



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/hot press applications
- Suitable for postforming
- 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

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. Store off floor in a well ventilated area.
- Rotate stock.
- Shelf life expires 1 year from manufacture date.

General Use Instructions

- Use only after you read and understand the warnings, safety measures and first aid instructions printed on container.
- May be applied by spray or glue spreader.
- Ensure substrates and adhesive are above 65°F.
- Best results are achieved between 70°F and 85°F.
- Surfaces must be clean and dry.

Continuous Panel Lamination/Postforming Instructions

- Roll coat 6-8 wet mils onto substrate.
- **Open time is a brief 2-5 minutes.**
- Index and insert assembly into laminator.
- Spray no-drip portions of the core after it exits the glue spreader.
- Exit surface temperature should be 150°F-160°F.
- For postforming, spray edge to be formed before insertion into postformer with 100% coverage.

Physical Properties

Color:	Blue
Viscosity:	1500 cps (typical)
Density:	9.1 lbs/gallon
Solids Content:	55.0% ± 2.0%
pH:	4.5-5.5 (typical)
VOC Content:	<20 g/L (Meth. 24)
VHAP Content:	<0.02 lbs/lbs solids
Coverage (Spray):	~255 ft ² /gal (bonded)
Coverage (Spreader):	~229 ft ² /gal @ 7 wet mils

*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.

- Over coverage of formed edge will prevent postforming.
- Allow adhesive to dry before compression force is applied.
- Laminate postforming temperature must be 325°F-375°F.

Glue Spreader/Hot Press Instructions

- Follow the glue spreader manufacturer's recommendations.
- Use a dual durometer roller (Black Bros. A2158, 16 x 1/2" pattern).
- Select a groove pattern appropriate for PVA adhesive.
- Apply 6-8 wet mils with glue spreader.
- **Open time is 2-5 minutes.**
- **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.



WITH FLUORESCENT!
for easy visibility

PVA ADHESIVE
FOR POSTFORMING AND HOT PRESS



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Flow-Through Postforming Instructions

- For Midwest or comparable equipment.
- Coat 100% of both surfaces uniformly with 7-8 wet grams/ft². The edge to be formed must receive 100% coverage. Open time is 2-5 minutes.
- Adjust oven temperature to raise laminate exit temperature to 125°F-150°F.
- Put laminate and core through the oven. Adhesive appearance should be approximately 50% clear with no wet spots on edge to be postformed. ADHESIVE SHOULD INITIALLY FEEL DRY, BUT STILL SMEAR WITH INCREASED FINGER PRESSURE.
- Index the laminate and core and pinch roll immediately at 30 psi minimum. DO NOT PINCH ROLL AT TEMPERATURES UNDER 110°F.
- Postforming may now proceed.
- For best results, 180° wraps should end on at least ¾" of flat surface.

Spray Equipment Recommendations

- *Binks*: Gun: M95, M95 Auto, M61; Fluid Tip: 66ss (edge/underwrap); Air Cap: 66R or 66PB (edge/underwrap), 68PB (overhead).
- *DeVilbiss*: Gun: JGA 510; Fluid Tip: D; Air Cap: 64H

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 waste in accordance with regulations.

Primary Contents

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

<u>Emission Types</u>	<u>Measure</u>
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 by the State of California to cause cancer or reproductive harm.

Volatle 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 complete data
- 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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