

Borden Resin UL39

Resin UL-39	HARDENERS							POT LIVES					PRESSING TIMES*													
	GRADE	Parts per 100 Resin	Hours (Except where marked m - mins)					Hours					Minutes (s = Seconds)				Seconds (m = Minutes)									
			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	1¾	1	½	20m	--	2¾	1½	¾	½	¾	6	2	1	¾	5	23	21	20	17	12	10	9	UH-21	
	UH-191	5	5¾	3¾	1¾	1	25m	9	5	2¼	1½	1	10	4	1¾	1½	60	35	33	30	25	20	15	15	UH-191	
	UH-191	10	9½	5½	2½	1½	30m	15	8¼	3¾	2½	1¾	12	5	2½	2¼	65	38	35	30	25	20	15	15	UH-191	
	UH-191	15	12	7¼	3¼	2	45m	20	11	5	3¼	2	14	5½	3	2½	70	45	40	35	30	25	15	15	UH-191	
	UH-191	20	18	10	4¾	2¾	1¼	30	15	7	4	1¾	16	6	3¼	2¾	80	45	40	35	30	25	15	15	UH-191	
	UH-583	10	19	11¼	5	3	1¼	30	17	7½	4½	1¾	16	6	3¼	2¾	80	40	40	35	35	25	18	16	UH-583	
	PD-410	15	20	12	5¼	3	1¼	36	18	7¾	4½	1¾	16	6	3¼	3	75	45	40	35	35	20	20	16	PD-410	
	PD-410	20	28	16½	7½	4½	1¾	--	24	11	6¾	2½	18	7	3½	3	75	40	40	35	25	20	15	13	PD-410	
	UH-583	15	36	20	9	5½	2¼	--	--	15	8	3¼	18	7	3½	3¼	75	50	45	35	35	20	15	15	UH-583	
	UH-583	20	48	30	14	8	3½	--	--	--	12	5¼	20	10	5¼	3½	90	55	45	40	40	35	25	17	UH-583	
UH-583	25	72	40	20	12	5	--	--	--	18	4	25	13	7	4	2m	60	50	40	40	35	25	17	UH-583		
COMBINED FILLER/ HARDENERS	UXE-14	20	6½	3¾	2	1	¾	-	-	-	-	-	8½	6	3	1¼	25	17	15	12	11	11	10	10	UXE-14	
	UXE-14	25	9½	4½	2¼	1¼	1	-	-	-	-	-	10	7½	3½	1½	30	20	15	12	11	11	10	10	UXE-14	
	UXE-13	20	16	6¾	3¼	1¾	1¼	-	-	-	-	-	13	8	3¾	1¾	50	36	28	20	16	12	12	12	12	UXE-13
	UXE-13	25	19½	8½	4½	2¼	1½	-	-	-	-	-	17	10	4¼	2	55	40	35	22	19	14	12	12	12	UXE-13
	UH-28	25	9	5 ½	2 ½	1 ½	½	14	8 ¼	3 ¾	2 ¼	2 ¼	12	5	2 ¼	2 ¼	60	40	35	30	22	20	15	15	UH-28	
	UH-28	30	11	6 ¾	3	1 ¾	¾	17	10	4 ½	2 ½	1 ¼	13	5¼	2 ½	2 ½	65	40	35	30	22	20	15	15	UH-28	
	UH-28	40	15	9	4	2 ½	1	-	13	6	3 ¼	1 ½	14	5 ½	2 ¾	2 ½	70	45	40	30	25	20	18	18	UH-28	
	UH-28	50	18	11	5	3	1 ¼	-	18	7 ½	4 ½	1 ¾	16	6	3	2	60	50	40	35	35	25	20	19	UH-28	
	UXE-32	20	-	9¼	5¾	3	1¾	-	-	-	-	-	19¼	8¼	7¾	3½	70	55	40	30	25	15	15	14	UXE-32	
	UXE-32	25	-	10	6¼	3¼	2	-	-	-	-	-	25	12	8	5	90	60	40	30	25	15	15	14	UXE-32	
UH-600	25	22	13 ½	6	3 ½	1 ½	-	20	9	5 ¾	2 ¼	16	6	3	2	60	50	40	35	35	25	20	19	UH-600		
UH-600	30	26	15	7	4 ½	1 ¾	-	24	10	6 ¼	2 ½	16	6	3	2	60	50	40	35	30	20	20	18	UH-600		
GAP FILLING HARDENERS	UH-600	40	36	20	10	6	2 ½	-	-	15	9	3 ¾	18	8	4	2 ½	75	50	45	40	35	25	25	20	UH-600	
	UH-600	50	40	24	13	7 ¾	3 ¼	-	-	20	11 ½	4 ¾	20	10	5	3	2 m	55	50	45	40	30	30	20	UH-600	
LIQUID HARDENERS	UXE-65	20	20	6¼	4	1½	¾	-	-	-	-	-	19½	12	8	3½	65	60	35	30	20	20	20	12	UXE-65	
	UXE66	20	-	8¼	6½	2¼	1¼	-	-	-	-	-	30	16	10½	3¾	75	60	40	30	30	30	27	15	UXE66	
	UXE-77	40	48	30	14	8	3 ½	-	-	-	12	5 ¼	20	10	5 ¼	3 ½	90	55	45	40	40	35	25	17	UXE-77	
FLEXIBLE	UXO-83	10	6	3	1 ¼	¾	-	9	5	2 ¼	1 ½	1	10	4	1 ¾	1 ½	60	35	33	30	25	20	15	15	UXO-70	
SEPARATE APPLICATION	1298	40	30	20	9	5 ¼	2 ¼	-	24	12	6	4	20	8	4 ½	2 ¼	105	90	60	50	45	40	35	25	1298	
	K10		8m	6 m	4 m	1½	¾m	35m	25m	20m	15m	10m													K10	

NOTE: This Chart is for Guidance Only

*** 0.6 mm Veneer on Chipboard**

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