

## 1. Manufacturer

Wilsonart LLC  
2501 Wilsonart Drive  
P.O. Box 6110  
Temple, Texas 76503-6110  
Phone: (254) 207-7000; (800) 433-3222  
Fax: (254) 207-2384  
Web Site: [www.wilsonart.com](http://www.wilsonart.com)

## 2. Product Overview

### General Description

- Meets or exceeds the requirements as set out in the Window & Door Manufacturers Association (WDMA) TM-6 for a Type I and Type II wood flush door adhesives
- High performance, Type II (ASTM D4317 classification) Water Resistant PVA
- Superior bonding strength formulated for all types of flexible wood veneers
- Exclusively designed to work with various substrates including MDF, particleboard, veneer-core, and fire-rated core
- Easy to sand, off-white, rigid glue line minimizes glue line visibility when cured
- Hot or cold press application
- Non-toxic and easy clean-up
- Does NOT require stirring before use

### Availability

1 gallon, 45 lb. pail, 500 lb. drum, and 2,500 lb. tote (returnable)

## 3. Technical Data

### Physical Properties

<b>Color</b>	White
<b>Viscosity</b>	4500 cps (typical)
<b>Density</b>	9.5 lbs./gallon
<b>Solids Content</b>	57.0% ± 1.0%
<b>pH</b>	2.9 (typical)
<b>VOC Content</b>	<20 g/L
<b>VHAP Content</b>	<0.032 lbs./lbs. solids
<b>Coverage (Bonded)</b>	~229 sq. ft./gal.@ 7 wet mils
<b>Chalking Temperature</b>	60 °F
<b>Use Temperature</b>	70 °F - 85 °F
<b>Open Time</b>	5 minutes
<b>Close Time</b>	15 minutes
<b>Cold Press Time</b>	30-60 minutes @40-50psi

### 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)

#### 4. **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.

##### **Adhesive Application and Press Requirements for Flexible Veneers**

- Ensure veneer and substrate has acclimated to the same temperature before bonding.
- Use correct roller groove configuration (Black Bros. A2083) with minimum of 14 grooves/inch buttress configuration.
- Apply 6-8 wet mils evenly across substrate.
- Open time is 5 minutes and closed time is 15 minutes.

##### Cold Press

- 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.
- Delay machining for 4 hours after bonding.
- Full cure develops in 24 hours.

##### Hot Press

- Hot press at 140°F - 180°F for 60-90 seconds.
- Light machining is possible after cool to touch.
- Heavy machining is available after 2 hours.

##### **Applications to Avoid**

- Tempered hardboard products
- Low pressure melamine, metallic, painted, and polyester surfaces

##### **Clean-Up and Disposal**

- Clean with hot tap water while glue is wet. Removal of dried adhesive is very difficult. Use diluted white distilled vinegar to clean dry adhesive.
- Wash water is RCRA non-hazardous. Dispose of in accordance with regulations.

##### **Storage/Shelf Life**

- DO NOT ALLOW PRODUCT TO FREEZE.
- Close container tightly when not in use.
- Store off the floor in a well ventilated area.
- Rotate stock.
- Agitation may be required if product thickens.
- Shelf life expires 1 year from manufacture date.

##### **Precautionary Information**

Refer to product label and Safety Data Sheet for health and safety information before using this product.

#### 5. **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.

**6. Technical Services**

Customer Service: 1-800-433-3222 or [Adhesives@Wilsonart.com](mailto:Adhesives@Wilsonart.com). Visit [Wilsonart Adhesives](#) online for more information.

**Specification Form:**

Adhesive shall be Wilsonart® 3135OV Flexible Veneer PVA, produced by Wilsonart LLC, Temple, Texas 76503-6110

Wilsonart® 3135OV Flexible Veneer Adhesive

Technical Data

Revised: October 3, 2017

© 1998-2017, Wilsonart LLC