

3301

PVA ADHESIVE

FOR HARD-TO-BOND APPLICATIONS



General Description

- An emulsion of water, starch and polyvinyl acetate suitable for bonding smooth, non-porous or hard-to-bond surfaces to wood.
- Capable of bonding hard-to-bond surfaces such as joint assembly, melamine to wood (with mechanical fasteners), ABS plastic sheets and mirrors (without Teflon or wax coated backs)
- Glue spreader/cold press laminating applications
- Professional use only
- Does NOT require stirring before use

Please Note: Wilsonart 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

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.

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 minutes.
- Cold 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 if possible.
- Cure time is 24-hours to full cure.

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 bonded ft ² /gal @ 7 wet mils
Open Time:	3-5 minutes
Closed Time:	15 minutes
Cold Press Time:	30-60 minutes @40-50psi

*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.

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. • Wash water 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)

Precautionary Information

Refer to product label and material safety data sheet for Health & Safety information before using this product.

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

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