

## CASCOPHEN® AG-5675Q with CASCOSSET® FM-6310L

### Description

CASCOPHEN® AG-5675Q is a liquid phenol-resorcinol-formaldehyde resin for use in gluing structural wood members when fast setting cure times are desirable.

CASCOSSET® FM-6310L is a para-formaldehyde, ready-to-use, liquid hardener for use with phenol-resorcinol and resorcinol resins.

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

Property	Specification	Units	Test Method
Viscosity – Resin	2,650-3,000	cps	(#3 spindle/20 rpm/ 25°C/1min)
Viscosity – Hardener	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)
Resin Solids	55-57	%	125°C convection oven; 1 hr. 45 min.
Gel Time <sup>2</sup>	13-17	minutes	50 gram controlled exotherm <sup>1</sup>
Storage Life - resin	9	months	@ 21°C
Storage Life – hardener	6-8	weeks	@ 21°C
Screening – resin	20	mesh	American National Standard
Screening – hardener	50	mesh	American National Standard
Weight/Gallon			
resin	9.78-9.82	Lbs./U.S. Gal	Gardner wt/gal cup @21°C
hardener	9.3-9.5	Lbs./U.S. Gal	Gardner wt/gal cup @21°C
Flash Point – resin	56	°C	Pensky-Martin closed cup
Flash Point – hardener	>94	°C	Pensky-Martin closed cup

Notes:

<sup>1</sup> A 50 gram sample of fresh adhesive is placed in a re-circulating water bath controlled at 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 out of the gel can.

<sup>2</sup> Resin reactivity can be adjusted to achieve gel times between 0-30 minutes for individual plant requirements.

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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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