



## TECHNICAL DATA SHEET

**PRODUCT:** **Cascamite**

### DESCRIPTION

Powdered urea/formaldehyde resin glue that satisfies the requirements of BSEN 204 durability class D3 and BS EN 302-1 A3 type 11 adhesive if mixed in the proportions specified.

### AREAS OF USE

General Joinery, Cabinet Work, Shop Fitting, Veneering, Boat building, all external Joinery.

### ADVANTAGES

Simple mix with water  
Gap Filling  
High Water Resistance  
Interior or Exterior Use  
Easy to Mix  
Non-Staining  
Mould Resistant  
Stronger Bond Than The Wood Itself

### MIXING

By Weight.

Use 2 parts of Cascamite powder to 1 part of cold water.

By Volume

Use 3.5 parts of Cascamite powder to 1 part of cold water.

NOTE: Mixing by weight is recommended for accurate and consistent glue mixes.

1. Put half the water in a container avoid copper, brass and ferrous metals.
2. Add Cascamite powder to water, stirring rapidly until the powder dissolves.
3. Add the remainder of the water, stirring until smooth. Any small lumps will quickly dissolve.

It is advisable to allow the mixture to stand after mixing to allow entrapped air to escape, bubbles or foam in a glue line can cause a weak bond. Cascamite is now ready for use. The mixture will remain usable for approx. 3 hours at 15°C

At higher temperatures the usable life is reduced and in hot weather it is advisable to mix only sufficient glue for immediate use (standing the mixing vessel in cold water will help prevent shortening of the usable life).

### APPLICATION

Joints should be smooth and well fitted. Apply the glue using a stiff brush to one surface only. Assemble and clamp (pin or screw) the joint whilst glue is wet. Keep the joint under pressure until set (approx. 6 hours at 15°C)  
A damp cloth can be used to remove excess wet adhesive.

NOTE: - At temperatures below 10°C (50°F), a period of up to 2 or 3 days may be required before the glue sets. During cold weather, it is therefore essential that joints under pressure be kept in a warm place.

#### Gel Time Guide:

20° C	30° C	70° C	100° C
1-2 Hr	30 Min	1.5 Min	33 Sec

Coverage should be 100 to 250 grams/sq. metre

NOTE: - If bonded wood is to be turned on a lathe it is recommended that the bonded wood is seasoned for a minimum of one week before turning.

#### **BONDING TIPS**

1 Ideally the moisture content of the substrates should be  $9\% \pm 2\%$  with no more than 3% difference between the two surfaces to be bonded, otherwise stresses are built into the joint, which may result in wood or joint fracture.

If the wood is too damp, the dilution effect will weaken the adhesive performance.

2. Although the workshop conditions may be above 10°C, wood brought in from unheated storage conditions may well be below this temperature and should be allowed to warm to above 10°C before attempting to bond it.

3. Some species of oak can be particularly dense resulting in difficulties in the adhesive penetrating the surface. In such instances, the surface should be removed by sanding to open the pores of the timber and double spreading may prove necessary to ensure both surfaces have sufficiently "wetted" out.

4. Some timbers, and particularly maple can be over prepared by planeing the timber; this leaves a "glassy" surface, which is detrimental to the bonding process.

5. Oily timbers, such as teak, present problems with the "oils" inhibiting a satisfactory bond.

Degreasing is normally required; this can be achieved by wiping the surface with washing up liquid.

Sanding can also remove surface grease, but if the adhesive is not applied shortly afterwards there are likely to be problems of case hardening where the oils have surfaced again.

#### **STORAGE**

Store Cascamite in a cool dry place with the container tightly closed. Heat and moisture will cause the glue powder to become solid or insoluble. Claims for loss due to neglect of this warning cannot be accepted.

#### **CLEANING OF CONTAINERS AND TOOLS**

Wash down equipment with clean cold water before the glue sets. After the glue has set it becomes hard and difficult to remove. In particular, glue should not be allowed to harden on brushes or rollers.

**WARNING:** The fully cured adhesive can only be removed by mechanical means (sawing, sanding etc).

## **HEALTH & SAFETY**

Protect skin from contact with both unmixed powder and mixed adhesive. Mix in well ventilated area. Full data sheet available on request.

Non-hazardous. Ensure good ventilation. Keep out of reach of children. Contact with eyes-wash immediately with warm water. Remove excess from tools and mixing vessels before washing in warm soapy water. Do not empty containers into drains or watercourses.

The information supplied herein is accurate to the best of our knowledge. Since conditions and methods are beyond our control, no warranty is expressed or implied. You are advised to assess the suitability of the product on a test area before application

Further information may be obtained from:

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