



Wilsonart®

PVA ADHESIVE FOR POSTFORMING & PINCH ROLLING



General Description

- An emulsion of water and polyvinyl acetate suitable for bonding decorative laminate to wood products
- Glue spreader or spray application (glue spreader/pinch roller, glue spreader/hot press applications); suitable for postforming applications
- Professional use only
- Recommended as a sprayable version of Wilsonart 3000 for large panels
- High solids
- 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
- Liner grade laminate to plywood

Availability

5-gallon pails, 55-gallon drums and 275-gallon 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.

Hand Spray Instructions

- Fluid pressure: 30 psi; atomizing air pressure: 60 psi; fluid line: 3/8" I.D. minimum (See equipment recommendations later in this document).
- Coat both surfaces evenly with 7-8 wet grams/ft² covering 100% of each surface. Coat each perimeter slightly heavier. Open time is 5 minutes. Bond immediately and before the adhesive film becomes more than 50% clear.
- Use mechanical pressure (pinch roller) on all assemblies greater than 4 ft². Otherwise, apply 30-40 psi uniform downward pressure using hand-held J-roller over 100% of the bonded area.
- Large assemblies may be routed or filed immediately. Assemblies less than 4 ft² should rest (5-10 minutes) prior to finishing. Use cover board to protect components against pulling, knocking or stress for one hour. Bond will usually reach full strength in 24 hours.

Spray Equipment Recommendations

- Binks: Gun: M95, M95 Auto, M61; Fluid Tip: 68ss (1-2 traversing heads), 66ss (3+ traversing heads), 66ss (edge/underwrap); Air Cap: 68PB (1-2 traversing heads), 66PJ (3+ traversing heads), 66R or 66PJ (edge/underwrap); Needle: 668 for 68ss fluid tip; 665 for 66ss fluid tip.
- DeVilbiss: Gun: JGA 510, MSA 510; Fluid Tip: D type; Air Cap: 64HD; Needle: D type

Flow-Through Postforming Instructions

- Coat both deck surfaces evenly with 7-8 wet grams / ft² covering 100% of each surface. Coat board edge to be formed slightly heavier.
- Run laminate and core through drying oven that has been preset to achieve laminate exit temperature of 125°F-150°F. Adhesive film should appear dry (50% clear) but still soft to increased finger pressure.

Physical Properties

Color:	Green
Viscosity:	2850 cps (typical)
Density:	9.0 lbs / gallon
Solids Content:	58.0% ± 2.0%
pH:	4 – 5 (typical)
VOC Content:	< 20 g / L (Meth. 24)
VHAP Content:	< 0.032 lbs / lbs solids
Coverage (Spreader):	~ 229 ft ² / gal @ 7 wet mils
Coverage (Spray):	~ 255 ft ² / gal (bonded)
Hot Press Time:	1-2 minutes @40-50psi
Open Time:	5 minutes

*GREENGUARD® Certified

*Complies with SCAQMD, Rule 1168

*Complies with the Ozone Transport Commission (OTC)

*Qualifies for LEED®-NC & CI EQ Credit 3.2:
Construction Indoor Air Quality Management Plan-Before Occupancy

*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.

- Index and apply uniform mechanical pressure (30–40 psi) while laminate temperature is at least 110°F.
- Postform per the manufacturer's recommendations. 180° bends should end on a flat area at least ¼" in width.

Glue Spreader/Hot Press Instructions

- Follow the glue spreader manufacturer's recommendations.
- Use a dual durometer roller (Black Bros. A2158, 16 x ½" pattern).
- Select a groove pattern appropriate for PVA adhesive.
- Apply 6-8 wet mils with glue spreader.
- Open time is 5 minutes. Coating of only one surface is preferable.
- Assemble and hot press for 1-2 minutes under 40-50 psi and 180°F-200°F.
- Allow panel to cool for 2-5 minutes. Proceed with fabrication.

Primary Contents

Vinyl acetate homopolymer (CAS 9003207), Water (CAS 7732185), NJTSRN #950002 and #950003

More information on page 2



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Warranty

NO WARRANTY: WILSONART MAKES NO WARRANTIES, EXPRESS OR IMPLIED. NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE SHALL APPLY. The person using the product (the "User") is solely responsible for determining whether the Wilsonart product is appropriate and/or suitable for User's purpose and method of application.

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

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)

Contact

Customer Service: 1-800-433-3222 or adhesives@wilsonart.com
Visit www.wilsonartadhesives.com for information