



Epoxy Systems' Product #709

THERMOSETTING EMULSION ADHESIVE

PRODUCT #709 conforms to Type I, ANSI/HPVA HP-1-1994 and meets Wet Use Classification, ASTM D5572-95. With the exception of creep-resistance requirements, it also conforms to ASTM D 2559, Adhesives For Structural Laminated Wood Products for Use Under Exterior (Wet Use) Exposure Conditions. It also meets the requirements of European Specification EN204 D4 and DIN 68602-B4.

It is used successfully as a laminating adhesive for cold press, hot press or radio frequency press in the production of veneered tops and end panels, solid and hollow core doors and face and edge glued lumber. It is also used to bond expanded polystyrene to mineral board in the manufacture of insulated roofing underlayment. It meets Factory Mutual wind uplift test requirements for such constructions.

Application	Brush, roller or glue spreader
Coverage	Smooth surfaces: 30-40 pounds/1000 square feet Screenbacks or absorbent materials: 40-65 pounds /1000 square feet
Temperature	Over 40°F (glue line)
Open Time	0 - 1 minute
Closed Assembly	0 - 10 minutes
Press Cycle	This factor will vary with substrates, construction and equipment (hot press, cold press, RF). Press cycles can range from 30 seconds/plus (hot press, RF) 30 minutes/plus (cold press laminating) and 45 minutes to 2 hours (cold press edge and face glue).

TYPICAL PROPERTIES

VISCOSITY	Approx. 4,500 cps before adding catalyst
WEIGHT/GALLON	Approx. 9.2 lbs.
FREEZE/THAW STABILITY	Fair. PROTECT FROM FREEZING.
pH	Approx. 4.6 before catalyzation Approx. 2.6 after catalyzation
WORKING LIFE	See Below
STORAGE	See Below

SEE CAUTIONS REGARDING HANDLING OF CATALYST BELOW.

OTHER PRECAUTIONS

- Keep adhesive covered to prevent drying out and contamination.
- Do not mix with other adhesives.

IMPORTANT NOTE

Minimum operating temperature can vary with changes in moisture content of wood and plant conditions (temperature and relative humidity).

Discoloration of wood veneer products occurs occasionally. Such discoloration is very infrequent and ranges in appearance, color and may vary with the species of the veneer. Discoloration may appear during or after the manufacturing process. Among other things, environmental conditions in some processing plants can contribute to discoloration. If veneer discoloration occurs, our technical service representatives are prepared to assist you in attempting to identify the causes of the staining and possible solutions. Because such discoloration is attributable to conditions beyond our control, Epoxy Systems, Inc. can assume no responsibility or liability for any discoloration that might occur.

MIXING INSTRUCTIONS

PRODUCT #709 must be accurately and thoroughly mixed with Catalyst "B" prior to use. Normal catalyst concentration is 5% on the PRODUCT #709 emulsion by weight.

Addition of Catalyst "B" results in a pastel green color which makes adhesive application visible. When product end-use makes this green color undesirable, 5% **by weight** of Catalyst "B" may be substituted.

See Volumetric Measuring Table, below, for convenient estimations of Catalyst.

VOLUMETRIC CATALYST MEASURE

To one gallon of adhesive, add: 5 **fluid** ounces of Catalyst "B"
Add slowly while stirring. Mix thoroughly.

CAUTION!

Catalysts are acidic in nature. **Handle with care!**

Protect eyes from catalyst. Should skin contact occur, wash the area immediately with water. In case of eye contact, flush with large amounts of water. **Call physician immediately.**

WORKING LIFE

16 to 48 hours at 72°F; will decrease at higher temperatures.

STORAGE LIFE

Shelf life of PRODUCT #709 is approximately 3 months from date of manufacture (@ 70°F). Maximum stability is attained if material is stored between 40°F and 70°F. The viscosity will increase with time in storage. Containers are dated so that storage life can be determined easily.

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