

### ➤ Product Description

ANCHORBOND D4 PVA is a formulated cross-linking emulsion adhesive. It is used for bonding most commonly used types of timber for external use or where high-water resistance is required. It is certified to EN204 Group D4 and it is tested according to WATT 91 and reaches a figure of >7N/mm<sup>2</sup>.

### ➤ Areas of Application

Bonding most commonly used types of timber in doors, windows or any non-load bearing application for external use or where high-water resistance is required.

Can be used in finger jointing, edge to edge gluing, solid wood bonding, dowelling and high (radio) frequency applications. Not suitable for the production of permanently stressed joints.

### ➤ Bonding Instructions

Adhesive, substrate and ambient temperature should ideally be a 15-20°C. The moisture content of the wood materials should be 10-15%.

Can be applied by brush, squeeze bottle, air activated gun, roller or mechanical glue spreader. Has an open time of up to 5 minutes.

Press time at 20°C with a wood moisture content of 12% for softwood is a minimum of 20 minutes. For hardwood it is a minimum of 40 minutes and with high (radio) frequency it is 45 seconds to 2 minutes (cooling time depends on type and shape of substrates).

Full water resistance to EN204 D4 is not achieved until at least 7 days after bonding at storage temperatures above 15°C.

### ➤ Technical Data

Description	Value
Typical Coat Weight	100-180 gsn
Solids Content	47.5% ± 1%
Viscosity (Brookfield RVT, Spindle 5, Speed 20rpm)	5000 mPa.s @ 23°C
Colour	White liquid
Glue Line Pressure	4-10 Kg/cm <sup>2</sup>
Closed assemble time	Up to 10 minutes
Shelf Life	1 Year

### ➤ Storage & Handling

Store in original packaging between 10°C - 40°C. Rotate stock using oldest batch first. Keep containers closed, upright to prevent contamination. Do not mix with other adhesives. Protect from freezing.

### ➤ Cleaning

Wash all equipment with cold or warm water before adhesive dries or MEK when the adhesive is dry.

### ➤ Ordering Information

Part Number	Container Size
1090	5kg
1090/4	4 x 5kg
1091	25kg

### ➤ Health & Safety

**ALWAYS READ RELEVANT MATERIAL SAFETY DATA SHEET BEFORE USE.**

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