

## CASCOPHEN® AG-5645Q with CASCOSSET® FM-6310L

### Description

Cascophen® AG-5645Q is a liquid phenol-resorcinol-formaldehyde resin for use in gluing structural wood members when fast setting cure times are desirable.

Cascoset® FM-6310L is a ready-made, liquid, formaldehyde hardener which is for use with phenol-resorcinol and resorcinol resins.

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

Property	Specification	Units	Test Method
Resin Viscosity	2,650-3,000	cps	(#3 spindle/20 rpm/25°C/1 min)
Hardener Viscosity	2,000-4,000	cps	(#5/20/21°C/5 min)
Mix Ratio	2.2-2.5/1	parts by wt.	Resin to hardener
Mix Viscosity	5,000-9,000	cps	(#4/20/21°C/5 min)
Gel Time	15-20	minutes	50 gram control exotherm <sup>1</sup>
Resin Storage Life	9	months	@21°C
Hardener Storage Life	6	months	@21°C
Resin Screening	20	mesh	American National Standard
Hardener Screening	50	mesh	American National Standard
Resin Solids	55-57	%	125°C convection oven; 1 hr. 45 min.
Resin wt./gallon	9.78-9.82	lbs/US Gal.	Gardner Wt/Gal cup
Hardener wt./gallon	9.3-9.5	lbs/US Gal.	Gardner Wt/Gal cup
Resin Flash Point	56	°C	Pensky Martin closed cup

<sup>1</sup>: A 50 gram sample of fresh adhesive is placed in a re-circulating water bath controlled to 21°C. A thermometer and gel stick are inserted into the sample to monitor temperature and distribute exotherm through occasional stirring. The gel is called when the glue mass breaks like toffee as the stick is pulled slowly out of the gel can.

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**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 (800) 441-9637.**

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