



Technical Data Sheet

Resin 404

self-hardening urea-formaldehyde powder glue

GENERALITIES

404 is one of a new generation of urea-formaldehyde resins of low formaldehyde content, having high yield value, good solubility & no oozing. It is used in the wood industry for hot-setting and high frequency bonding. It is suitable to obtain products of E1 class.

APPLICATIONS

404 is used to produce plywood, cored panels, chipboard and furniture required to have low formaldehyde emission. high tenacity and resistance.

If a reduction of setting time is necessary, PVA D3 glue can be added (max 20%)

CHARACTERISTICS

FORM

white

SPECIFIC GRAVITY

0.5

g/cm³

VISCOSITY Brookfield at 20°C g3/5rpm (solution 2:1 in water)

4200 – 8000

mPa*s

pH at 20°C

5 – 6

DIRECTIONS

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

RESIN 404		10	kg
COLD WATER (15 -20 °C)		5	kg
POT LIVES AT:	20°C	8	hours
	30°C	4	hours
HARDENING TIME AT:	60°C	15	minutes
	80°C	180	seconds
	100°C	65	seconds

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

COATING AND PRESSING

By means of a glue applicator with rollers, spatula or brush. The glue quantity must be spread according to the type of materials (generally between 100 and 200 g/m²). **To get class E1 the glue quantity may not exceed 100g/m²**
The operating pressure of the press depends on the materials used, ranging from 0.8 to 2kg/cm²

WARNING

Check frequently that the glue still feels damp and sticky when pressing it.

Wood like birch, rosewood, teak, fir-wood and briars in general may sometime require a specific 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 25kg.

STORAGE

Shelf life: 6 months at 20°C in original closed packages.

Store the product in a cool and dry place; by contact with humidity it may alter and became 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.

Date: January '02 version n° 00

-THIS TECHNICAL SHEET HAS NOT TO BE CONSIDERED AS A PRODUCTION SPECIFICATION.