

ANCHOR® AnchorResin 1554 Hardener

TECHNICAL DATASHEET

Anchor 1554 hardener is used in conjunction with Anchor UF Resin 1528. Urea Formaldehyde resins are cured by the addition of a hardener. These hardeners are either acidic or become acidic by reaction with free formaldehyde. These are supplied as an aqueous solution which is mixed with the resin immediately before use. The speed of the cure can be adjusted by variations in levels of acidity and temperature.

The 1554 resin mix is typically for hot and cold press assembly work, veneering, sub-assemblies and flush door manufacture. Can also be used with high frequency curing techniques.

Mixing Instructions

It is recommended that all mixes should be gauged by weight not by volume to ensure accurate percentages. Mixing can be undertaken by hand although for larger mixes, mechanical mixing is recommended. It is advisable that the mix is allowed to stand after mixing to allow any entrapped air is freed.

Application

The mixed adhesive can be applied by brush, roller, hand applicator or mechanical rollers at a spread rate of 150-150g/m². Mechanical spreaders are more capable of achieving the lower end of the range.



Surface Preparation

Ensure all surfaces being bonded are clean and free from oil, wax or other water repellent materials and are dust free. Oily timber should be wiped with an appropriate detergent or degreasing solvent. Machined hardwood may become burnished and consequently water repellent which should be sanded prior to glue application. Plywood may present a similar problem. The ideal moisture content of the surfaces to be bonded should be between 5% and 15% with the moisture difference between the surfaces of no more than 3%.

Further Notes

Storage and Handling: Protect from extremes of temperature in a controlled environment between 10C and 20C, and away from direct sunlight. DO NOT ALLOW THE PRODUCT TO FREEZE. Keep containers closed to avoid contamination and do not mix with other adhesives.

Pot Life and Pressing Times for Anchor UF Resin 1528

Grade	% by Weight	Pot Life			Pressing Time		
		20°C	15°C	20°C	70°C	80°C	90°C
1554	10	1.5hrs	7.5hrs	3.75hrs	65secs	35secs	30secs
	15	2hrs			85secs	60secs	55secs
	20	3hrs			110secs	90secs	85secs

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