



WHITE WOOD GLUE

WATER RESISTANT



General Description

- Lokweld Type II is a one-part crosslinking polyvinyl acetate adhesive designed for wood-to-wood joint assembly, hot/cold press panel operations, fire doors assembly or in radio frequency curing operations
- Carries ASTM D4317 Type II classification
- Carries EN204 type D3 European classification
- Carries Warnock-Hersey registration for GP and Marshfield for doors up to 90 minute (Consult your Wilsonart rep for further details)
- Demonstrates good RF green strength & excellent sandability
- Conforms to ASTM D-4236
- Consumer or professional use
- Ideal for miters and bonding custom edges
- Non-toxic, excellent sandability and easy clean-up
- Does NOT require stirring before use

Applications to Avoid

- Tempered hardboard products
- Generic fire retardant treated board products (w/o consultation of Wilsonart rep).
- Low pressure melamine, metallic, painted, polyester surfaces and waterproof (Type I) demands.

Availability

Pints and 1-gallon jugs

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.
- Agitation may be required if product thickens.

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.
- May be applied by squeeze bottle

Joint Assembly

Use a generous amount of adhesive. Clamp for 45 minutes. Allow a minimum of one hour before machining.

Certificates/Listings

Wilsonart Type II is approved for use in the assembly of up to 90 minute fire doors using the proprietary care material specifications of the following companies: MARSHFIELD DOOR SYSTEMS, INC. and GEORGIA-PACIFIC. Wilsonart Type II is listed by Underwriters Laboratories as an approved component in a Class 1/A fire rated assembly (UL Files R5434 and R6838). For further questions, consult your Wilsonart representative.

Hot or Cold Press High Pressure Decorative Laminating

- Ensure laminate and substrate have acclimated to the same temperature before bonding.
- Use correct roller groove configuration (Black Bros. A2158) with minimum of 16 grooves/inch and no cross groove. Dual durometer rollers enhance coverage on uneven substrates.
- Apply 6-8 wet mils evenly across substrate.
- Open time is 5 minutes, and closed time is 20 minutes.
- 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.
- Full cure develops in 24 hours.
- Delay machining for 12 hours after bonding.
- Hot press at 180°F-200°F for 60-90 seconds. Machining is possible after cool to touch.

Physical Properties

Color:	White
Viscosity:	4900 cps (typical)
Density:	9.1 pounds/gallon
Solids Content:	49.0% ± 1.0%
pH:	2.85 (typical)
VOC Content:	<20 g/L
VHAP Content:	<0.032 lbs./lbs. solids
Coverage (Bonded):	~229 sq. ft./gallon at 7 wet mils
Chalking Temperature:	60°F
Use Temperature:	70°F-85°F
Open Time:	5 minutes
Closed Time:	20 minutes
Cold Press Time:	30-60 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.

GREENGUARD® Indoor Air Quality Standards

GREENGUARD Indoor Air Quality Certified Products meet the following minimum emission requirements:

Category: Adhesives/Sealants

Emission Types	Measure
Individual VOCs	<0.1 TLV
Formaldehyde	<0.05 ppm (<0.06 mg/m ³)
4-phenylcyclohexane	<0.0065 mg/m ³
Styrene	<0.07 mg/m ³
Total VOCs	<0.05 mg/m ³
Total aldehydes	<0.1 ppm

Primary Contents

VINYL ACETATE POLYMER (NOT APPLICABLE), WATER (CAS 7732185), ALUMINUM CHLORIDE (CAS 7446700)

More information on page 2



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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.

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.

Contact

Customer Service: 1-800-433-3222 or adhesives@wilsonart.com
Visit www.wilsonartadhesives.com for information