General Description
• An emulsion of water, starch and polyvinyl acetate suitable for bonding decorative laminate to wood products
• Glue spreader/cold press laminating applications
• Professional use only
• Fast cure time
• Formulated for bonding paper-backed products
• Easy clean-up
• 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
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.

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.

Cold Press Laminating Instructions
• Follow the glue spreader manufacturer’s recommendations.
• Use a dual durometer roller (Black Bros. #A2158, 16 x 1/2” pattern).
• 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 20 minutes.
• Press time is 30-60 minutes at 40-50 psi.
• Wait at least 2-3 hours after pressing to machine.
• Wait 24 hours after pressing for heavy machining.

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.

Primary Contents
Vinyl acetate homopolymer (CAS 9003207), Water (CAS 7732185), NUTSRN (990011), Starch (CAS 9005258), Polyvinyl Alcohol (CAS 25213245)

Physical Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>White</td>
</tr>
<tr>
<td>Viscosity (typical)</td>
<td>5750 cps</td>
</tr>
<tr>
<td>Density (lbs/gallon)</td>
<td>9.1</td>
</tr>
<tr>
<td>Solids Content (%)</td>
<td>43.0% ± 2.0%</td>
</tr>
<tr>
<td>pH</td>
<td>4 – 6 (typical)</td>
</tr>
<tr>
<td>VOC Content (Meth. 24)</td>
<td>&lt; 20 g/L</td>
</tr>
<tr>
<td>VHAP Content</td>
<td>&lt; 0.043 lbs / lbs solids</td>
</tr>
<tr>
<td>Coverage (Spreader)</td>
<td>~ 229 bonded ft²/gal @ 7 wet mils</td>
</tr>
<tr>
<td>Open Time (minutes)</td>
<td>5</td>
</tr>
<tr>
<td>Closed Time (minutes)</td>
<td>20</td>
</tr>
<tr>
<td>Cold Press Time (minutes) @40-50psi</td>
<td>30-60</td>
</tr>
</tbody>
</table>

Volatile Organic Compounds (VOC):
The use, supply, sale or offer for sale of this product in certain states and localities may be prohibited if it exceeds certain VOC limits. Please check state and local regulations for any prohibitions on the sale and use of this product.

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
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