



WILSONART[®]
INTERNATIONAL

General Description

An emulsion of water and polyvinyl acetate suitable for bonding decorative laminate to wood products. This product does not require stirring before use.

Applications

- Glue spreader or spray application
- Glue spreader/pinch roller
- Glue spreader/hot press applications
- Suitable for postforming
- Consumer or professional use

Applications to Avoid

- Tempered hardboard products
- Fire retardant treated board products
- Boards treated to be moisture resistant
- Low pressure melamine surfaces
- Metallic, polyester and painted surfaces
- Liner grade laminate to plywood

Availability

- 275-gallon totes (returnable)
- 55-gallon drums
- 5-gallon pails

Storage/Shelf Life

- DO NOT ALLOW PRODUCT TO FREEZE.
- Close container tightly when not in use and store off the floor in a well ventilated area.
- Rotate stock.
- Shelf life expires 1 year from manufacture date.

General Use Instructions

- Ensure substrates and adhesive are above 65°F.
- Best results are achieved between 70°F and 85°F.
- Surfaces must be clean and dry.

Hand Spray Instructions

- Fluid pressure: 30 psi; atomizing air pressure: 60 psi; fluid line: 3/8" I.D. minimum (See equipment recommendations later in this document).
- Coat both surfaces evenly with 7-8 wet grams/ft² covering 100% of each surface. Coat each perimeter slightly heavier. Open time is 5 minutes. Bond immediately and before the adhesive film becomes more than 50% clear.
- Use mechanical pressure (pinch roller) on all assemblies greater than 4 ft². Otherwise, apply 30-40 psi uniform downward pressure using hand-held J-roller over 100% of the bonded area.

Physical Properties

Color:	Pink
Viscosity:	2850 cps (typical)
Density:	9.0 lbs / gallon
Solids Content:	58.0% ± 2.0%
pH:	4 – 5 (typical)
VOC Content:	< 20 g / L (Meth. 24)
VHAP Content:	< 0.032 lbs / lbs solids
Coverage (Spreader):	~ 229 ft ² / gal @ 7 wet mils
Coverage (Spray):	~ 255 ft ² / gal (bonded)

*GREENGUARD[®] Certified

*Complies with SCAQMD, Rule 1168

*Qualifies for LEED[®]-NC & CI EQ Credit 4.1:

Low Emitting Materials: Adhesives & Sealants

*Qualifies for LEED[®]-NC & CI EQ Credit 4.4:

Laminating adhesives shall contain no added urea-formaldehyde resins.

- Large assemblies may be routed or filed immediately. Assemblies less than 4 ft² should rest (5-10 minutes) prior to finishing. Use cover board to protect components against pulling, knocking or stress for one hour. Bond will usually reach full strength in 24 hours.

Spray Equipment Recommendations

- *Binks:* Gun: M95, M95 Auto, M61; Fluid Tip: 68ss (1-2 traversing heads), 66ss (3+ traversing heads), 66ss (edge/underwrap); Air Cap: 68PB (1-2 traversing heads), 66PJ (3+ traversing heads), 66R or 66PJ (edge/underwrap); Needle: 668
- *DeVilbiss:* Gun: JGA 510, MSA 510; Fluid Tip: JGA 4040; Air Cap: MD 4039, 64HD; Needle: D type



PVA ADHESIVE
FOR POSTFORMING & PINCH ROLLER APPLICATIONS



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Flow-Through Postforming Instructions

- Coat both deck surfaces evenly with 7-8 wet grams / ft² covering 100% of each surface. Coat board edge to be formed slightly heavier. Open time is 5 minutes.
- Run laminate and core through drying oven that has been preset to achieve laminate exit temperature of 125°F-150°F. Adhesive film should appear dry (50% clear) but still soft to increased finger pressure.
- Index and apply uniform mechanical pressure (30-40 psi) while laminate temperature is at least 110°F.
- Postform per the manufacturer's recommendations. 180° bends should end on a flat area at least ¾" in width.

Glue Spreader/Hot Press Instructions

- Follow the glue spreader manufacturer's recommendations.
- Use a dual durometer roller (Black Bros. A2158, 16 x ½" pattern).
- Select a groove pattern appropriate for PVA adhesive.
- Apply 6-8 wet mils with glue spreader.
- Open time is 5 minutes.
- Coating of only one surface is preferable.
- Assemble and hot press for 1-2 minutes under 40-50 psi and 180°F-200°F.
- Allow panel to cool for 2-5 minutes.
- Proceed with fabrication.

Clean-up/Disposal

- Clean with hot tap water while adhesive is wet.
- Removal of dried adhesive is very difficult.
- Use diluted ammonia to clean dry adhesive.
- Washwater is RCRA non-hazardous.
- Dispose of in accordance with regulations.

Primary Contents

- Vinyl acetate homopolymer (CAS 9003207)
- Water (CAS 7732185)
- NJTSRN #9500001 and #9500002

GREENGUARD® Indoor Air Quality Standard for Low Emitting Products

GREENGUARD Indoor Air Quality Certified Products meet the following minimum emission requirements:

Category: Adhesives/Sealants

Emission Types	Measure
Individual VOCs	<0.1 TLV
Formaldehyde	<0.05 ppm (<0.06 mg/m ³)
4-phenylcyclohexane	<0.0065 mg/m ³
Styrene	<0.07 mg/m ³
Total VOCs	<0.05 mg/m ³
Total aldehydes	<0.1 ppm

Proposition 65 Warning

This product contains substances known to the State of California to cause cancer or reproductive harm.

Volatile Organic Compounds (VOC):

The use, supply, sale or offer for sale of this product in certain states and localities may be prohibited if it exceeds certain VOC limits. Please check state and local regulations for any prohibitions on the sale and use of this product.

Safety

- Non-flammable
- Mildly irritating to eyes
- May irritate sensitive skin
- Inhalation may irritate respiratory tract
- See MSDS for more complete information
- 24 hr. Chemtrec emergency number:
1-800-424-9300 (US); 703-527-3887 (International)

Warranty

Wilsonart International, Inc. warrants to the user that this product is free of defects for a period of one (1) year from the date of manufacture when it is applied in accordance with manufacturer's instructions or the manufacturer will replace the container at no cost or additional charge to the user, provided the unused portion of the product is returned to the place of purchase within 15 days of the date of purchase. This warranty does not apply to (I) products that are purchased after the expiration of the manufacturer's recommended shelf life as stated on this technical data sheet, (II) misuse or mishandling of the product, (III) improper storage, or (IV) improper fabrication using this product. NO OTHER WARRANTIES, EXPRESS OR IMPLIED ARE MADE, INCLUDING MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. UNDER NO CIRCUMSTANCES SHALL THE MANUFACTURER BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE, OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF WILSONART INTERNATIONAL, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATION OF THIS WARRANTY. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state. Therefore, some of the limitations stated above may not apply to you. It is to your benefit to save your documentation upon purchase of product.

For More Information

- www.wilsonartadhesives.com for:
 - Tech Data Sheets
 - Material Safety Data Sheets (MSDS)
 - Adhesive Quick Reference Chart
 - Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
- Wilsonart Adhesives Division
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