multidecor
SUPERFICIES DE INGENIERÍA

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PVA ADHESIVE
FOR POSTFORMING & PINCH ROLLING

General Description
• An emulsion of water and polyvinyl acetate suitable for bonding decorative laminate to wood products
• Glue spreader or spray application (glue spreader/pinch roller, glue spreader/hot press applications); suitable for postforming applications
• Professional use only
• High solids
• Fast performance and high heat resistance
• 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
• Liner grade laminate to plywood

Availability
5-gallon pails, 55-gallon drums and 330-gallon 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 substrates and adhesive are above 65°F.
• Best results are achieved between 70°F and 85°F.
• Surfaces must be clean and dry.

Hand Spray Instructions
• Fluid pressure: 30 psi; atomizing air pressure: 60 psi; fluid line: 3/8" I.D. minimum (See equipment recommendations later in this document).
• Coat both surfaces evenly with 7-8 wet grams/ft² covering 100% of each surface. Coat each perimeter slightly heavier. Open time is 2-5 minutes. Bond immediately and before the adhesive film becomes more than 50% clear.
• Use mechanical pressure (pinch roller) on all assemblies greater than 4 ft². Otherwise, apply 30-40 psi uniform downward pressure using hand-held J-roller over 100% of the bonded area.
• Large assemblies may be routed or filed immediately. Assemblies less than 4 ft² should rest (5-10 minutes) prior to finishing. Use cover board to protect components against pulling, knocking or stress for one hour. Bond will usually reach full strength in 24 hours.

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.

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.

GREENGUARD® Indoor Air Quality
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/m3)
4-phenylcyclohexane	<0.0065 mg/m3
Styrene	<0.07 mg/m3
Total VOCs	<0.05 mg/m3
Total aldehydes	<0.1 ppm

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)

Physical Properties

Color:	Pink
Viscosity::	2850 cps (typical)
Density:	9.0 lbs/gal
Solids Content:	58.0% ± 2.0%
pH:	4 – 5 (typical)
VOC Content::	< 20 g / L (Meth. 24)
VHAP Content:	< 0.032 lbs / lbs solids
Coverage (Spreader):	~ 229 ft² / gal @ 7 wet mils
Coverage (Spray):	~ 255 ft² / gal (bonded)
Hot Press Time:	1-2 minutes @40-50psi
Open Time:	2-5 minutes

*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.

Warranty
NO WARRANTY: WILSONART MAKES NO WARRANTIES, EXPRESS OR IMPLIED. NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR APARTICULAR 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
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Contact
Customer Service: 1-800-433-3222 or adhesives@wilsonart.com
Visit www.wilsonartadhesives.com for information

Flow-Through Postforming Instructions
• Coat both deck surfaces evenly with 7-8 wet grams / ft² covering 100% of each surface. Coat board edge to be formed slightly heavier.
• Run laminate and core through drying oven that has been preset to achieve laminate exit temperature of 125°F-150°F. Adhesive film should appear dry (50% clear) but still soft to increased finger pressure.
• Index and apply uniform mechanical pressure (30–40 psi) while laminate temperature is at least 110°F.
• Postform per the manufacturer's recommendations. 180° bends should end on a flat area at least ¾" in width.

Glue Spreader/Hot Press Instructions
• Follow the glue spreader manufacturer's recommendations.
• Use a dual durometer roller (Black Bros. A2158, 16 x ½" pattern).
• Select a groove pattern appropriate for PVA adhesive.
• Apply 6-8 wet mils with glue spreader.
• Open time is 2-5 minutes.
• Coating of only one surface is preferable.
• Assemble and hot press for 1-2 minutes under 40-50 psi and 180˚F-200˚F.
• Allow panel to cool for 2-5 minutes.
• Proceed with fabrication.

Primary Contents
Vinyl acetate homopolymer (CAS 9003207), Water (CAS 7732185), NJTSRN #950001 and #950002