

**UF resin for thermal curing**

**950.20**

**Application:** For bonding veneer and decor paper, HPL and CPL materials to wood-based substrates, in warm and hot presses, also for solid wood bonding. Frequently used in HF presses for the manufacture of multilayer formed parts.

**Characteristics/ Directions for Use:** Powder glue, low in formaldehyde, with integrated hardener and organic thickeners in exact dosage, hardly any bleeding through.  
 For manufacturing procedures to achieve the classification I according to the standard EN 314, 2.  
 The glue has to be diluted in lukewarm water (18 – 22 °C) with a weight ratio of approx. 2 : 1 (powder : water), e.g.:

**10 kg Jowat® 950.20 UF resin                      and 5 kg water, or**  
**10 l Jowat® 950.20 UF resin                      and approx. 3 l water**

Depending on the viscosity desired, the amount of water added may vary by ± 5 %. Can be used for the standard applicator systems (spatula, hand roller or glue spreader). If desired, the glue can be coloured with water-based stains or with mineral colours free of alkali. In case difficult veneers are to be bonded, the glue may be mixed with 10 to 20 % of for instance with Jowacoll® 113.10 in order to improve the adhesion; also increase the pressure.

Pot life at 20°C [h]:	<7
Min. pressing temperature [°C]:	70
Adhesive application:	one-sided
Quantity applied [g/m²]:	80 – 150 (for HPL, CPL and veneer) 50 – 70 (for decor paper)
Open assembly time [min]:	approx. 13
Moisture content of the wood [%]:	6 – 10
Pressure [N/mm²]:	>0.2

<b>Pressing temperature [°C]:</b>	<b>70</b>	<b>80</b>	<b>100</b>	<b>120</b>
<b>Minimum pressing time [min]:</b>	<b>5</b>	<b>3</b>	<b>1</b>	<b>0.5</b>

Tested according to Jowat test methods on veneer of 0.6 mm thickness. For thicker veneer, the pressing time has to be increased for each mm by 30 – 90 seconds, depending on the pressing temperature.

Appearance:	beige
Powder density [g/l]:	approx. 610
Resin content [%]:	approx. 68

Our Application Technology Department and our Application Specialists will provide technical data to assist you in your choice of an appropriate product for your requirements. Please observe the information in the section “Remarks”.

continued on page 2

**08/20** All data indicated are characteristics represented as average values. Our technical data sheets are periodically revised to represent the latest state of technology. This edition is replacing and superseding all previous ones, and is valid on the date of compilation.  
**Please refer to the last page of this technical data sheet for additional information.**



**Cleaning:** Machines and equipment may be cleaned after use with warm or cold water. After cleaning, at least the ferrous parts should be treated with the release agent Jowat® 900.00 to prevent rusting.

**Storage:** The product should remain stored in closed original containers, dry and cool. For best-before date, please see container label. After the elapse of the best-before date, it is essential that you again verify that the product is fit for your intended application.

**Packaging:** Types of packaging and units upon request.

**Remarks:** **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**

The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding upon Jowat, nor should it be relied upon in lieu of your own required testing. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from the information contained herein nor from the information provided by our free technical advisory service.

## **Jowat Information**

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.