



CASCO-RESIN® CR-583

Product Description

Casco-Resin® is a high solids urea formaldehyde resin for hardwood plywood, furniture and lumber gluing. Hardwood plywood and furniture panels made with CR-583 exhibit low formaldehyde emissions per HPVA HP-1 1992 standard. CR-583 meets South Coast AQMD Rule 1168 VOC for wood adhesives.

Catalyst Selection

It is important to choose the best catalyst for the job. The type of catalyst and the amount used can be varied to give a range of usable life, assembly time and press time. CR-583 can be cured at room temperature (limited basis) or by application of heat with a hot press or radio frequency press.

Cascoset® FM-250D is Hexion™ Specialty Chemicals, Inc.'s most popular catalyst for hot pressing hardwood plywood and for RF pressing curved plywood. FM-250D provides an adhesive mix with long usable life.

Cascoset FM-390F provides a thicker, faster curing mix than FM-250D. This catalyst is the best choice for RF edge gluing and for faster hot press cycles in cold weather.

CR-583 is recommended for heat cure operation. Room temperature gluing of high pressure laminate plastic to wood or board core is possible, although cure times range from several hours to more than 24 hours. Some room temperature applications, such as gluing hardwood lumber, are not recommended with CR-583. It is best to discuss your intended application with a Hexion representative before proceeding.

Mixing Directions

The catalyst level may be varied from 10 to 20 parts catalyst per 100 parts resin by weight. For hot

pressing plywood, 10 parts catalyst is a good starting point. For RF pressing curved plywood, 15 parts catalyst will provide a good RF conductive mix. If RF edge gluing, use 15 to 20 parts catalyst.

IMPORTANT: This is considered the minimum information needed for a basic working knowledge of CR-583. We encourage you to contact Hexion for more extensive information.

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

For more information contact your local Hexion Sales Representative or Customer Service Center +1 800 441 9637.

Usable Life @	10 Parts FM-250D	20 Parts FM-250D	10 Parts FM-390F	20 parts FM-390F
70°F	6 Hours	8 Hours	3 Hours	1 Hour
90°F	3 Hours	4 Hours	1½ Hours	½ Hour

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