



**Wilsonart®**

# PVA ADHESIVE

## HOT OR COLD PRESS APPLICATIONS



### General Description

- A high-solids emulsion of water, starch and polyvinyl acetate suitable for bonding decorative laminate to wood products
- Glue spreader/cold or hot press laminating applications
- Hot continuous panel laminating applications
- May be applied by paint roller
- 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
- 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.

### Hot Press/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 3-5 minutes.
- Closed time is approximately 10-15 minutes.
- Cold press time is 30-60 minutes at 40-50 psi.
- Wait at least 2-3 hours after pressing to machine.
- Hot press time is 2-3 minutes at 180°F and 40-50 psi.
- Wait at least 5 minutes or until cool to touch for machining.
- Wait 24-hours after pressing for heavy machining.

### Hot Continuous Application (Evans #4260 Continuous Panel Laminator)

- Apply 6-8 wet mils to single surface.
- Allow oven dwell time of one (1) minute. The panel exit temperature must be 150°F - 160°F.
- Set each sequential roller to deliver 50 psi.
- Machining may occur as assembly cools to touch (5 minutes).

### 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.

### Physical Properties

Color:	White
Viscosity:	9250 cps (typical)
Density:	9.5 lbs/gallon
Solids Content:	58.0% ± 2.0%
pH:	4 – 6 (typical)
VOC Content:	< 20 g/L (Meth. 24)
VHAP Content:	< 0.031 lbs / lbs solids
Coverage (Spreader):	~ 229 bonded ft <sup>2</sup> /gal @ 7 wet mils
Open Time:	3-5 minutes
Closed Time:	10-15 minutes
Cold Press Time:	30-60 minutes @40-50psi
Hot Press Time:	2-3 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.*

### Primary Contents

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

### 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.

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### Contact

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