



ONE SHOT

Code 967 3KG
Code 968 6KG
Code 969 25KG

Moisture Resistant Wood Glue

A powdered urea/formaldehyde resin glue for general joinery and cabinet work. The glue line is mould resistant and does not stain most timbers. It is used by simply mixing with water; the correct amount of hardener is already blended into the powder. This adhesive satisfies the requirements of BS EN 204 durability class D3 and BS EN 303-1 A3 type 11 adhesive if mixed in the proportions specified.

Mixing

By weight:

Use 2 parts of **One Shot** powder to 1 part of cold water.

By Volume:

Use 3.5 parts of **One Shot** powder to 1 part of cold water.

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

Put half the water in a container, avoid copper, brass and ferrous metals

Add **One Shot** powder to the water stirring rapidly until the powder dissolves.

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. **One Shot** is now ready for use.

Usable Life of Mix

9 hours at 10 deg C (50 deg F)

3.5 hours at 15 deg C (59 deg F)

1.5 hours at 20 deg C (68 deg F)

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 in thin spread by brush or hand roller. Apply full pressure with clamps or press while the film of glue is still moist (i.e. at higher temperatures, within 20 minutes of spreading the glue: at lower temperatures, within 30 minutes).

Pressing Time

18 hours at 10 deg C (50 deg F)

8 hours at 15 deg C (59 deg F)

3 hours at 20 deg C (68 deg F)

Note: At temperatures below 10 deg C (50 deg 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.

The following table gives a guide based on laminating 0.6mm veneer to particleboard where the heat is transferred from the press to the glue line fairly rapidly. Heat transfer through thicker substrates will vary considerably. For timber a very rough guide is 1 minute per 5mm, but other materials may take considerably longer. This should be tested with temperature strips in a dry construction.

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TECHNICAL DATA



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.

Minutes

50 deg C	4.5
60 deg C	3.5
70 deg C	2.5
80 deg C	2.25
90 deg C	2

Seconds

100 deg C	95
110 deg C	80
120 deg C	70
140 deg C	65
150 deg C	-

Gluing Plastic Laminates

Cascamite Wood Glue may be used to fix plastic laminates e.g. Formica, Waverite, Armabond, Perstorp etc., where resistance to high humidity or dampness is required, e.g. bath surrounds etc. It is essential that pressure be applied as indicated above, either with a press or by clamps.

Bonding tips

Ensure that the surfaces to be bonded are clean and free of dust. Very oily timbers should be wiped with a cloth soaked in detergent or if necessary a degreasing solvent (read the safety instructions carefully). The surfaces of timber should be planed or sanded not more than 48 hours before bonding. Any sign of case hardening i.e. a smooth shiny surface must be removed.

Ideally the moisture content of the substrates should be 10-14% 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.

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

Application of **Cascamite Wood Glue** to both surfaces is recommended for hardwood and particularly dense timbers.

Storage

Store **Cascamite Wood Glue** 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

Wash down equipment with warm soapy 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.