

# 3131

# PVA ADHESIVE

## HOT OR COLD PRESS APPLICATIONS



### General Description

- A high-solids emulsion of water, starch and polyvinyl acetate suitable for bonding decorative laminate to wood products
- Glue spreader/cold or hot press laminating applications
- Hot continuous panel laminating applications
- May be applied by paint roller
- Professional use only
- Most economical hot press adhesive
- Does NOT require stirring before 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
- Wheatboard and strawboard

### Availability

45-lb pails, 500-lb drums and 2,500-lb totes (returnable)

### 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.

### 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 approximately 3-5 minutes.
- Closed time is approximately 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.
- 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.

### Physical Properties

Color:	White
Viscosity:	4850 cps (typical)
Density:	9.4 lbs/gallon
Solids Content:	62.0% ± 2.0%
pH:	4 – 6 (typical)
VOC Content:	< 20 g/L (Meth. 24)
VHAP Content:	< 0.042 lbs / lbs solids
Coverage (Spreader):	~ 229 bonded ft <sup>2</sup> /gal @ 7 wet mils
Open Time:	3-5 minutes
Closed Time:	15-20 minutes
Cold Press Time:	30-60 minutes @40-50psi
Hot Press Time:	2-3 minutes @40-50psi

\*GREENGUARD® Certified

\*Complies with SCAQMD, Rule 1168

\*Complies with the Ozone Transport Commission (OTC)

\*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.*

- Wash water is RCRA non-hazardous.
- Dispose of in accordance with regulations.

### Primary Contents

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

### Safety

- Non-flammable
- Mildly irritating to eyes
- May irritate sensitive skin
- Inhalation may irritate respiratory tract
- See MSDS for more complete information
- 24-hour Chemtrec Emergency: 1-800-424-9300 (US), 1-703-527-

3887 (International)

### Warranty

Manufacturer and distributor of this product makes no warranties, express or implied. No warranty of merchantability or fitness for a particular purpose shall apply. The person using this product (the "user") is solely responsible for determining whether this product is appropriate and/or suitable for user's purpose and method of application. Limitation and exclusion of remedies and damages: the exclusive and sole remedy, and the manufacturer and distributor's exclusive and sole obligation, for any defect of this product is the refund of the purchase price of the product. The manufacturer and distributor shall not, under any circumstances or under any legal theory, be liable to the purchaser or any other person for special, incidental or consequential damages of any nature, including without limitation damages to, or loss of use of, property, damages for loss of profits or revenues or any other damages arising from the purchase or use of the product. The manufacturer and distributor's liability will in no event exceed the purchase price of the product.

### Contact

Customer Service: 1-800-433-3222 or adhesives@wilsonart.com  
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