



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/ft². 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:	3000-3500 cps (typical)
Density:	8.7 - 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 ² / gal @ 7 wet mils
Coverage (Spray):	~ 282 - 295 ft ² / 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.

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.

LIMITATION AND EXCLUSION OF REMEDIES AND DAMAGES: The exclusive and sole remedy, and Wilsonart's exclusive and sole obligation, for any defect of this Wilsonart product is the refund of the purchase price of the product. Wilsonart 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. Wilsonart's liability will in no event exceed the purchase price of the product.

More information on page 2



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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
Visit www.wilsonartadhesives.com for information