

1. Manufacturer

Wilsonart LLC
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2. Product Overview

General Description

- An emulsion of water and polyvinyl acetate for hard to bond applications
- Ideal for metal partitions or porous to nonporous bonds
- Glue spreader/cold press laminating applications
- Non-toxic and easy clean-up
- Does NOT require stirring before use

Availability

480 lb. drum (returnable) and 2,400 lb. tote (returnable)

3. Technical Data

Physical Properties

Color	White
Viscosity	4000 – 6000 cps
Density	8.9 lbs./gallon
Solids Content	53.0% ± 2.0%
pH	4.0 – 6.0
VOC¹ (less water & exempt solvent)	18.85 g/Liter (Calculated)
VOC/liter of material¹	9.17 g/Liter (Calculated)
VHAP Content	<0.017 lbs./lbs. solids
Coverage (Bonded)	~229 sq. ft./gal. @ 7 wet mils
Chalking Temperature	60 °F
Use Temperature	70 °F - 85 °F
Open Time	5 minutes
Close Time	15 minutes
Cold Press Time	30-60 minutes @40-50psi

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

- Ensure decorative surface and substrate has acclimated to the same temperature before bonding.
- Consult the glue spreader manufacturer for recommended roller groove configuration.
- Apply 6-8 wet mils or 35 lb. of adhesive per 1000 square feet of covered substrates 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.

Applications to Avoid

- Tempered hardboard products
- Fire retardant treated board products
- Boards treated to be moisture resistant
- Low pressure melamine, 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. Visit [Wilsonart Adhesives](#) online for more information.

Specification Form:

Adhesive shall be Wilsonart® 3312 Metal Partitions PVA, produced by Wilsonart LLC, Temple, Texas 76503-6110

Wilsonart® 3312 Metal Partitions PVA

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