



Laminated beam MUF system 1247 / 2526

- One of the fastest MUF on the market
- Flexible mix ratio to fit different production needs

Light coloured system for laminated beam and finger joints in load bearing timber structures

Product Specification

	1247			2526		
Product	MUF adhesive			Hardener		
Delivery Form	Liquid			Liquid		
Colour	Opaque white			White		
Viscosity (at time of production)	10000 - 25000 mPas (Brookfield LVT, sp.4, 12 rpm, 25°C / 77°F)			1700 - 2700 mPas (Brookfield LVT, sp.4, 60 rpm, 25°C / 77°F)		
Density	Appr. 1270 kg/m ³			Appr. 1070 kg/m ³		
Ph (at time of production)	9,5 - 10,7 (at 25°C / 77°F)			1,3 - 2,0 (at 25°C / 77°F)		
Dry content	64 - 69%			Not applicable		
Storage Life (months)	15°C/59°F	20°C/68°F	30°C/86°F	15°C/59°F	20°C/68°F	30°C/86°F
	4	4	2	4	4	2,5
Storage Conditions	<p>Recommended storage temperature 15°C to 25°C / 59°F to 77°F.</p> <p>Only short time exposure to temperatures below 10°C / 50°F and above 30°C / 86°F are acceptable.</p> <p>The product can be frozen but it must be thawed, raised to room temperature and homogenized before usage.</p>			<p>Recommended storage temperature; 15°C to 25°C / 59°F to 77°F.</p> <p>Only short time exposure to temperatures below 10°C / 50°F and above 30°C / 86°F are acceptable.</p> <p>Frozen and thawed product cannot be used due to irreversible changes in the product.</p>		
Formaldehyde Info	≤0.8% free formaldehyde			Contains no formaldehyde		

Contact Information

Glue Line Properties	<p>Light coloured glue lines. High water and weather resistance.</p> <p>Fulfils the requirements according to EN 301 (for glue type I and II, service classes 1, 2, 3), EN 391, EN 392 and DIN 68141.</p>
Approvals	<p>1247 with hardener 2526 is approved by Norsk Treteknisk Institutt (NTI), Norway, Materialprüfungsanstalt Universität Stuttgart - Otto-Graf-Institut (MPA), Institut Technologique FCBA, France, SKH/KOMO (DHBC No. 32389), Holland and BUtgb (ATG 06/2662) Belgium for the production of load-bearing timber structures.</p> <p>1247 with hardener 2526 fulfils the requirements according EN 301 for glue type I for service classes 1, 2, 3 in EN 386 as well as the requirements in DIN 68141 for the production of load-bearing timber structures according DIN 1052.</p> <p>The combination can be used for the production of laminated beams according to EN 14080.</p> <p>It is allowed to colour the products with Acomix WZ1. The maximum allowed addition is 1 part by weight to either the adhesive or the hardener or to both as long as the total amount is maximum 1%</p> <p>The intention for use of this adhesive system is with separate application of glue and hardener. However the system is also approved to be used as a mixed system. When glue and hardener are applied separately only Casco Adhesives´ Separate Ribbon Spreader 6230 is allowed for use. When separate application is used the maximum allowed bond-line thickness is 0.3 mm.</p>

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Reason for change: Change position and information of approvals

Contact Information

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Gluing Operation Information

Applications	Laminated Beams, Duo-Trio Beams, I-Beams			
Press Type	Clamp carrier, Cold Press, Hot Press, Continuous Press, and High Frequency press			
Press Temperature	Minimum pressing temperature is 20°C / 68°F			
Pressing time when a thin glue line is guaranteed (approx. 0.1 mm)	Glue joint temperature	Mixing ratio 100:20		
	20°C / 68°F	5h 45'		
	Glue joint temperature	Mixing ratio 100:50		
	20°C / 68°F	2h		
	Glue joint temperature	Mixing ratio 100:100		
	20°C / 68°F	1h 5'		
Pressing time according to EN 302-6 (0.3 mm glue line)	Glue joint temperature	Mixing ratio 100:20		
	20°C / 68°F	5h 45'		
	Glue joint temperature	Mixing ratio 100:50		
	20°C / 68°F	3h 15'		
	Glue joint temperature	Mixing ratio 100:100		
	20°C / 68°F	3h		
Pot Life	Mixing ratio	15°C/59°F	20°C/68°C	30°C/86°C
	100:20	---	40'	---
	100:50	---	15'	---
	100:100	---	8'	---
Pressure	Minimum 0,5 MPa for soft wood. Minimum 1,0 MPa for hard wood. In laminated beam production: Minimum 0,7 MPa for 33 mm lamellas. Minimum 0,9 MPa for 45 mm lamellas.			
Assembly Time (20°C / 68°F)	Gluing conditions	Mixing Ratio	Max Closed	
	250 g/m ² / 51 lbs/1000 ft ²	100:20	30'	
	400 g/m ² / 82 lbs/1000 ft ²	100:20	2h	
	250 g/m ² / 51 lbs/1000 ft ²	100:50	22'	
	400 g/m ² / 82 lbs/1000 ft ²	100:50	1h 20'	
	250 g/m ² / 51 lbs/1000 ft ²	100:100	18'	
	400 g/m ² / 82 lbs/1000 ft ²	100:100	50'	



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	100 : 20 - 100 (adhesive: hardener)
Mixing Ratio (by weight)	The accuracy in the hardener amount shall be ± 3 pbw both when the glue and hardener are used in separate application or as a glue mixture.
Glue Spread	170 - 450 g/m ² , for laminated beams preferably 250 - 450 g/m ²
Moisture content of wood	8 - 15%, for laminated beams preferably 10 - 12%
Preparation of wood	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.
Temperature of wood	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.
Post curing	After the pressing time, the bond line has enough strength for the construction to be handled. Full strength will be reached after a certain time, depending on the pressing time and the pressing temperature.

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Machinery

Applicator

- 6230-12 Separate ribbon spreader for MF and MUF (two component system)
 - 6230-52 Separate ribbon spreader for MF and MUF (three component system)
 - 6231- Ribbon spreader
 - 6235- Roller spreader width <300mm
 - 6237- Roller spreader width >400mm
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Mixer

- 6201- Mixing system for UF, PRF, MUF
 - 6203- Mixing system for UF, PRF, MUF
 - 6205- Mixing and sometimes applying system for MUF, PRF, UF
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Accessories

- 6205- Pulse wheel
 - 6213- Metering system for UF, PRF, MUF
 - 6246- Cooler
 - 6257- lamella temperature sensor
 - 6261- Cleaning equipment
 - 6262- Waste water disposal system
 - 6266- Casco glue log
 - 6282- Control unit
 - 6284- Level sensors
 - 6289- Day tanks
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Contact Information

Handling and HSE info

Handling	Always use gloves and goggles when handling the product.
Cleaning	Glue on skin should be washed with soap and water. For the equipment, use lukewarm water w addition of Glue wash 4450 or Washing agent 2704 (for more info see General Info). Cleaning must start before the system cures.
Waste handling - of the products	<p>Glue - Is normally classified as hazardous waste (contains free formaldehyde.)</p> <p>Hardener - Depending on classification hardeners may be considered as hazardous waste, check the SDS (section 13).</p> <p>Mixed glue and hardener – Can normally be treated as non hazardous waste when fully cured.</p> <p>NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.</p>
Waste water treatment - of the waste water	<p>Chemical precipitation → drain*</p> <p>Biological treatment → drain*</p> <p>Mechanical precipitation → drain*</p> <p>* municipal sewage with biological treatment</p> <p>NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.</p> <p>For more info, see General Information below.</p>
Health and Safety	For more information, please see respective SDS.

For more information regarding the above mentioned data, see respective section below

Legal clause

The information is based on laboratory tests and practical experience. It is introductory and intended to help the user find the most suitable method of working. Since the user's production conditions are beyond our control, we cannot be held responsible for the results of the work which is affected by local circumstances. In each particular case testing and continuous control are recommended.

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