

AQUENCE FU 406/1

Known as DORUS FU 406/1

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PRODUCT DESCRIPTION

AQUENCE FU 406/1 provides the following product characteristics:

Technology	Urea Formaldehyde Condensation Resin
Product Type	Veneering Glue
Application	Assembly
Appearance	opaque after drying

Application Areas

- Veneering and crossbanding in the hot press
- Veneering as per E 1 (low formaldehyde content)
- Veneering in membrane press
- Veneering with higher water resistance
- B1 particle boards with HPL

Product Properties

- Long shelf life of the powder
- Short setting time
- Long pot life of ~20 hours
- High bonding agent content
- High water resistance in compliance with C3 as per DIN EN 12765
- Exceedingly low formaldehyde emission, far below the threshold value of the E1 requirement

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use

Open Time

Open time at 20 °C:		
Quantity applied 100 g/m ² , minutes	~10	
Quantity applied 200 g/m ² , minutes	~21	

Pressing temperature and basic pressing time

at 80 - 90 °C, minutes	≥4
at 90 - 95 °C, minutes (from 2.5 min with formula B)	≥2
at 95 - 100 °C, minutes	≥2
at 100 - 110 °C, minutes	≥1.5

Effective pressing time: Basic pressing time plus 1 min per mm veneer thickness

The data shown is based on 8-12 % wood moisture, 20 °C room and material temperature, 65 % relative air humidity and 0.5 N/mm² pressure.

The actual open and setting times will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness of the glue, etc.

The working temperature of the workpiece and glue should be at least + 10°C.

Mixing

The ready-to-use glue mix:

for IF 20 veneering (Formula A):
1 part by volume water
1 part by volume AQUENCE FU 406-1
3/4 part by volume rye flour

for veneering with particularly high water resistance (Formula B):
1 part by volume water
3 parts by volume AQUENCE FU 406-1

Preparation of the glue mix:

Put the water into the mix vessel first. Then add the glue powder until you receive a cream-soup-like liquid free of lumps. You may use the various mechanical types of agitation available.

Potlife

Pot life at ambient temperature
of 20°C, hours: ~20
of 30°C, hours: ~3 to 4

Application

Thinly and evenly by brush, toothed spatula, manual and automated glue spreader.

Processing

The parts are to be joined within the open time and kept under pressure till the initial adhesion is strong enough for further processing.

Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

STORAGE

Storage life up to 9 months without significant loss of adhesion strength. Once opened the inner plastic bag should be tightly closed to keep the powder glue dry.

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information
Transport Regulations
Safety Regulations

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