

### ➤ Product Description

ANCHOR 1554 & 1574 Hardener is to be used in conjunction with Anchor UF Resin 1528 and 1535

### ➤ Features

Urea Formaldehyde resins are cured by addition of a hardener. These hardeners are either acidic or become acidic by reaction with free formaldehyde.

They are supplied as a powder or aqueous solution which is mixed with the resin immediately before use.

Speed of cure can be adjusted by variations in levels acidity and temperature.

### ➤ Application

- Mixing: It is recommended that all mixes should be gauged by weight and not by volume.
- Mixing may be undertaken by hand although for larger mixes, mechanical mixing is recommended.
- It is advisable that the mix be allowed to stand after mixing to allow any entrapped air to be liberated.
- Preparation: Ensure all surfaces to be bonded are clean and free from dust. Oily timber should be wiped with an appropriate detergent or degreasing solvent.
- The ideal moisture content of the surfaces to be bonded should be between 5% and 15% with a moisture differential between surfaces of no more than 3%
- Application: The mixed adhesive can be applied by brush, roller, hand applicator or mechanical rollers.

### ➤ Typical Applications

- The hardener can be used in conjunction with the Anchor UF Resin 1528 and 1535 which is used for Hot and Cold Press assembly work.
- Veneering, Sub-assemblies and Flush door manufacture.
- Can also be used with High frequency curing techniques.
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### ➤ 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
1574	10	0.75hrs			55secs	30secs	25secs

➤ **Pot Life and Pressing Times For Anchor UF Resin 1535**

Grade	% by Weight	Pot Life		Pressing Time	
		20°C	70°C	80°C	90°C
1554	10	2.5hrs	105secs	85secs	75secs
	15	3hrs	135secs	105secs	90secs
	20	4hrs	160secs	130secs	100secs

➤ **Health & Safety**

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

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