



## CASCOPHEN® AG-5635Q with CASCOSET® LQ-100

### Description

Cascophen® AG-5635Q is a liquid phenol resorcinol formaldehyde resin for use in gluing structural wood members when fast setting cure times are desirable.

Cascoset® LQ-100 is a ready-made, liquid, para-formaldehyde hardener for use with phenol resorcinol and resorcinol resins. AG-5635Q with LQ-100 exceeds the adhesive durability requirements of the ASTM D-2559 and CSA O112.9 and is designated HRA by both the ALSC and CLSAB.

### Typical Physical Properties (at time of manufacture):

Property	Specification	Units	Test Method
Resin Viscosity	2,000-3,000	cps	(#3 spindle/20 rpm/25°C/1 min)
Hardener Viscosity	500-4,000	cps	(#5/20/21°C/5 min)
Mix Ratio	2.2-2.6/1	parts by weight	Resin to hardener
Mix Viscosity	2,000-5,000	cps	(#4/20/21°C/5 min)
Gel Time	20-40	minutes	50 gram control exotherm <sup>1</sup>
Resin Storage Life	9	months	21°C
Hardener Storage Life	2.5	months	21°C
Resin Screening	20	mesh	American National Standard
Hardener Screening	50	mesh	American National Standard
Resin Solids	55-57	%	125°C convection oven; 1 hr, 45 in.
Resin Specific Gravity	1.17 ± .01		Hydrometer
Hardener Specific Gravity	1.09 ± .01		Hydrometer
Resin Flash Point	56	°C	Pensky Martin closed cup

### Performance Properties

Property	Specification
ASTM D-7374	HRA Elevated temperature
ASTM D2559-04	Wet use
ASTM D7247-07a	Elevated temperature performance
CSA 0112.7	Phenol-Resorcinol Resin Adhesives for Wood

<sup>1</sup>: A 50 gram sample of fresh adhesive is placed in a re-circulating water bath controlled to 21°C. A thermometer and gel stick are inserted into the sample to monitor temperature and distribute exotherm through occasional stirring. The gel is called when the glue mass breaks like toffee as the stick is pulled slowly out of the gel can.

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