



Wilsonart®

PVA ADHESIVE

HOT OR COLD PRESS & PINCH ROLLING APPLICATIONS



General Description

- A high-solids emulsion of water, starch and polyvinyl acetate suitable for bonding decorative laminate to wood products
- Glue spreader/cold or hot press laminating applications
- May be applied by paint roller
- 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
- Metallic, polyester and painted surfaces
- Wheatboard and strawboard

Availability

- 45-lb pail, 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.

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.

General Use Instructions

- Ensure substrates and adhesive are above 65°F.
- Best results are achieved between 70°F and 85°F.
- Surfaces must be clean and dry.

Hot Press/Cold Press Laminating Instructions

- Follow the glue spreader manufacturer's recommendations.
- Use a dual durometer roller.
- 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 15-20 minutes.
- Cold press time is 30-60 minutes at 40-50 psi.
- Wait at least 2-3 hours after pressing to machine.
- Hot press time is 2-3 minutes at 180°F and 40-50 psi.
- Wait at least 5-10 minutes or until cool to touch for machining.
- Wait 24-hours after pressing for heavy machining.

Physical Properties

Color:	White
Viscosity:	5800 cps (typical)
Density:	9.3 lbs/gallon
Solids Content:	45.0% ± 2.0%
pH:	3.5 – 6 (typical)
VOC Content:	< 20 g/L (Meth. 24)
VHAP Content:	< 0.031 lbs / lbs solids
Coverage (Spreader):	~ 229 bonded ft ² /gal @ 7 wet mils
Open Time:	5 minutes
Closed Time:	15-20 minutes
Cold Press Time:	30-60 minutes @40-50psi
Hot Press Time:	2-3 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.

Glue Spreader and Pinch Roller

Use a good commercially available glue spreader with the roller groove pattern (dual durometer) set for the application of PVA adhesives used for bonding High Pressure Decorative Laminate (HPDL) such as Wilsonart.

1. Set the wet adhesive film to a depth of 7 ± 1 wet mil which will yield a spread rate of approximately 35 lbs of adhesive per 1000 square feet. With this method, the adhesive may be applied to one surface only, typically the particleboard or plywood substrate.
2. Assemble the materials as the substrate exits the glue spreader and move them immediately through the pinch roller. Under most conditions, this should be completed within 120 seconds. but the panel should not be flexed during the "set period" (typically 1 hour). Flexing the panel during this set period can cause separations between the laminate and substrate resulting in an intermittent bond.
3. At this point the panels should be allowed to rest on a flat surface for about one hour (when the environment and materials are at or above 70°F) before further fabrication is attempted. During this period, it is recommended that the top sheet in the stack be covered (weighted down) by an additional sheet of similar substrate material. No further pressure is required after the pinch roller.

More information on page 2



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Primary Contents

Vinyl acetate homopolymer (CAS 9003207), Water (CAS 7732185), NJTSRN #950002, Starch (CAS 9005258), Polyvinyl Alcohol (CAS 25213245)

Safety

- Non-flammable
- Mildly irritating to eyes
- May irritate sensitive skin
- Inhalation may irritate respiratory tract
- See MSDS for more complete information
- 24-hour Chemtrec Emergency: 1-800-424-9300 (US), 1-703-527-3887 (International)

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.

Contact

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