



Sovereign One Shot

Sovereign One Shot is a urea-formaldehyde powdered resin adhesive.



Product Code
30806607

Description

Sovereign One Shot urea-formaldehyde powdered resin is a waterproof gap-filling wood adhesive.

Sovereign One Shot conforms to BS1204 1993 MR parts 1 and 2, BS EN 204 Durability Group D3 and BS EN 302-1 A3 Type II.

Form Supplied: Powdered Resin

Pack Sizes: 3 kg

Colour Range: Cream coloured powder

Contains: Urea-formaldehyde

Properties

Particularly suitable for interior and exterior joinery, shop fitting, assembly gluing, synthetic laminates, and veneers. Sovereign One Shot will cure quickly but allows sufficient working time for most applications using both hot and cold pressing techniques.

Preparation

Mixing by volume: 3.5 parts One Shot to 1 part clean water.

Mixing by weight: 2 parts One Shot to 1 part clean water.

Add the water to the powder gradually and stir until the solution is lump free. The pot life of the mixture in relation to time is given in the data table. The mixing vessel should be made of glass, stoneware or plastic. Metallic containers will discolour the adhesive.



USAGE

Surfaces to be joined should be thoroughly sanded and free from dust. Joints should be well fitting although One Shot will accommodate small discrepancies.

MOISTURE CONTENT

The surfaces to be bonded should ideally have moisture contents between 7 - 13%, but at pressing temperatures above 105°C, moisture content should not exceed 10%. Variation in moisture content between bonded surfaces should not exceed 3%.

APPLICATION

The mixed adhesive should be applied thinly by brush, wooden rod or hand roller to one surface at a rate of 180-250 gm/m². The joint should then be assembled and full clamping pressure applied. Where low clamping pressure is applied then the adhesive mixture should be applied to both surfaces.

PRESSING OR CLAMPING

When wood has been stored in unheated conditions it may be cold and contain excessive moisture thereby causing poor bonding. Prior to gluing the wood should be stored for several days in reasonably warm and dry conditions. See data table for minimum pressing or clamping times.

HEAT PENETRATION

The setting times refer to glue line temperatures only and the time taken for heat to travel from the press platen must be taken into account. Heat penetration time depends on the wood density, moisture content and distance to the farthest glue line. The extra times required for low and medium timbers are shown in the data table. These pressing times apply when bonding absorbent materials such as low and medium density wood. Pressing times must be greatly extended when bonding less absorbent materials.

PRESSURE

The clamping pressure applied on joints must be sufficient for good contact between bonding surfaces and must be maintained over the specified clamping time. When veneering or applying thin decorative laminated plastics to surfaces such as particleboard, plywood, or blockboard, pressures of 0.35 - 0.42 MPa (50 - 60 lbf/in²) are adequate.

CLEAN UP

Equipment may be cleaned with warm soapy water before the glue has time to set. Persistent residue may be removed by the addition of isopropyl alcohol to the water.



POT LIFE MIXED

Temperature of mix	10°C	20°C	30°C
Pot Life	10 Hours	2 Hours	30 Minutes

OPEN TIME

Temperature of mix	10°C	20°C	30°C
Assembly Time	60 Minutes	30 Minutes	8 Minutes

PRESSING OR CLAMPING TIME

Glue Line Temperature	10°C	20°C	30°C
Minimum pressing or clamping time	20 Hours	4 Hours	2 Hours

Minimum pressing or clamping times are those required to give 1.33 kN dry shear strength on close joints according to BS 1204: Part2. When joints are strained immediately after removal of pressure the above times should be increased. Sovereign One-Shot will continue to gain strength over several days when full waterproof properties are developed.

HOT PRESSING TIME

Glue Line Temperature	50°C	70°C	90°C
Basic set time	9-10 Minutes	3 Minutes	1 Minute

HEAT PENETRATION

Distance to Glue Line	Heat Penetration time in minutes per mm Distance to glue line		
	80°C	100°C	120°C
Less than 5 mm	1.2	0.9	0.8
Between 5 and 10 mm	1.7	1.2	1.0
Greater than 10 mm	2.0	1.4	1.2

Storage: Between 5°C – 30°C.

Shelf Life: 12 months unopened.

HEALTH & SAFETY

- ! Keep out of reach of children.
- ! Do not breathe dust.
- ! Avoid contact with the skin.
- ! In case of contact with eyes rinse immediately with plenty of water and seek medical advice.
- ! Wear suitable protective clothing, gloves and eye/face protection.
- ! If you feel unwell seek medical advice



Health & safety information available on request



Important Disclaimer

The information given is in good faith based on experience and usage, however all recommendations are made without warranty or guarantee, since the conditions of use are beyond our control. All goods are sold in accordance with our Conditions of Sale, copies of which are available on request. Customers are advised that product, techniques and codes of practice are under constant review and changes occur without notice. Please ensure you have the latest updated information.



Sovereign
the gold standard in building products

Sovereign Support: 01229 870800 | www.sovchem.co.uk

FIND US HERE

