

PUR 1968

- PUR 1968 is a fast curing 1-component polyurethane adhesive for wood.

The 1968 is used for doors, windows, wall beams, furniture, wooden floors and wood/metal or wood/hard plastics bonds.

Well suited for difficult-to-glue materials and for bonding wood with high moisture contents, even at low temperatures.

Product Specification

1968	
Product	Isocyanate MDI based pre-polymer
Delivery Form	Liquid
Colour	Transparent white
Viscosity (at time of production)	Approx. 2000 - 4000 mPas (Brookfield LVT sp. 4, 20 rpm, 20°C)
Density	1160 kg/m ³
Storage life (months)	6
Storage Condition	Sealed packaging at 20°C / 68°F. Should not be exposed to temperatures below 5°C / 41°F or above 30°C / 86°F.
Formaldehyde Info	The adhesive contains no formaldehyde, and will not contribute to emission.

Gluing operation instruction

Moisture contents	The adhesive cures by reacting with water, and practice shows that the moisture contents of the wood should be 8 – 18%. All our tests were made on wood with water content of 10 - 12%.
Assembly time (At 20°C, 65 % RH, 200 g/m ² and 8-10 % moisture content of wood.	Closed: maximum 25 minutes.
Glue amount	100 - 300 g/m ² for single-sided or double-sided application.

Version: 03 (2011-08-02)

Reason for change: Up-date info reg assembly and pressing times

Contact Information

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

Pressing time, general	In general the pressing time will depend on the glue amount, the temperature, the relative humidity (RH) and the moisture content of the wood. The adhesive joint obtains full water resistance after approx. 12 hrs at 20°C / 68°F.
Pressing time (At 20°C, 65 % RH, 200 g/m ² and 8-10 % moisture content of wood)	Minimum 35 minutes
Pressure	0,4 - 0,8 MPa (=4 - 8 kg/cm ²)

Machinery

Applicator	Preferably a ribbon spreader is used.
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Handling and HSE info

Cleaning	Adhesive on skin is removed with water and soap. Tools are cleaned with cleaning liquids for PUR, before the adhesive is cured. Dried adhesive on tools is removed mechanically.
Handling	Good working hygiene should be observed. The adhesive contains isocyanate, which reacts with the moisture of the skin. Always use gloves (nitrile) and goggles when handling the product. Provide good ventilation, especially when using a hot press.
Waste handling – of the products	Normally not to be considered as hazardous waste. Leave residues to cool before sending it off for disposal. 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.

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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