

3125

WATER RESISTANT PVA ASSEMBLY & HOT OR COLD PRESS



General Description

- An emulsion of water and polyvinyl acetate designed for joint assembly and hot/cold press laminating applications
- Carries ASTM D4317 Type II classification
- Demonstrates good radio frequency (RF) green strength and excellent sandability
- Professional use only
- Ideal for miters and bonding custom edges
- Non-toxic and easy clean-up
- Does NOT require stirring before use

Applications to Avoid

- Tempered hardboard products
- Generic fire retardant treated board products (w/o consultation of Wilsonart rep).
- Low pressure melamine, metallic, painted, polyester surfaces and waterproof (Type I) demands.

Availability

45-pound pails, 500-pound drums and 2500-pound 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.
- Agitation may be required if product thickens.

General Use Instructions

- Ensure surfaces are clean and dry and all substrates are acclimated together at or above 65°F. Bond at 70°F or warmer.

Joint Assembly

Use a generous amount of adhesive. Clamp for 45 minutes. Allow a minimum of one hour before machining.

Hot or Cold Press High Pressure Decorative Laminating

- Ensure laminate and substrate have acclimated to the same temperature before bonding.
- Use correct roller groove configuration (Black Bros. A2158) with minimum of 16 grooves/inch and no cross groove. Dual durometer rollers enhance coverage on uneven substrates.
- Apply 6-8 wet mils evenly across substrate.
- Open time is 5 minutes, and closed time is 20 minutes.
- Allow at least a 30 minute cold press time at 70°F, 45% RH and 40-50 psi. Allow 1-2 hour press time for less than ideal conditions.
- Full cure develops in 24 hours.
- Delay machining for 12 hours after bonding.
- Hot press at 180°F-200°F for 60-90 seconds. Machining is possible after cool to touch.

Clean-up/Disposal

Clean with hot tap water while glue 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.

Physical Properties

Color:	White
Viscosity:	3000 cps (typical)
Density:	9.5 pounds/gallon (typical)
Solids Content:	53.0% ± 1.0% (typical)
pH:	2.9 (typical)
VOC Content:	<20 g/L
VHAP Content:	<0.032 lbs./lbs. solids
Coverage (Bonded):	~229 sq. ft./gallon at 7 wet mils
Chalking Temperature:	60°F
Use Temperature:	70°F-85°F
Open Time:	5 minutes
Closed Time:	20 minutes
Cold Press Time:	30-60 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.

GREENGUARD® Indoor Air Quality Standards

GREENGUARD Indoor Air Quality Certified Products meet the following minimum emission requirements:

Category: Adhesives/Sealants

Emission Types	Measure	Emission Types	Measure
Individual VOCs	<0.1 TLV	Styrene	<0.07 mg/m ³
Formaldehyde	<0.05 ppm	Total VOCs	<0.05 mg/m ³
	(<0.06 mg/m ³)	Total aldehydes	<0.1 ppm
4-phenylcyclohexane	<0.0065 mg/m ³		

Primary Contents

Vinyl Acetate Polymer (CAS# 9003-20-7), Polyvinyl Alcohol (CAS# 25213-24-5), Starch (CAS# 9005-25-8), Water (CAS# 7732-18-5), Aluminum Chloride (CAS# 7446-70-0)

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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