



**Wilsonart®**

# PVA ADHESIVE

## FOR NON-COPPER & NON-FERROUS METAL BONDING



### General Description

- An emulsion of water, starch and polyvinyl acetate suitable for bonding metal to board applications (non-copper, non-ferrous)
- May be applied by paint roller
- Glue spreader/cold press laminating applications
- Very high solids and easy water clean-up
- 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
- Polyester and painted surfaces

### Availability

5-gallon pails and 55-gallon drums

### 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 12 months from manufacture date.

### General Use Instructions

- Use only after you read and understand the warnings, safety measures and first aid instructions printed on container.
- Application by glue spreader or paint roller.
- Ensure substrates and adhesive are above 65°F.

### 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.
- Cold press time is 20 minutes at 40-50 psi.
- Wait at least 6/8 hours after pressing to machine.
- DO NOT DISTURB A WET BOND.
- Wait 24-hours after pressing for heavy machining.

### Primary Contents

VINYL ACETATE POLYMERS (NOT APPLICABLE), WATER (CAS 7732185)

### 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.

### Physical Properties

Color:	White
Viscosity:	1600-1800 cps (typical)
Density:	8.9 lbs/gallon
Solids Content:	63.0% ± 1.0%
pH:	4.3 - 5.3 (typical)
VOC Content:	< 20 g/L (Meth. 24)
VHAP Content:	< 0.042 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:	45-60 minutes @40-50psi

\*Complies with SCAQMD, Rule 1168

\*Complies with the Ozone Transport Commission (OTC)

\*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.*

### 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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