

# ANCHOR® Anchorbond D3 PVA Adhesive

## TECHNICAL DATASHEET

Anchorbond D3 PVA is a high performance, water resistant one part PVA emulsion adhesive, formulated for woodworking and meets the requirements of BS EN204/D3 and BS4071.

- Fast Setting
- High Solids - 50%

Suitable for general purpose woodworking including furniture and staircase manufacturing, wood veneer application, decorative laminates and mouldings.

### Surface Preparation

The surface temperature is ideally at between 15-20C to ensure effective and quick drying. The moisture content of the wood materials should not exceed 12%.

### Application

The adhesive, substrate and ambient temperature should ideally be at 20C during the application process. Can be applied by serrated glue spreader, roller or a brush. The open time is dependent on temperature and the moisture content of the substrate.

Recommended coat weight of for cold pressing 100-160 grams per m<sup>2</sup>, and the hot pressing recommendation is 70-120gsm<sup>2</sup>.

### Curing

Closed assembly time on standard board is 20 minutes and FR board is 7 minutes. Details on pressing times at different temperatures can be found on the Anchorbond D3 PVA Adhesive Pressing Guide.

Full water resistance is achieved 7 days after bonding

### Cleaning

Equipment should be cleaned with water whilst the adhesive is wet.

### Key Features

- Polymer Type - PVA emulsion of vinyl acetate
- Solids Content - 50% ± 1%
- Colour - White, clear when dry
- Viscosity (Brookfield RVT) - 100-200 Pas@23C
- Coat Weight - 70-160gsm
- Specific Gravity at 25C - 1.10
- Bond Strength - High
- Drying Time - 3-4 hours
- Shelf Life - 1 year



### Available in:

Anchorbond D3 is available in 1kg, 5kg, 20kg, 250kg and 1000kg containers

**Further Notes**

**Storage and Handling:** Protect from extremes of temperature in a controlled environment between 10C and 40C, and away from direct sunlight. **DO NOT ALLOW THE PRODUCT TO FREEZE.** Store under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months. Keep containers closed to avoid contamination and do not mix with other adhesives.

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