



Unibond 800

Instructions For Use

Unibond 800 resin and hardener C800 is a modified urea formaldehyde 2-part adhesive designed for a wide variety of wooden parts where a rigid, gap- filling and craze- resistant bond is desired.

Mixing

Unibond 800 blends easily and can be mixed by hand or mechanically. Always mix the hardener into the resin, and stir until mixture is smooth. The curing action of Unibond 800 can be increased or decreased by resin to hardener ratio. A faster set is usually used at a lower temperature to shorten clamp times and a lower set is used to provide adequate open assembly time at higher temperatures. **DO NOT EXCEED THESE RATIOS OR PROPER BONDING CANNOT BE ASSURED.**

When possible, it is recommended that Unibond 800 be measured by weight rather than volume for maximum accuracy.

Mixing Ratios:

	FAST	SLOW	
BY WEIGHT	7	12	RESIN HARDENER
BY VOLUME	3	6	RESIN HARDENER

Pot Life

As soon as the glue is mixed it is ready for application. Pot life will depend on the temperature of the glue and the room temperature. **DO NOT USE UNIBOND 800 BELOW 65°F AS PROPER CURING WILL NOT TAKE PLACE.**

Pot Life	Temperature
30 min.	90°
45 min.	85°
1 hr.	75°
2 hr.	65°

Assembly Time

It is recommended to apply clamping pressure directly after the glue is applied. The table below indicates approximate amount of open assembly time to prevent air drying and lack of proper adhesion to the adjoining surface.

Temperature	Minutes
90°	10
80°	20
70°	30

Clamping Time

Proper clamping time for Unibond 800 is determined by four factors: temperature of glue, temperature of wood, temperature of room, and by the ratio of resin to hardener. Recommended minimum clamp time is given for flat work that is not unduly stressed. Bent laminations should remain clamped until full set is achieved.

Clamp Time	Temp F°
1 hr.	95°
2 hr.	85°
3 hr.	75°
5 hr.	65°

A simple test to determine minimum clamp times is to set aside a small amount of the extra mixed glue in a cup. When it has gelled to the point where it can be removed in one piece and is the consistency of firm rubber, a panel or part that is not stressed can be removed, but not worked or machined until full set has been achieved. Full set is achieved when the glue is no longer flexible.

Glue Color

C800R, the original catalyst for Unibond 800, is neutral tan in color and formulated for use on medium tone woods. A lighter Glue color can be achieved by using the white hardener C800W for extremely blonde woods. More recently we have formulated C800D for projects requiring a dark glue color (such as mahogany, walnut and others).

Shelf Life

Unibond 800 resin should be stored in its original container in a cool place. The shelf life of this resin depends on the temperature at which it is kept. Unibond 800 resin is no longer useful when it becomes too thick to spread or work with.

Temperature °F	Shelf Life
60°F	12 mos.
75°F	6 mos.
90°F	3 mos.

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