



**Wilsonart®**

# PVA ADHESIVE

## FOR POSTFORM EDGE APPLICATIONS



### General Description

- An emulsion of water and polyvinyl acetate for high-speed postformed edge applications
- Glue spreader or spray application (glue spreader/hot press applications); suitable for postforming applications
- Glows with blacklight for easier viewing and removal of excess adhesive
- Professional use only
- 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

### 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

- Use only after you read and understand the warnings, safety measures and first aid instructions printed on container.
- May be applied by spray or glue spreader.
- Ensure substrates and adhesive are above 65°F.
- Best results are achieved between 70°F and 85°F.
- Surfaces must be clean and dry.

### Continuous Panel Lamination/Postforming Instructions

- Roll coat 6-8 wet mils onto substrate.
- Open time is a brief 2 - 5 minutes.
- Index and insert assembly into laminator.
- Spray no-drip portions of the core after it exits the glue spreader.
- Exit surface temperature should be 150°F-160°F.
- For postforming, spray edge to be formed before insertion into postformer with 100% coverage.
- Over-coverage of formed edge will prevent postforming.
- Allow adhesive to dry before compression force is applied.
- Laminate postforming temperature must be 325°F-375°F.

### Spray Equipment Recommendations

- Binks: Gun: M95, M95 Auto, M61; Fluid Tip: 66ss (edge/underwrap); Air Cap: 66R or 66PB (edge/underwrap); 68PB (overhead).
- DeVilbiss: Gun: JGA 510; Fluid Tip: D; Air Cap: 64HD

### Flow-Through Postforming Instructions

- For Midwest or comparable equipment.
- Coat 100% of both surfaces uniformly with 7-8 wet grams/ft<sup>2</sup>. The edge to be formed must receive 100% coverage. Open time is 2-5 minutes.
- Adjust oven temperature to raise laminate exit temperature to 125°F-150°F.
- Put laminate and core through the oven. Adhesive appearance should be approximately 50% clear with no wet spots on edge to be postformed. Adhesive should initially feel dry, but still smear with increased finger pressure.
- Index the laminate and core and pinch roll immediately at 30 psi

### Physical Properties

Color:	Blue
Viscosity:	2100-3100 cps (typical)
Density:	9.1 lbs / gallon
Solids Content:	55.0% ± 2.0%
pH:	4.5 – 5.5 (typical)
VOC Content:	< 20 g / L (Meth. 24)
VHAP Content:	< 0.02 lbs / lbs solids
Coverage (Spreader):	~ 229 ft <sup>2</sup> / gal @ 7 wet mils
Coverage (Spray):	~ 295 ft <sup>2</sup> / gal (bonded)
Hot Press Time:	1-2 minutes @40-50psi
Open Time:	2-5 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.*

- minimum. DO NOT PINCH ROLL AT TEMPERATURES UNDER 110°F.
- Postforming may now proceed.
- For best results, 180° wraps should end on at least 3/4" of flat surface.

### Glue Spreader/Hot Press 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 adhesive.
- Apply 6-8 wet mils with glue spreader.
- Open time is 2-5 minutes.
- 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

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.

### Precautionary Information

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

### Contact

Customer Service: 1-800-433-3222 or [adhesives@wilsonart.com](mailto:adhesives@wilsonart.com)  
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