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KAURIT® Glue 122 Powder

Kaurit Glue 122 Powder is used for hot-process surface gluing without the addition of further extender after mixing with water. The bond strengths meet the requirements of

EN 636 – 1 for use class 1
DIN EN 12765 durability group C2
DIN 68705 Part 2 (1981) IF

If processing is carried out correctly and the appropriate base material is used, the veneered items meet the requirements of section 3 of the Annex (to § 1) of the German Ordinance on the Prohibition of Certain Chemicals [*ChemVerbotsV*].

Chemical characterization

Ready-made urea-formaldehyde condensation product in powder form.

Classification and labelling according to EC directives

No classification

Properties

Product specification

Appearance light-beige

Kaurit Glue 122 Powder contains natural products. A slight amount of inhomogeneity and colour variations are normal and do not affect use.

Other properties

Shelf life ¹⁾	at 20 °C	approx. 1 year
	at 30 °C	approx. 6 months

Gel times (guide values) for dissolved Kaurit Glue 122 Powder
(Solution ratio 100 parts by weight powder : 100 parts by weight water)

Temperature in °C	20	30	100
Gel time	14 h	4 h 40 min	37 s

¹⁾ see section on storage

Application

Formulation

The glue is mixed in the ratio
100 parts by weight glue powder : 100 parts by weight water (20 °C) or
3 l glue powder : 2 l water (20 °C). The glue powder is first mixed in two thirds of the water used to dissolve it, so there are no lumps, and then the remaining water is added. After standing for approx. 20 min, the mixture is stirred again and is then ready for use.

Pot-life

at 20 °C 8 hours
at 30 °C 3 hours

The pot-life of the glue formulation on the working application machine is shortened to 2 to 3 hours owing to evaporation of water.

Pressing time

The pressing time required consists of the basic time for pressing plus the heating time per millimetre of wood (through to the innermost glue joint).

Pressing temperature °C	Heating time min/mm	Basic pressing time min
80	2	6
90	1	4
100	1	3
110	1/2	2

A cold substrate material increases the stated pressing times.

Wood moisture content

6 – 12 %

Glue applied

Veneering	on chipboard	120 – 140 g/m ²
	on blockboards	140 – 160 g/m ²
	Crossbanding	180 – 200 g/m ²

Thin, even application of glue prevents glue from bleeding through.

Wet lay-up time

Up to 15 minutes, depending on the indoor climate and quantity of glue applied (the glue should still feel sticky).

Assembly time

Up to 2 minutes, depending on the pressing temperature.

Bonding pressure

The bonding pressure is dependent on the nature of the surface, structure and type of wood.

Gluing of face veneers:	0.4 – 0.6 N/mm ²
Crossbands and face veneers:	0.5 – 0.7 N/mm ²

General information

Woods such as maple, beech, birch, chestnut, teak, pine, oak etc. may cause problems during gluing owing to their high content of certain wood constituents or because of their structure. Better bonding can be achieved by adding up to 20 % PVAc glue to the glue solution. It is advisable to carry out the gluing as soon as possible after sawing, planing or routing. Further information is contained in our Technical Information "Wood gluing: general information".

Storage

Kaurit Glue 122 Powder must be stored in tightly closed containers in cool conditions (if possible, below 20 °C). In particular, the product must be protected against dampness (even against humidity from the air), otherwise it forms lumps and becomes insoluble after some time. The containers must be closed again whenever any product has been removed.

Frost does not harm Kaurit Glue 122 Powder.

If the powder cannot be mixed homogeneously with the required quantity of water, the glue is no longer usable.

Safety

A safety data sheet according to 91/155/EEC is available for Kaurit Glue 122 Powder.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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