



## Cascomel™ 4720 with Wonderbond™ Hrdnr 5025A

### Description

Cascomel™ 4720 is a liquid melamine formaldehyde resin that is used with the liquid hardener Wonderbond™ Hardener 5025A in the manufacture of engineered wood products, e.g. finger jointed lumber, wood I-joists, and glued laminated beams (glulam), for a durable weather-proof bond. It is well suited for ambient temperature cure of finger jointed lumber at temperatures above 50°F and cold set glulam at temperatures above 65°F. Cascomel™ 4720 with Wonderbond™ Hardener 5025A is also well suited to operations using radio frequency cure.

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

Property	Specification	Test Method
<b>4720</b>		
Viscosity	2000-6000 cps	Brookfield RV #4 spindle/20 rpm/25°C @ 1 min
pH	9.2-9.6	25°C (77°F)
Solids	63 – 73%	Convection Oven, 105°C (221°F), 180 minutes
Density	10.49-10.69 lbs/gal	Gardner Weight per Gallon (US) Cup @ 25°C
<b>5025A</b>		
Viscosity	2500-5000 cps	Brookfield RV #4 spindle/20 rpm/25°C @ 1 min
pH	≤1.0	25°C (77°F)
Solids	48 – 50%	Calculated
Density	9.60-11.27 lbs/gal	Gardner Weight per Gallon (US) Cup @ 25°C

### Performance Properties

Property	Specification
ASTM D 2559	Douglas fir, Southern yellow pine
ASTM D 1151 Exposure 3 and 20	Douglas fir
ASTM D 1183 Test Condition D	Douglas fir
CSA O112.9-04 B <sub>2</sub> Creep	Douglas fir
CSA O112.9-04 (CCMC # 13252-L)	
CSA O177-06 small-scale bondline fire performance equivalency tests	
APA/WIJMA AC1000-05, 60 minute duration at 450°F	
Small-scale Bunsen burner flame test	
AWC Elevated-Temperature Adhesive Qualification Procedure, Method A	
Approved by ALSC and CLSAB as a heat resistant adhesive (HRA) for end-jointed lumber	
ASTM D7247-07a according to the criteria set in ASTM D5055-07	

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Before using any Hexion Inc. product, please be sure to read the Safety Data Sheet which was included with the shipment.

For more information contact your local Hexion Sales Representative or Customer Service Center (866) 443-9466.

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