CASCAMITE

Technical Data Sheet

Cascamite Powdered Resin Wood Glue

Cascamite is the original single component powdered urea-formaldehyde resin glue, which, when mixed with water, provides a gap filling water resistant adhesive unaffected by moulds and fungi.

Cascamite only requires mixing with water to make it ready for use. It is a weatherproof adhesive which can be used for interior and exterior joinery, cabinetwork and assembly gluing, particularly when small amounts of reactive glue mix are required or when demand is such that the use of a liquid adhesive is uneconomic. Cascamite will allow an adequate working life for most applications using both hot and cold pressing techniques.

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Benefits

Mix with water	Gap filling
High water resistance	Non-staining
Interior or exterior use	Mould resistant
Easy to mix	Stronger than the wood itself

Technical Data

Brookfield Viscosity	200-300mPas at 50% RH
Gel time	2 - 3 hours
Solids content	43 - 49%
Colour	Off-white
Coverage	125g per square metre

Available Sizes

125g	250g	500g	1.5kg	3kg	6kg	25kg

Preparation and Application

Ensure that the surfaces to be bonded are smooth, clean and free from dust or other deposits. Wood, plywood, HPL (high pressure laminates) should be of uniform thickness. Some dense hardwoods may require sanding before bonding. For best results the moisture contents of the surfaces to be bonded should be in the range of 6 – 9%. Moisture content variation between adjacent components should not be > 3%.

Cascamite should be mixed 2 parts by weight with 1 part by weight of water. It is not recommended that Cascamite is mixed by volume. Use a dry container, preferably non-metallic, and add the water to the powder gradually, stirring to ensure the powder is evenly dispersed. Continue to stir until the solution is free from lumps. The mixed adhesive is then ready to use. Addition of too much water will seriously reduce the rate of setting, particularly at lower temperatures.

Cascamite should be applied evenly to one substrate using a brush, hand roller or mechanical roller. Adhesive coverage between 100 and 400g per square metre are suitable depending on the surfaces to be bonded. When bonding difficult timbers, such as teak and high-density hardwoods, the adhesive should be applied to both surfaces of the joint. It should be noted that adhesive spread has considerable influence on both assembly and setting times. Lay the substrates to be bonded together within the workable time and press them for as long a time as is needed to achieve the required handling strength.

The pressure should be high enough to ensure contact of the parts over the entire area of the joint. Clamping pressure on joints should be sufficient to ensure good contact between mating surfaces and should be maintained during the indicated clamping time.

The following table gives an indication of cure times based on ambient and hot press temperatures. The basic setting times stated refer to glue line temperatures only and allowance must be made for the heat to travel from the press platen. Heat penetration time will vary according to the density of the wood, moisture content and distance to the farthest glue line. The pressing times apply when bonding absorbent materials such as low and medium density wood. The pressing time must be considerably extended when bonding less absorbent, or high-density materials.

At temperatures below 10°C, gluing is not recommended. If this cannot be avoided then a period of up to 2 or 3 days may be required before the glue cures. During cold weather, it is essential that joints under pressure be kept in a warm place.

Technical Data

Cold Press Time					
Temperature	10°C	15°C	20°C	25°C	30°C
Time (Hours)	8	5	3	2.25	1

Hot Press Time			
Temperature	70°C	80°C	100°C
Time (Mins)	3	2	40

Handling and Storage

Clean machines, equipment and tools with water before the adhesive dries. Cascamite should be stored in the original containers in a cool, dry place, at a temperature range of between 5°C and 30°C, but the ultimate storage conditions are between 20°C and 25°C. The adhesive should be protected against humidity and direct sun light. Moisture ingress will damage the integrity of the unmixed adhesive. In these conditions it has a storage life of at least 12 months.

DISCLAIMER: Due to the variation in materials likely to be handled by prospective users of this product, together with differences in production techniques and ultimate performance required, it is important that this product is thoroughly evaluated under production and end use conditions before being commercially adopted. Such an evaluation should incorporate an ageing test and this test should be repeated if the substrates on which the this product is used are changed in any way or are purchased from a different source. During the evaluation and testing of the product, it is the purchasers/end user's responsibility to carry out appropriate actions for the protection of the environment, the health and safety of its employees and purchasers of its products. No employee of Ureka Global Ltd has any authority to waive or change the forgoing provisions. The above recommendations are made in good faith for the guidance of users and are without liability. Any queries should be made in writing to the head office of Ureka Global Ltd.

Revision date: April 2024

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