

**TROPICAL****HARDENER 5530**

Fast hardener for urea formaldehyde resins, suitable for hotpress and for use in radio frequency heated presses. The hardener is specially intended to be use with flooring application. It is recommend to be used with Modifier 0653 or 2725 and Synteko<sup>®</sup> 0621, 1352, 1357 and 0527.

Hardener 5530 is suitable for Casco Wood Adhesives' automatic mixing and dosing equipment.

**TECHNICAL DATA**

|               |   |   |
|---------------|---|---|
| Delivery form | : | Liquid  |
| Colour        | : | Beige   |
| Viscosity     | : | 5000 - 10000 cps, measured with LVT, sp4/60 rpm, Brookfield Viscometer at +25°C |
| pH            | : | 2.8 – 3.5 measured at +25°  |

**OTHER DATA**

Storage life : 4 months at 30°C

**MIXING PROPORTION**

*With 1357*

|                    |                         |
|--------------------|-------------------------|
| <u>Glue Premix</u> |                         |
| Powder Resin       | 100 parts by weight     |
| Water              | 48 parts by weight      |
| Modifier 2725      | 15 - 20 parts by weight |

|             |   |                  |
|-------------|---|------------------|
| Glue premix | : | Hardener premix  |
| 100 pbw     | : | 20 pbw +/- 1 pbw |

When mixing, add the hardener to the glue. At low temperature the mixing must be extended.

**HARDENER 5530****Potlife:****a) Potlife in minutes**

25°C            45 mins

30°C            25 mins

**Amount of glue:**

The amount of glue applied varies with its application. It must always be determined in every specific case. The values noted below can serve as guidelines :

Veneering    100 - 150 g/m<sup>2</sup>Flooring        150 - 250 g/m<sup>2</sup>**Assembly time:**

Maximum 6 mins at 30°C.

The assembly time is shortened by higher temperatures and/or lower air humidity. Sometimes this can be compensated by a larger glue amount.

**Pressing time:**

Pressing time for different objects using this type of hardener must be determined individually. The condition of the press, moisture content of the material, construction and other parameters related to the specific customers will have influences on the performance of the hardener.

**Pressure:**

Depends on the types of material used. Not below 0.3MPa. Well prepared surfaces give the best results.

**Moisture content of the wood:**

The moisture content of the wood material should be 5 - 12%, preferably 6 - 10%.

**Handling:**

The hardener 5530 is acidic. Protective gloves and goggles are therefore recommended when handling the product.

**HARDENER 5530**

**Cleaning:** Glue mix on skin is washed immediately with soap and lukewarm water before curing.

Material are cleaned with lukewarm water before the glue has cured.

To facilitate the cleaning of the glue spreader, we recommend using Glue Wash 4450. At least 1% 4450 (calculated on the rest amount of glue mixture in the spreader) must be added.

Therefore, the spreader is left running for about 5 minutes to ensure good mixing. After that, the spreader can be washed with lukewarm water.

**Health and Safety:** The complete information regarding health and safety is found in the Material Safety Data Sheet. Make sure always to study this information carefully before taking any new product into consideration.

**ONLY FOR PROFESSIONAL USE.**

**BEFORE USING THIS PRODUCT FOR A PURPOSE OTHER THAN PROFESSIONAL, PLEASE CONTACT US.**

The information is based on laboratory tests and a long 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.

|                           |                         |   |
|---------------------------|-------------------------|---|
| <b>Date</b><br>22-02-2005 | <b>Replaces</b><br>0658 | <b>Reason for change:</b><br>New sales code |
| 31-03-2005                | 22-02-2005              | Change of storage life                      |
|                           | <b>Signed by</b>        | <b>Approved by</b><br>Catherine Lee         |