

3125

Wilsonart®

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 durom eter 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.

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)

Physical Properties

Color:	White
Viscosity:	3000 cps (typical)
Density:	9.5 pounds/gallon (typical)
Solids Content:	53.0% ± 1.0% (typical)
pH:	2.9 - 3.1 (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 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.

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) ³	Total aldehydes	<0.1 ppm
4-phenylcyclohexane	<0.0065 mg/m ³		

Precautionary Information

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

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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Contact

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