FURNITEX FA-N

LOW-FORMALDEHYDE UREA-BASED GLUE

Properties

Furnitex FA-N is a ready-mixed urea-formaldehyde glue powder useable for veneer and crossband gluing. The powder can easily be mixed with water, resulting in a smooth, ready-to-use glue mixture with a high solid content. Furnitex FA-N can be applied with standard equipment. Non-cured glue can be easily washed off. Subject to using emission class E1 chipboard, Furnitex FA-N allows you to veneer boards according to E1.

Application

Veneer and crossband gluing in hot presses.

Pot Life

at +20 °C over 10 hours
at approx. +30° C approx. 3 hours

Open Time

approx. 15 to 20 min. at 20° C

Pressing Conditions

Pressure: 0.3 to 0.6 N/mm2

Processing Instructions

Pot life, open time and pressing time are widely influenced by the circumstances during processing, such as temperature and moisture, form and height of the workpieces, types of presses, amounts of glue that is applied and characteristics of substrates and veneers.

Good results will be achieved if the following conditions are observed:

Room, material temperature und glue temperature:	18 ... 22 °C
Wood moisture:	8 ... 10 %
Relative air humidity:	60 ... 75 %
Amount of adhesive to apply	Crossband: 150 ... 200 g/m^2 Face veneering: 100 ... 150 g/m2
Mixing ratio	100 parts by weight 60 - 54 parts by weight of water

Glue Mixture

Stir the required amount of Furnitex FA-N with approximately 2/3 of the water needed in a vessel until it forms a smooth thick fluid and use the rest of the water to achieve the right viscosity. Fast-running agitator blades have proven to be suitable. Depending on the desired viscosity, the mixing ratio can be varied.

Applying the Adhesive

The glue should be applied as a homogeneous layer. For a highly absorbent material and little pressure you have to apply a rather large amount of glue. The higher the applied pressure, the less glue is needed. For large-pored veneer, the glue mixture should be highly viscous and applied as a thin layer in order to prevent bleed-through.

Pressing Time

The pressing time is the floor-to-floor time plus the heating time.

Temperature	90 °C	100 °C	110 °C
Floor-to-floor time (min)	3	2	1
Heating time per 1 mm veneer thickness	1	1	0,5

The pressing time has to be adjusted to the work cycle. If the temperature is too high or the working time too long, the glue might harden too soon. If the temperature is too low and the pressing time too short, the initial strength will be insufficient and the water resistance reduced. The pressure should be at least enough to put the joint surfaces in close contact.

Preparation of the Workpiece

Substrates and veneers must show a homogeneous thickness. A divergence in thickness can cause air pockets. The surfaces must be clean and free of dust or other substances with separating effects. If the content of moisture is too high, particularly in the veneer, the glue might be diluted in the joint due to moisture translation caused by pressing heat, and bleed-through might occur.

Important Information

Some wood types such as birch, chestnut, teak, pine, ash, rosewood, koto and others can be difficult to bond due to their structure or a high content of certain wood constituents. An improvement can be achieved by adding 15% of dispersion glue.

Chemical-technical data

Base:	ready-made urea formaldehyde resin
Delivery form:	Powder (25 kg sack)
Bulk weight:	approx. 550 g/litre
pH value, glue mixture:	slightly acidic

Cleaning

Cleanse the glue application machine and other equipment with water directly after use, in any case before the end of the pot life.

Storage

Furnitex FA-N has to be stored in a cool and dry place. Use up opened containers immediately. Heat and moisture reduce the glue's shelf time. If properly stored, Furnitex FA-N has a shelf life of approximately 9 months.

Please Note

The glue must NOT get in touch with brass, copper, soap or alkalis.

Labelling

According to the current Hazardous Substances Ordinance, Furnitex FA-N is not subject to labelling.