

**3117**

# PVA ADHESIVE

## FOR COLD PRESS APPLICATIONS



### General Description

- An emulsion of water, starch and polyvinyl acetate suitable for bonding decorative laminate to wood products
- Glue spreader/cold press laminating applications
- Professional use only
- Fast cure time
- Formulated for bonding paper-backed products
- Easy clean-up
- 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
- Wheatboard and strawboard

### Availability

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 5 minutes.
- Closed time is approximately 20 minutes.
- Press time is 30-60 minutes at 40-50 psi.
- Wait at least 2-3 hours after pressing to machine.
- Wait 24 hours after pressing for heavy machining.

### 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

Vinyl acetate homopolymer (CAS 9003207), Water (CAS 7732185), NJTSRN (990011), Starch (CAS 9005258), Polyvinyl Alcohol (CAS 25213245)

### Physical Properties

Color:	White
Viscosity:	5750 cps (typical)
Density:	9.1 lbs/gallon
Solids Content:	43.0% ± 2.0%
pH:	4 – 6 (typical)
VOC Content:	< 20 g/L (Meth. 24)
VHAP Content:	< 0.043 lbs / lbs solids
Coverage (Spreader):	~ 229 bonded ft <sup>2</sup> /gal @ 7 wet mils
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 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.*

### Volatile Organic Compounds (VOC):

The use, supply, sale or offer for sale of this product in certain states and localities may be prohibited if it exceeds certain VOC limits. Please check state and local regulations for any prohibitions on the sale and use of this product.

### 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)

### 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.

### Contact

Customer Service: 1-800-433-3222 or adhesives@wilsonart.com  
Visit [www.wilsonartadhesives.com](http://www.wilsonartadhesives.com) for information