – free standing excess accelerator should be avoided.

°Cascamite Accelerator may be allowed to dry out completely and provided that the surfaces are kept free from contamination, the hardener-coated components may be stored for some time before assembly. *See note on avoidance of iron contamination

Using a mechanical spreader, adhesive coverage of 100-200 grams per square metre are obtainable, whereas with hand application, spreads of 150-300 grams per square meter are more usual. °Cascamite Accelerator coverage is in the order of 50-75 grams per square meter. After the surfaces have been brought together, full pressure should be applied as quickly as possible, although the accelerator will tolerate some closed assembly within the limits given in table 1

Cold pressing times are given in table 2.

Technical Data

Closed Assembly Time

Temperature	10°C	15°C	20°C	25°C	30°C
Time (Mins)	25	12	6	4	3

Cold Press Time

Temperature	10°C	15°C	20°C	25°C
Time	2h	55m	25m	14m

Hot Press Time

Temperature	30°C	35°C	40°C
Time (Mins)	9	7	5

Handling and Storage

Care should be taken to avoid contact of resin or accelerator with nails etc., or with ferrous fittings (for example, on brushes or containers), since this can lead to staining on timber. Staining is caused by the formation – under acid conditions – of iron-tannin compounds, especially on woods with high tannin contents, such as oak or ash).

Accidental discoloration due for example to squeeze-out the adhesive against a G-clamp may be removed by wiping the affected area with an absorbent pad moistened with 10% citric acid solution. Since citric acid may itself cause the colour changes in certain types of wood, it is advisable first to test its effect on an off-cut.

*Cascamite Wood Glue & *Cascamite Accelerator, should be stored firmly sealed in their original containers in a cool (5°C – 15°C), dry place. Shelf life for *Cascamite Wood Glue is at least 6 months under these conditions.

*Cascamite Accelerator has a usable life of at least 2 years.



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.

Revision date: April 2024

© 2023 Ureka Global Ltd. All rights reserved.
UREKA Global Ltd. Unit 5, Decoypool Road, Newport NP19 4RG. Company Number 8499525