



**Wilsonart®**



# MELAMINE ADHESIVE

## ACRYLIC EMULSION FOR NON-POROUS MATERIALS

### General Description

- A premium acrylic-based adhesive that bonds non-porous materials to wood and composite surfaces including: melamine, vinyl, high pressure laminate, PVC, wood veneer, metal, stone, tile and acrylics
- High strength bond with excellent water resistance
- Ideal product for manufacturing drawer boxes (including European, pre-finished and medical drawers), cabinets and point of purchase materials.
- Dries quick and clear
- Non-flammable
- Consumer or professional use
- Does NOT require stirring before use

### Applications to Avoid

- Exterior use or application where moisture is present.

### 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 surface is clean and dry.
- Ensure substrate and glue are at or above 45°F.
- Best results are achieved between 70°F and 85°F.
- At least one of the bonding surfaces must be porous. Surfaces to be bonded must be clean and dry. Apply a generous amount of adhesive to the porous surface. Rub the two surfaces together to ensure wetting. Join the two surfaces while the adhesive is still wet (assembly time: 20 minutes at 70°F/50% RH) and lightly clamp the assembly to stabilize the bond for 45-60 minutes or until the adhesive film dries. Staples, screws and/or other fastening devices will create a tighter joint and may be used in lieu of clamping. Machining is typically possible 3-4 hours after assembly.

### Primary Contents

Water (CAS 7732185), Vinyl Acetate Polymers (Not Applicable), Styrene Acrylic Polymers (Not Applicable), Starch (CAS 9005258), Aromatic Diester (NJTSRN #990011)

### 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 30 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.

### Physical Properties

Color:	Off-White
Viscosity:	3800 cps (typical)
Density:	9.0 pounds/gallon
Solids Content:	57.0% ± 2.0%
pH:	7.8 (typical)
VOC Content:	7 g/L
Coverage (Bonded):	~229 sq. ft./gallon at 7 wet mils

\*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.*

### First Aid

**Inhalation:** At the first sign of overexposure (headache, nausea, dizziness), seek fresh air immediately. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician immediately. **Eye Contact:** Immediately flush eyes with running water for at least 15 minutes. Get medical attention. **Skin Contact:** Immediately wash contacted areas of skin with soap and water. Remove contaminated clothing immediately; launder prior to reuse. **Swallowing:** If swallowed, call physician immediately. Do NOT induce vomiting unless directed to do so by a physician. NEVER give anything by mouth to an unconscious person.

### Spray Equipment Recommendations

- Binks: Gun: M95, M95 Auto, M61; Fluid Tip: 68ss (1-2 traversing heads), 66ss (3+ traversing heads), 66ss (edge/underwrap); Air Cap: 68PB (1-2 traversing heads), 66PJ (3+ traversing heads), 66R or 66PJ (edge/underwrap); Needle: 668 for 68ss fluid tip; 665 for 66ss fluid tip.
- DeVilbiss: Gun: JGA 510, MSA 510; Fluid Tip: D type; Air Cap: 64HD; Needle: D type

### 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 glue is wet.
- Removal of dried adhesive is very difficult.
- Use denatured alcohol to clean dry adhesive.
- Washwater 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](mailto:adhesives@wilsonart.com)  
Visit [www.wilsonartadhesives.com](http://www.wilsonartadhesives.com) for information