

Borden Resin F/120



HARDENERS

POT LIVES

PRESSING TIMES★

RESIN F/120	GRADE	Parts per 100 Resin	Hours (Except where marked m - mins)					Hours					Minutes (s = Seconds)				Seconds (m = Minutes)						GRADE					
			10°C	15°C	20°C	25°C	30°C	10°C	15°C	20°C	25°C	30°C	50°C	60°C	70°C	80°C	90°C	100°C	110°C	120°C	130°C	140°C		150°C	160°C			
POWDER HARDENERS	UH-21	20	4	2	1	½	18m	8	4	2	1	½	11	4¾	2¼	¾	57	37	32	29	23	15	12	10	UH-21			
	UH-191	5	7	4	2¾	1½	¾	14	8	5½	3	1½	16	5½	2½	1¾	68	39	36	32	26	21	14	14	UH-191			
	UH-191	10	8½	6½	4½	2½	1½	17	13	9	5	3	16	5½	2½	1¾	68	39	36	32	25	20	14	14	UH-191			
	UH-191	15	18	10	7	4	1¾	34	22	14	8	3½	16	5½	2½	1¾	52	35	33	30	26	23	15	15	UH-191			
	UH-191	20	28	14	9	6	2½	46	30	20	10	5	21	7	3¼	2¼	66	39	35	32	28	24	15	15	UH-191			
	PD-410	15	26	17	8	4½	2½	42	30	16	9	5	21	7	3¼	2¼	59	37	34	32	32	19	19	16	PD-410			
	PD-410	20	30	23	11	4¾	3½	42	36	20	9½	7	23	8	3¾	2½	68	40	40	39	29	25	20	18	PD-410			
	UH-583	15	25	17	11½	5½	3	40	30	23	11	6	21	7	3¼	2¼	61	47	47	41	41	28	26	25	UH-583			
UH-583	20	40	22½	16½	10½	4½	50	40	30	20	9	21	7	3¼	2¼	68	47	44	43	43	40	36	26	UH-583				
COMBINED FILLER/HARDENERS	UXE-14	20	15	7	3.5	2	1¼	-	-	-	-	-	12½	7	5½	3½	2m	40	35	25	20	15	11	9	UXE-14			
	UXE-14	25	-	10	4½	2¼	1½	-	-	-	-	-	12¾	8	6	4	2½m	50	40	30	17	16	11	9	UXE-14			
	UXE-13	20	-	9½	5½	2¾	1¾	-	-	-	-	-	25	12	6	2½	90	60	35	31	23	17	12	12	UXE-13			
	UXE-13	25	-	12	6½	3¼	2	-	-	-	-	-	26	14	7	3½	1¾m	90	40	32	25	18	15	13	UXE-13			
	UXE-32	20	14	10	6	4	2½	18	14	10	7	4	10	7	3½	2	60	45	35	30	30	25	20	10	UXE-32			
	UXE-32	25	20	15	10	6	4	-	24	15	8	5	16	8	4½	4	90	60	45	40	35	30	20	15	UXE-32			
	UH-28	25	10	7	5½	2¾	1½	24	14	10	5½	3	16	5½	2½	1¾	50	35	30	27	20	19	15	15	UH-28			
	UH-28	50	20	10	8	5¼	3	-	20	16	10½	6	21	7	3¼	2¼	70	50	40	35	30	25	17	15	UH-28			
UH-600	25	-	17	9	5½	2¾	-	-	-	-	-	28	18	9	3	2½m	40	38	32	30	28	18	16	UH-600				
UH-600	50	-	18	11½	5¾	-	-	-	-	-	-	43	26	13	4	3m	65	50	45	36	34	19	17	UH-600				
GAP FILLING HARDENERS	UXE-65	20	-	7½	4¼	2	1½	-	-	-	-	-	40	20	10	4½	2¼m	60	50	41	31	25	22	16	UXE-65			
	UXE-66	20	-	16	8¼	4	2½	-	-	-	-	-	40	21	10	6½m	4½m	4m	3½m	75	45	35	26	26	UXE-66			
	UXE-77	40	40	22½	16½	10½	4½	50	40	30	20	9	21	7	3¼	2¼	68	47	44	43	43	40	36	26	UXE-77			
FLEXIBLE	1298	40	40	30	16	8	5	48	40	30	15	10	28	9½	4½	1½	2¼m	2m	73	58	51	43	36	25	1298			
LIQUID HARDENERS	UXO-83	10	23.5	8.5	4.75	2.75	2						30	10	4½	3	2m	90	66	60	40	35	30	12	UXO-70			
SEPARATE APPLICATION	K10		10m	5 m	2 m	1 m	½ m	2	¾	15m	10m	-					Maximum Assembly Periods						--	--	--	--	--	K10

NOTE: This Chart is for Guidance Only

★ 0.6 mm Veneer on Chipboard

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