

Product Information

Furniture & Flooring system 1205 / 2545

- All-round system with long pot life.

2545 is an all-round hardener that can be used in all types of applications. 2545 can either be used as hardener in a two component adhesive system or as a third component in for example floor production when using a separate adhesive system.

The hardener 2545 can be used with all our UF-adhesives and gives a very long pot life with all of them.

2545 is suitable for our Automatic Adhesive Mixers. To extend the pot life, the use of a Glue Chiller is recommended.

Product Specification

	1205	2545										
Product	UF adhesive	Mix in hardener										
Delivery Form	Liquid	Liquid										
Colour	White	Greyish										
Viscosity (at time of production)	1000 – 3000 mPas (Brookfield LVT sp3, 12rpm, 25°C / 77°F)	2000 – 10000 mPas (Brookfield LVT sp 3, 12 rpm, 25°C / 77°F)										
pH (at time of production)	7,5 – 9,0 (25°C / 77°F)	3,5 – 6,0 (25°C / 77°F)										
Storage Life (months)	<table border="1"> <thead> <tr> <th>20°C/68°F</th> <th>25°C/77°F</th> <th>30°C/86°F</th> </tr> </thead> <tbody> <tr> <td>3</td> <td>2</td> <td>1</td> </tr> </tbody> </table>	20°C/68°F	25°C/77°F	30°C/86°F	3	2	1	<table border="1"> <thead> <tr> <th>20°C/68°F</th> <th>30°C/86°F</th> </tr> </thead> <tbody> <tr> <td>6</td> <td>3</td> </tr> </tbody> </table>	20°C/68°F	30°C/86°F	6	3
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Storage Condition	<p>Recommended storage temperature 15°C – 20°C (59°F – 68°F)</p> <p>Only short term exposure to temp above 30°C / 86°F is acceptable.</p> <p>The product can be frozen but it must be thawed, raised to room temperature and homogenized before usage.</p> <p>During storage the glue will mature and the viscosity can increase.</p>	<p>Recommended storage temperature 15°C – 25°C (59°F – 77°F)</p> <p>Only short term exposure to temp above 30°C / 86°F is acceptable.</p> <p>The product can be frozen but it must be thawed, raised to room temperature and homogenized before usage.</p>										
Formaldehyde Info	Free formaldehyde < 0,75%.	Contains formaldehyde catcher										
Density	Appr. 1300 kg/m ³	Appr. 1450 kg/m ³										

Contact Information

Stockholm, Sweden +46 8 743 40 00
High Point, USA +1 336 841 5111
Singapore +65 6762 2088
Medellin, Colombia +57 4 3618888
www.akzonobel.com/adhesives

Version: 05 (2015-10-01)

Reason for changes: Updated product specification

Gluing Operation Information

Applications	Flooring			
	Curved Plywood			
	Solid Wood Lamination			
	Edge glued panels			
	Doors			
	Veneering			
Board on Frame				
Press Type	Cold Press, Hot Press or High Frequency Press			
Glue Line Temperature	Not below 20°C / 68°F			
Press Time		70°C/158°F	90°C/194°F	110°C/230°F
	0,6 mm	5'	2'	45''
	3,6 mm	12'30''	7'30''	5'00''
	6,0 mm	15'	9'	7'30''
Pot Life	15°C/59°F	20°C/68°F	30°C/86°F	
	15h	8h	4h	
Pressure	Not below 0,3 MPa			
Assembly Time (120 g/m ² /12 g/ft ² , 20°C/68°F)	Open: 15 min		Closed: 30 min	
Mixing Ratio (by weight)	100:20 (adhesive:hardener)			
Glue Spread	Flooring: 90 - 175 g/m ² , 9 - 17 g/ft ² Curved Plywood: 120 - 200 g/m ² , 12 - 20 g/ft ² Solid wood lamination: 150 - 250 g/m ² , 15 - 25 g/ft ² Edge glued panels: 120 - 150 g/m ² , 12 - 15 g/ft ² Veneering: 90 - 150 g/m ² , 9 - 15 g/ft ² Foliating: 20 - 70 g/m ² , 2 - 7 g/ft ² Board on frame: 120 - 180 g/m ² , 12 - 18 g/ft ²			
Moisture content of wood	Preferable 5 - 9%.			
Preparation of wood	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.			
Temperature of wood	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.			
Post curing	Needs no after curing time, can be processed directly after pressing.			

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Machinery

Applicator	6231- Ribbon spreader Roller spreaders may be ordered through our technical representative.
Mixer	6201- Mixing system for UF, PRF, MUF 6203- Mixing system for UF, PRF, MUF 6205- Mixing and sometimes applying system for MUF, PRF, UF
Accessories	6213- Metering system for UF, PRF, MUF Glue chiller may be ordered through our technical representative. 6282- Control unit 6284- Level sensors 6289- Day tanks 6201-50 Accessory for glue mixers

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Handling and HSE info

Handling	Always use gloves and goggles when handling the product.
Cleaning	Glue on skin should be washed with soap and water. For the equipment, use lukewarm water with addition of Glue wash 4450 or Washing agent 2704 (for more info see General Info). Cleaning must start before the system cures.
Waste handling - of the products	Glue - Is normally classified as hazardous waste (contains free formaldehyde.) Hardener - Depending on classification hardeners may be considered as hazardous waste, check the SDS (section 13). Mixed glue and hardener – Can normally be treated as non hazardous waste when fully cured. NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
Waste water treatment - of the waste water	Chemical precipitation → drain* Biological treatment → drain* Mechanical precipitation → drain* * municipal sewage with biological treatment NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities. For more info, see General Information.
Health and Safety	For more information, please see respective SDS.

Legal clause

The information is based on laboratory tests and 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.

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