



CP-0509

Veneer Splicing Adhesive

For product information or purchasing:  
CP Adhesives  
800.454.4583

**General Characteristics:**

CP Adhesives splicer adhesive is a pre-catalyzed dry urea-formaldehyde powder, designed for use with conventional splicer machines, both straight-through and cross-feed types, as well as automated splicing equipment. This adhesive is usable for up to one year when stored in a closed container in a cool, dry location. Drums should be placed on boards or pallets, and not directly on concrete floors.

This splicer adhesives require only the addition of water. It is a light tan / whitish color, and has a long gel time. That translates into longer pot life and longer carry time.

**Directions and use guidelines**

**Mixing Procedures:**

	<b>Splicer proportion</b>	<b>Water proportion</b>
	<b>100 parts</b>	<b>60 parts</b>

When used in non-automated splicing machines, splicer adhesive should be mixed on the basis of 100 parts powder to 60 parts of water by weight. The amount of water may be varied to obtain viscosity for various application methods. Roller application generally requires a higher viscosity than a spray application. The water temperature for mixing should be between 70° F and 75° F unless plant and stock temperatures are above 90° F, then 60° F to 65° F water should be used.

The suggested mix procedure is as follows:

1. Place 1/2 to 2/3 of the required water into the mixer.
2. Start agitation and slowly add the powder.
3. Mix until lump-free viscous mixture is obtained.
4. Add remaining water and mix thoroughly.

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**Working Life, Adhesive Spreads, and Assembly Times:**

Table I gives the approximate working life for mixed CP-0509 at 77° F and 90° F conditions. Using cool water when mixing the glue can extend the working life.

In general, as light a spread as possible should be used with the assurance that a continuous adhesive film is applied. After application, the adhesive should not be visible to the naked eye. If the veneer is held at the proper angle near a light source, a lustrous glue line should be visible. Heavy glue spreads can result in longer dry-down times, veneer sticking, **and** adhesive buildup on the heater bars.

Minimum assemblies (dry-down) times for all splicer adhesives are about 30 to 60 minutes. This time can be reduced through the use of fans, heat lamps, or heat boxes. Factors that govern dry down times are veneer moisture content, specific gravity, and plant relative humidity or temperature. Maximum assembly times (carry time) are governed by plant temperature and relative humidity as well as veneer moisture content, density, and acidity.

**TABLE I**

<i>Adhesive</i>	<i>Mix Color</i>	<i>Pot Life (in hours) @ 77° F</i>	<i>Pot Life (in hours) @ 90° F</i>	<i>Assembly Time</i>
CP-0509	Tan	30-36	18-20	Up to two days

\*Final bundles may be carried over to the next morning, for splicing if plant and stock temperatures do not exceed 70° F.

**Splicer Maintenance**

A clean tape less splicing machine is important for best results. The heater bars should be cleaned frequently by running a piece of thick veneer through the splicer with the veneer grain direction at right angles to the heater bar. This will scrape off any resin that has built up on the heater bars. If veneer sticking and glue buildup persist, a release agent should be applied to the heater bars each day before splicing starts.

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## TROUBLE SHOOTING GUIDE

Listed below are the most common causes for problems in veneer splicing

<i>Problem</i>	<i>Probable Cause</i>	<i>Remedy</i>
Applied adhesive fails to dry-down.	Too much adhesive on veneer	Reduce amount being applied.
Veneer fails to carry through the day or night.	Cool temperatures. High relative humidity in plant	Use heater with fan or hotbox.
	Very long gel time splicer being used	Select shorter gel time glue.
Excessive adhesive buildup on the heater bars.	High plant temperatures. Low relative humidity in plant	Select splicer with longer carry time.
	Too much adhesive on veneer.	Reduce amount being applied.
Spliced veneer falls apart after splicing.	Not enough carry time.	Allow more time before splicing.
	Dirty or gummy heater bars.	Clean heater bars and apply release agent.
Excessive adhesive on each side of splice joint.	Insufficient adhesive.	Increase amount applied and make sure application is uniform.
	Veneer too dry.	Increase moisture content in the veneer. Range 4-10%, optimum 6-8%.
	Not enough pressure when spliced.	Increase pressure.
Splice joint highly visible.	Poor glue joints.	Check joints to make sure they are true and straight.
	Incomplete adhesive cure.	Check heat.
Lumpy mix.	Too much adhesive on veneer.	Reduce amount of adhesive applied.
	Adhesive too wet.	Allow longer stand time.
Thin adhesive mix	Thick splice joint.	Too much adhesive, or veneer not properly jointed.
	Color of adhesive and veneer do not match.	Modify color by tinting.
Thin adhesive mix	Incomplete mixing	Weigh comp
	Overage material	
Thin adhesive mix	Excess water	Adjust water, weigh components

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