



Technical Data Sheet

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Prefere 4157 with Hardener Prefere 5326X and additive Prefere 4865

Medium viscosity, melamine modified, urea resin. It has a long shelf life and good wash down properties.

Use

Used for the production of fire rated doors and certain other applications.

Technical data

	Prefere 4157
Appearance	Translucent to opaque liquid
Viscosity at 25°C (mPas)	1800 – 2500
Specific Gravity at 25°C	1.270 – 1.330
pH	7.5 – 8.6
Solids Content (%)	67.0 – 72.0%

Instructions For Use

Mixture

Parts by weight

Prefere 4157	100
Prefere 4865	20
Hardener Prefere 5326X	2.5
Water	0.5

Preparation of the mix

Mix the Prefere 4157 and water in a container fitted with a mechanical agitator. Add the Prefere 4865 gradually, with stirring, to ensure that the powder is evenly dispersed. Continue to stir until the solution is free from lumps.



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The mix, with no hardener added, can be kept for up to 12 hours.

When the mix is even and free from lumps, add the required amount of hardener Prefere 5326X. When the hardener has been added the mix should be used immediately. Care should be taken to ensure that the hardener is well dispersed prior to use.

Pot life

The glue mix has a pot life of approximately 3 hours at 25°C. The pot life will be longer at lower temperatures, and shorter at higher temperatures. The pot life will be greatly reduced at temperatures above 30°C. On a mechanical glue spreader, the spreader life will be about 2 hours.

Spread Rates

Glue spreads of between 170 – 190 g/m² are recommended for fire rated constructions.

Press Times

At press temperatures of 90 – 100°C, a press time of approximately 12 – 15 minutes is required for typical fire rated door constructions. The press time will depend on the construction of the panels, and the distance to the furthest glue line from the press platens.

Pressure

A pressure of 0.35 – 0.42 MPa (50 – 60psi) is normally adequate for typical fire rated panel constructions.

Cleaning

The mixing and application equipment must be cleaned at the end of each working day. The application equipment can be easily cleaned with warm water (40 – 60°C). If the glue mix thickens in the application equipment, the equipment must be immediately emptied and cleaned, otherwise there is a risk that the glue will cure. TS Resins product CB conditioner can be used to ease cleaning of thickened glue. Cured glue is insoluble and must be scraped off. Before flushing of the equipment with warm water is started, the water pipes must be drained of cold water, as the thickened glue is insoluble in cold water.

Advice on safe handling of glue remainders and wash water can be found in our Technical Information leaflet No. 2E “Glue waste disposal – Prevention of pollution”.



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Caution

TS Resins adhesives and hardeners are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming into contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper – non cloth – towels should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in Material Safety Data sheets for the individual product. These are available on request and should be referred to for fuller information.

The suggestions given in these notes are based on data gained from experience and tests. However, since operating conditions in the user's plant is beyond our control, we cannot assume responsibility for any risks or liabilities, which may result from the use of our products.

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