



REDWOOD

Anchorbond D3 PVA Adhesive Pressing Guide

A simple guide on using the Anchorbond D3 PVA which explains the different application methods and best processing instructions.

Application Options

Apply by brush, roller or mechanical glue spreaders, ensure even spreading for consistent glue lines

Working Process Recommendations

Substrate/Environment/Adhesive Temperature - 15-20C

Moisture Content of substrate - 8-12%

Open Time - <5 minutes

Radio Frequency - 2-4 minutes

Recommended Coat Weights

Cold Pressing - Flat Lamination	100-160gsm
Hot Pressing - Flat Lamination	70-120gsm
Edge Gluing	100-160gsm

Pressing Guide

Closed Assembly Times	Standard Board	<20 minutes
	FR Board	<7 minutes
Press Time - 20C	Standard Board	<30 minutes
	FR Board	>45 minutes
Press Time - 90C	Standard Board	>20 seconds
	FR Board	>60 seconds
Press Time - 75C	Edge Gluing - 25mm	>3.5 minutes

Full water resistance is achieved after 7 days of bonding