Urea Resin Curing Times for Dynea 4152.

Hardener Addition and Pot Life						
Hardener (Dynea)	Parts per 100 resin by weight	Pot Life (Hours)				
		10°C	15°C	20°C	25°C	30°C
5689	15	2-3	1-1½	¾ - 1	½ - ¾	¼ -1/2
5602	15	11-12	7-8	4-5	2-3	1-1½
5611	20	>24	18-25	9½ -12	5½ - 7	2¾ - 3¼
5664	50	-	22-24	12-14	5-6	2½ - 3

Cold and Warm Pressing Times							
	Glue Line Temperature (Hours)						
	10°C	15°C	20°C	25°C	30°C	35°C	40°C
5689	2 ½	1½	1	¾	½	¼	10min
5602	14	8	5	3¼	1¾	65min	50min
5611	-	-	-	-	-	-	-
5664	-	-	-	-	-	-	-

Hot Pressing Times						
	Glue-Line Temperatures (Mins)					
	55°C	60°C	65°C	70°C	75°C	80°C
5689	4 ½	3	2	1 ½	1 ¼	¾
5602	6½-7	4-4½	3½	2-2½	1½ -2	1¼-1½
5611	-	-	-	2¼	2¾ - 3½	2¾ - 3
	70°C	75°C	80°C	85°C	90°C	95°C
5664	190secs	165secs	140secs	120secs	100secs	75secs

Note: This chart is for guidance only. It is recommended that components are weighed accurately before mixing.

Adkwik | 57 Ditton Walk | Cambridge | CB5 8QD
T. 01223 412373 | F. 01223 249085 | E. sales@adkwik.co.uk | www.adkwik.co.uk