

Product Information

Resin system - Zero

Mix-in system with long pot-life



H201 is a medium fast mix-in hardener with long pot life to be used with our amino adhesive A201.

It has low tool wear and can be used in hot presses and in high frequency presses.

Product Specification

	LignuPro™ Zero Adhesive A201			Hardener H201	
Product	Amino adhesive			Mix in hardener	
Delivery Form	Liquid			Liquid	
Colour	White			Cream	
Viscosity (at time of production)	1500 - 4000 mPas (Brookfield LVT sp4, 6 rpm at 25°C/77°F)			5000 - 15000 mPas (Brookfield LVT sp3, 12 rpm at 25°C/77°F)	
Density	Appr. 1300 kg/m ³			Appr. 1230 kg/m ³	
pH (at time of production)	8.0 – 10 (at 25°C / 77°F)			2.0 – 5.0 (at 25°C / 77°F)	
Storage Life (months)	20°C/68°F	25°C/77°F	30°C/86°F	20°C/68°F	30°C/86°F
	2.5	2.5	0,5	4	2
Storage Condition	Recommended storage temperature 15°C to 20°C / 59°F to 68°F. Only short term exposure to temp above 30°C / 86°F is acceptable. The product cannot be frozen. During storage the glue will mature and the viscosity can increase.			Recommended storage temperature 15°C to 25°C / 59°F to 77°F. Only short term exposure to temperatures above 30°C / 95°F is acceptable. The product can be frozen but it must be thawed, raised to room temperature and homogenized before usage. The product can form a skin on the surface if the container is not properly closed.	

Contact Information

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www.akzonobel.com/cascoadhesives

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Reason for changes: New product

Gluing Operation Information

Applications	Flooring			
Press Type	High Frequency Hot Press			
Glue Line Temperature	Not below 70°C / 122°F			
Press Time		70°C/158°F	90°C/194°F	110°C/230°F
	0,6 mm	6'00"	2'30"	1'00"
	3,6 mm	-	5'00"	4'00"
	6,0 mm	-	-	-
Pot Life	15°C/59°F	20°C/68°F	30°C/86°F	
	-	100:15 4h 100:20 2h 50 min	-	
Pressure	Not below 0,3 MPa			
Assembly Time (120 g/m ² /12 g/ft ² , 20°C/68°F)	Open: <10 min		Closed: <10 min	
Mixing Ratio (by weight)	100:15 – 100:25, adhesive: hardener			
Glue Spread	Flooring: 90 - 175 g/m ² , 9-17 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.			

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

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Accessories	6213- Metering system for UF, PRF, MUF Glue chiller may be ordered through our technical representative. 6282- Control unit 6284- Tank monitoring system 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	Normally not to be considered as hazardous waste. Leave residues to dry before sending it off for disposal. For 2 component systems the hardener may be considered as hazardous waste, check the SDS (section 13). 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 For more info, see General Information below. 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, 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.

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