



# Anchorbond 3538 Laminating PVA Adhesive

## TECHNICAL DATASHEET

Anchorbond 3538 is a high performance, fast setting one part PVA emulsion adhesive, formulated for laminating and other woodworking to meet the requirements of BS EN204/D3 and BS4071.

- Fast Setting
- Good Heat Resistance

Suitable for general purpose woodworking, wood veneer application, decorative laminates and mouldings. Suitable for hot, cold and RF pressing. With high bond strength and water and creep resistance its an excellent choice for laminating projects.

### 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 3538 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 3538 is available in 5kg, 20kg and 1000kg containers



# Anchorbond 3538 Laminating PVA Adhesive

## TECHNICAL DATASHEET

### 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

Data herein is furnished for information purposes only, and is believed to be reliable. Redwood UK Ltd and any subsidiary companies cannot assume responsibility for the results obtained by others, over whose methods it does not control. It is the users' responsibility to determine suitability for the user's intended purpose of any product and any product method mentioned herein, and to adopt any such precautions as may be necessary to protect property and persons against hazards that may be involved in the handling and use thereof. We recommend that each prospective user test the proposed application to determine the suitability of this product for the purpose intended prior to incorporating any product or application in its manufacturing process using this data as a guide, Redwood UK Ltd accept no liability arising out of the use of this information or the products described herein.