




Furniture & Flooring system 1205/2584

- Fast mix in system with long pot life.

2584 is a medium fast mix-in hardener for urea-formaldehyde adhesives with long pot life. It has low tool wear and can be used in most gluing applications, both in hot presses and in high frequency presses.

2584 is suitable for Casco Adhesives' Automatic Adhesive Mixers. To extend the pot life, the use of Casco Adhesives' Glue Chiller is recommended.

Product Specification

	1205	2584 										
Product	UF adhesive	Mix in hardener										
Delivery Form	Liquid	Liquid										
Colour	White	Cream										
Viscosity (at time of production)	1000 - 3000 mPas (Brookfield LVT, sp.3, 12 rpm, 25°C / 77°F)	2000 - 9000 mPas (Brookfield LVT, sp.3, 12 rpm, 25°C / 77°F)										
pH (at time of production)	7,5 – 9,0 (at 25°C / 77°F)	2,0 – 5,0 (at 25°C / 77°F)										
Storage Life (months)	<table border="1"> <tr> <td>20°C / 68°F</td> <td>25°C / 77°F</td> <td>30°C / 86°F</td> </tr> <tr> <td>2,5</td> <td>1,5</td> <td>1</td> </tr> </table>	20°C / 68°F	25°C / 77°F	30°C / 86°F	2,5	1,5	1	<table border="1"> <tr> <td>20°C / 68°F</td> <td>30°C / 86°F</td> </tr> <tr> <td>4</td> <td>2</td> </tr> </table>	20°C / 68°F	30°C / 86°F	4	2
20°C / 68°F	25°C / 77°F	30°C / 86°F										
2,5	1,5	1										
20°C / 68°F	30°C / 86°F											
4	2											
Storage Condition	<p>Recommended storage temperature 15-20°C / 59-68°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 15-25°C / 59-77°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	App. 1300 Kg/m ³ , 10,9 lbs/gal	App. 1230 Kg/m ³ , 10,3 lbs/gal										



adhesive solutions

Tel: +353 1 8850000

www.ect.ie



This product contains raw material from renewable resources

Version: 02 (2011-09-16)

Reason for change: Changed density

Wood Finishes and Adhesives
Stockholm, Sweden +46 8 743 40 00
High Point, USA +1 336 841 5111
Singapore +65 6762 2088
Medellin, Colombia +57 4 3618888
www.cascoadhesives.com



AkzoNobel
Tomorrow's Answers Today

Gluing Operation Information

Applications	Board on frame Curved Plywood Doors Edge glued panels Flooring Solid wood lamination Veneering			
Press Type	Cold Press High Frequency Hot 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	3' 00"	45"	30"
	3,6 mm	10' 00"	4' 30"	3' 30"
	6,0 mm	13' 00"	9' 00"	5' 00"
Pot Life	15°C / 59°F	20°C / 68°F	30°C / 86°F	
	6h	3h 30'	1h 45'	
Pressure	Min 0,3 MPa			
Assembly Time (120g/m ² /11g/ft ² , 20°C / 68°F)	Open:20'	Closed:1h		
Mixing Ratio (by weight)	100:20, adhesive hardener			
Glue Spread	Board on frame: 120 - 180 g/m ² , 11 - 17 g/ft ² Curved Plywood: 120 - 200 g/m ² , 11 - 19 g/ft ² Doors:120 - 230 g/m ² , 11 - 21 g/ft ² Edge glued panels: 120 - 150 g/m ² , 11 - 14 g/ft ² Flooring: 90 - 175 g/m ² , 8 - 16 g/ft ² Solid wood lamination:150 - 250 g/m ² , 14 - 23 g/ft ² Veneering: 90 - 150 g/m ² , 8 - 14 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.			

Version: 02 (2011-09-16)

Reason for change: Changed density



Tel: +353 1 8850000
www.ect.ie

Wood Finishes and Adhesives
Stockholm, Sweden +46 8 743 40 00
High Point, USA +1 336 841 5111
Singapore +65 6762 2088
Medellin, Colombia +57 4 3618888
www.cascoadhesives.com



AkzoNobel
Tomorrow's Answers Today

Machinery

Applicator

- 6231 Ribbon spreader
- 6235 Roller spreader width <300 mm
- 6236 Roller spreader with integrated mixer <300 mm, patented mixing zone.
- 6237 Roller spreader width >400 mm

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

- 6201-50 Accessory for glue mixers
 - 6213 Metering system for UF, PRF, MUF
 - 6246 Chiller and heat exchanger
 - 6262 Waste water disposal system
 - 6282 Control unit
 - 6284 Tank monitoring system
 - 6289 Day tanks
-



adhesive solutions

Version: 02 (2011-09-16)

Tel: +353 1 8850000
www.ect.ie

Reason for change: Changed density

Wood Finishes and Adhesives
Stockholm, Sweden +46 8 743 40 00
High Point, USA +1 336 841 5111
Singapore +65 6762 2088
Medellin, Colombia +57 4 3618888
www.cascoadhesives.com



AkzoNobel
Tomorrow's Answers Today

Handling and HSE Information

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.
Health and Safety	For more information, please see respective SDS.

For more information regarding the above mentioned data, see respective section below

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.



Version: 02 (2011-09-16)

Tel: +353 1 8850000
www.ect.ie

Reason for change: Changed density

Wood Finishes and Adhesives
Stockholm, Sweden +46 8 743 40 00
High Point, USA +1 336 841 5111
Singapore +65 6762 2088
Medellin, Colombia +57 4 3618888
www.cascoadhesives.com