



Anchorbond D4 Exterior Grade PVA Adhesive

TECHNICAL DATASHEET

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 $>7\text{N/mm}^2$.

- Water Resistant
- External use projects

For bonding most commonly used timbers for doors, windows and any non-load bearing application for external use or where high water resistance is required.

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 be between 10%-15%.

Application

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

Curing

Press time at 20C with a wood moisture content of 12% for softwood is a minimum of 20 minutes. For hardwood it is a minimum of 40minutes 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 achieved after >7 days after bonding at storage temperatures above 15C.

Cleaning

Equipment should be cleaned with cold or warm water whilst the adhesive is wet or when the adhesive dries use MEK.

Key Features

- Typical Coat Weight - 100-180gsm
- Solids Content - 47.5% \pm 1%
- Viscosity (Brookfield RVT, Spindle 5, Speed 20rpm - 5000mPa.s@23C
- Colour - White
- Glue Line Pressure - 4-10kg/cm²
- Closed assemble time - <10 minutes
- Shelf Life - 1 year



Available in:

Anchorbond D4 is available in 1kg, 5kg or 25kg



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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.

Disclaimer

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