

Technical Information

SPLICER GLUE NH 18/3 POWDER is a one-shot urea/formaldehyde resin adhesive which is used for direct splicing of veneers or splicing of pre-glued veneer bundles on special veneer splicing machines.

Technical Properties of Resin when Manufactured

Appearance	cream coloured powder
Solid Content	min. 98%
Specific Gravity	0,53 (loose weight)
Storage Life	minimum 6 months when stored in cool dry places

Technical Properties of Resin as 65 % Solution in Water

pH (20°C)	5,5 - 6,0
Pot Life (20°C)	approx. 7 hours
Pot Life (30°C)	approx. 2,5 hours
Viscosity (20°C)	2500 - 3000 mPa.s
Colour of the mix/glue line	tane / wood coloured

Preparation of the Glue Mix

Mixing Proportions (depending on viscosity required):

68 - 64 parts of weight	SPLICER GLUE NH 18/3 POWDER
32 - 36 parts of weight	Cold Water

For lump-free mixings add the SPLICER GLUE to only 3/4 of the water and stir until thoroughly mixed. Finally mix with the remaining amount of water.

Changing the mixing proportions leads to changes in viscosity, pot life as well as reactivity of the glue mix. Because of that a mixing ratio that was once found to be appropriate should be kept always the same.

Application

The working temperature should be between 100 - 220 °C. Thicker veneers require higher temperature respectively lower conveying speeds than thinner ones. In order to prevent excessive curing of the glue line it is necessary to adjust the temperature and the conveyance accordingly. In the application of direkt splicing the glue transfer should be adjusted in a way that only a very small amount of glue is visible at the front edge of the spliced veneers. In case the amount of glue applied is too high damages at the front edges of the veneers may occur.

continued

With optimized glue dosage an absolutely clean glue line can be achieved, without any spots or residues on the veneer surface. Also very light coloured veneers like European Maple can be spliced with this type of glue without showing a visible glue-line.

Some veneer woods (such as for example cherry and pear) tend to discoloration under low pH-value conditions. Due to the chemical nature of urea-formaldehyde resins such discoloration may occur by and by in the glue line area of spliced veneers. This appearance might be more or less pronounced, depending on the kind of wood and the accuracy in which the glue transfer to the veneer edges has been effected. Therefore, when gluing veneers from in this respect critical woods it is suggested to care for most precise glue transfer, avoiding that excessive glue is being spread on the veneer surface next to the glue lines.

The veneer moisture should be in the range of 6 - 10 %.

A glue mix - once prepared - can best be left at low temperature (10°C) if it is not being used at the moment. Higher temperatures will lead to shorter pot life.

Storage

SPLICER GLUE NH 18/3 POWDER must be stored in well sealed packings in cool, dry places. Bags or containers - once opened - have to be tightly closed, otherwise the powder glue will harden and become insoluble.

Delivery Form

Strengthened paper bags with plastic liners

20 kg content.