



General Description

An emulsion of water and polyvinyl acetate suitable for bonding smooth, non-porous or hard-to-bond surfaces to wood surfaces. This product does not require stirring before use.

Applications

- Melamine-to-wood joint assembly (with mechanical fasteners), ABS plastic sheets and mirrors (without Teflon or wax coated backs)
- Glue spreader/cold press laminating
- Consumer or professional use

Please Note: *Wilsonart WA 3301 PVA adhesive has been found to be effective with many low pressure and hard-to-bond surfaces. However, since there are many varieties of low pressure and painted surfaces, and manufacturers of these products may change procedures or components at any time, WA 3301 customers should conduct their own testing to determine the suitability of WA 3301 for any particular use.*

Applications to Avoid

- Tempered hardboard products
- Fire retardant treated board products
- Boards treated to be moisture resistant
- Metallic surfaces

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.

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.

Physical Properties

| | |
|-----------------------------|--|
| Color: | White |
| Viscosity: | 2750 cps (typical) |
| Density: | 8.8 lbs/gallon |
| Solids Content: | 57.0% ± 2.0% |
| pH: | 4-5 (typical) |
| VOC Content: | <20 g/L (Meth. 24) |
| VHAP Content: | <0.033 lbs/lbs solids |
| Coverage (spreader): | ~229 ft ² /gal @ 7 wet mils |

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

Laminating adhesives shall contain no added urea-formaldehyde resins.

- Open time is approximately 3-5 minutes.
- Closed time is approximately 15 minutes.
- Press time is 30-60 minutes at 40-50 psi.
- Wait at least 2-3 hours after pressing to machine.
- DO NOT DISTURB A WET BOND.
- Wait 24 hours after pressing for heavy machining.

Joint Assembly Instructions

- Apply an even film of adhesive on one surface by squeeze bottle. One surface MUST be porous to allow the moisture to dissipate.
- Press materials together and attach mechanical fasteners.
- Protect assembly from flexing or impact for at least 30 minutes, but light machining without disturbing the bond is possible.
- Cure time is 24 hours to full cure.



PVA ADHESIVE
FOR SMOOTH, NON-POROUS & HARD TO BOND APPLICATIONS



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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

- Toluene (CAS 108883)
- Ethylene glycol (CAS 107211)
- NJTSRN #950001 and #950002
- Water (CAS 7732185)

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 for:
 - Tech Data Sheets
 - Adhesive Quick Reference Chart
 - Material Safety Data Sheets (MSDS)
 - Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
- Wilsonart Adhesives Division
10601 NW HK Dodgen Loop
Temple, TX 76503-6110