



**WILSONART**<sup>®</sup>  
INTERNATIONAL

### General Description

A high solids emulsion of water, starch and polyvinyl acetate suitable for bonding decorative laminate to wood products. This product does not require stirring before use.

### Applications

- Glue spreader/hot press laminating
- Glue spreader/cold press laminating
- May be applied by paint roller
- Hot continuous panel laminating

### 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
- Wheatboard and strawboard

### Availability

- 2,500-pound totes (returnable)
- 500-pound drums
- 45-pound 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

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

### Hot Press/Cold Press Laminating 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 glue.
- Apply 6-8 wet mils with glue spreader.
- Open time is 3-5 minutes.
- Closed time is 15-20 minutes.
- Cold press time is 30-60 minutes at 40-50 psi.
- Wait at least 2-3 hours after pressing to machine.
- Hot press time is 2-3 minutes at 180° F and 40-50 psi.

### Physical Properties

<b>Color:</b>	White
<b>Viscosity:</b>	4850 cps (typical)
<b>Density:</b>	9.4 lbs/gallon
<b>Solids Content:</b>	62.0% ± 2.0%
<b>pH:</b>	4-5 (typical)
<b>VOC Content:</b>	<20 g/L (Meth. 24)
<b>VHAP Content:</b>	<0.042 lbs/lbs solids
<b>Coverage (Spreader):</b>	~229 ft <sup>2</sup> /gal @ 7 wet mils

**\*GREENGUARD<sup>®</sup> Certified**

**\*Complies with SCAQMD, Rule 1168**

**\*Qualifies for LEED<sup>®</sup>-NC & CI EQ Credit 4.1:**

*Low Emitting Materials: Adhesives & Sealants*

**\*Qualifies for LEED<sup>®</sup>-NC & CI EQ Credit 4.4:**

*Laminating adhesives shall contain no added urea-formaldehyde resins.*

- Wait at least 5 minutes or until cool to touch for machining.
- Wait 24 hours after pressing for heavy machining.

### Hot Continuous Application

**(Evans #4260 Continuous Panel Laminator)**

- Apply 6-8 wet mils to single surface.
- Allow oven dwell time of one (1) minute. The panel exit temperature must be 150° F-160° F.
- Set each sequential roller to deliver 50 psi.
- Machining may occur as assembly cools to touch (5 minutes).

### 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.



**PVA ADHESIVE**  
**FOR HOT & COLD PRESS APPLICATIONS**



# PVA ADHESIVE FOR HOT & COLD PRESS APPLICATIONS

## Primary Contents

- Vinyl acetate homopolymer (CAS 9003-20-7)
- Water (CAS 7732-18-5)
- NJTSRN #950001
- Starch (CAS 9005258)
- Polyvinyl Alcohol (CAS 9002895)

## 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 <sup>3</sup> )
4-phenylcyclohexane	<0.0065 mg/m <sup>3</sup>
Styrene	<0.07 mg/m <sup>3</sup>
Total VOCs	<0.05 mg/m <sup>3</sup>
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 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](http://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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