Cascol Polyurethane 1809

Is a one-component solvent free adhesive, which cures under the influence of moisture in the air and from the materials being glued together.

Is mainly formulated to glue wood to wood, wood to metal and different plastic materials.

- Almost transparent glue line
- High heat resistance according to WATT 91
- Balanced open- and pressing time acceptable for both professionals and do it yourself
- Fulfills EN 204 class D4
- Good extended storage stability
- Less foaming

**TECHNICAL DATA**

| Basis: Diphenylmethane-diisocyanate (mixture of isomers) |
| Solvent: None |
| Appearance: Clear yellowish |
| Consistency: Liquid |
| Density: Approx. 1230 kg/m³ |
| Dry solids: 100 % |
| Service temperature: -20°C - +100°C. |
| Flash point: >150°C |

**APPLICATION DATA**

Application temperature: Down to +5°C, normally 15 – 25°C, up to 90°C

Moisture content of wood: 5 - 14%, preferably 7 - 10%

Tools: Toothed towel, brush or roller

Coverage: 100 – 300 g/m² dependent on material combination.

Application time at 20°C/65% RH and depending on temperature and RH:

- Open assembly time is max. 10-15 min.
- Closed assembly time: Min. 5 minutes to max. 25 min.
- Pressure: The adhesive joint has to be fixed with high pressure.
- Pressing time, 20°C:
  - The adhesive cures under the influence of moisture and is therefore depending on moisture content in the air and in the materials. At high RH the pressing time will be shortened and at low RH prolonged. The temperature is also of great importance to the curing.
  - *Pine/pine* with 200 g/m² and moisture contents of 12% in the wood.

<table>
<thead>
<tr>
<th>Pressing time</th>
<th>Temperature</th>
<th>RH</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>15°C</td>
<td>40%</td>
<td>8 hours</td>
</tr>
<tr>
<td></td>
<td>23°C</td>
<td>50%</td>
<td>4 hours</td>
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<tr>
<td></td>
<td>30°C</td>
<td>65%</td>
<td>2 hours</td>
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Curing time: Complete curing to full strength is normally achieved after about 24 hours.

Storage life: At least one year in closed packages at dry and cool conditions. Should not be exposed to temperatures below +5°C or above +30°C.

**RESISTANCE**

The glue line is moisture resistant and semi-rigid.

Fulfills EN 204 Class D4

Heat resistance up to +100°C according to WATT 91

**SURFACE PREPARATION**

Joint interface must be clean, dry and free from oils, loose aggregates, laitance, release agents, waterproofing and other contaminants.

A thorough wire brushing, grinding, sand blasting or solvent cleaning may be required to expose clean, sound surfaces.
DIRECTIONS FOR USE
Cascol Polyurethane 1809 provides almost colorless and water resistant glue joint; normally invisible. During the curing process carbon oxide is created, **high pressure is therefore of great importance to secure good adhesion.** The adhesive is not intended for supporting wood constructions.

Apply adhesive directly from the bottle or with toothed trowel, roller or other suitable tool.

When gluing two non-porous materials to each other, it is advisable to moisten the surface already applied with adhesive by means of a spray-bottle containing water.

Apply high pressure to secure good adhesion.

Close the package immediately after adhesive application since the product easily absorbs moisture from the air thus influencing the storage time.

HANDLING AND CLEANING INSTRUCTIONS
When working with adhesives, cleanliness must be observed. Therefore always work carefully and systematically in order to avoid unnecessary spillage.

In case of skin contact, wash with soap and water.

Contains isocyanate which by some persons might cause allergic reactions.

Maintain good ventilation and use protective gloves to prevent skin contact.

Tools with not cured product can be cleaned with acetone. Do not use compressed air for blowing clean.

Cured adhesive must be removed mechanically.

Keep out of reach of children.

Do not empty into drains.

ENVIRONMENTAL ASPECTS
For additional health and safety information consult the Safety Data Sheet.