



# Wilsonart® WA 20

## Yellow Polyvinyl Acetate Wood Glue for Assembly and Cold Pressing

### Applications

- Joint assembly.
- Cold press laminating
- For consumer or professional use

### Applications to Avoid

- Tempered hardboard products
- Fire retardant treated board products
- Boards treated to be moisture resistant
- Low pressure melamine surfaces
- Metallic, polyester, or painted surfaces

### General Description

- An emulsion of water and polyvinyl acetate

### Availability

- 330 gallon totes (disposable / non-returnable)
- 275 gallon totes (disposable / non-returnable)
- 55 gallon drums
- 5-gallon pails, 1-gallon bottles, 1-pint bottles

### Physical Properties

- Color: Yellow
- Viscosity: 4750 cps (typical)
- Density: 9.0 pounds/gallon
- Solids Content: 47% ± 2%
- pH: 4 - 5
- VOC Content: < 20 g/L (Meth. 24)
- VHAP Content: < 0.032 lbs/lbs solids
- Coverage: ~ 229 ft<sup>2</sup>/gal @ 7 wet mils
- Chalking Temp. 50°F
- Use Temperature: 70°F - 85°

### Performance Properties

- Bond Strength (ASTM D 905-94, Block shear using maple)

Overnight Cure Temp.	Strength	% Wood Failure
Room Temp.	3600 psi	77%
150°F	1600 psi	10%

- Speed of Set (Torsion Test using hard maple and tangential face)

Time from Clamping to Rupture	Strength Development
3 minutes	164 inch pounds
5 minutes	281 inch pounds
10 minutes	469 inch pounds
15 minutes	511 inch pounds

### Storage/Shelf Life

- **DO NOT ALLOW PRODUCT TO FREEZE.**
- Close container tightly when not in use.
- Rotate stock.
- Shelf life expires 1 year from manufacture.
- Store in a well ventilated area and off the floor.

### Safety

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

### General Use Instructions

- Use only after you read and understand the warnings, safety measures and first aid instructions printed on container.
- May be applied by squeeze bottle or glue spreader.
- Surfaces must be clean and dry.
- Test in an inconspicuous area before use.

### Wood and Pottery:

- Spread adhesive evenly and clamp for at least 30 minutes or until the moisture in the bond dissipates.
- Bond will usually reach full strength in 24 hours.

### Paper and Cloth:

- Spread adhesive lightly and press materials together for 15-30 minutes or until the moisture in the bond dissipates.

- Do not disturb the bond while the adhesive is wet.

#### Joint Assembly:

- Squeeze a generous amount of adhesive over the area to be bonded, fit the joint together snugly, and clamp the assembly to stabilize the bond for one (1) hour or until the adhesive film dries. Machining is usually possible one (1) hour after assembly.

#### High Pressure Decorative Laminate:

- Ensure laminate and substrate has acclimated to the same temperature before bonding.
- Apply the adhesive with a glue spreader adjusted to deposit 6 -8 wet mils. Consult the spreader manufacturer for the recommended roller groove configuration (Black Bros.: A2158, 16 x ½" pattern)
- Maintain temperature in the application area at 70°F or above in order to avoid longer press and curing times.
- Use the following recommendations for temperatures between 70°F - 85°F and 45% RH:
  - Apply adhesive at 6 - 8 wet mils
  - Open time is 5 minutes
  - Closed time is 10 - 15 minutes
  - Press time is 15 minutes at 40 - 50 psi
  - Allow a one (1) hour wait time before heavy machining. Note - For some assemblies, a 30 minute wait time may be suitable if the press time is 30 minutes or longer.
  - If the temperature of the shop or components is below 70°F, press for 30 minutes and wait 1 - 2 hours before machining.

#### Cleanup

- Clean with a water-wet rag while the adhesive is wet. Removal of dried adhesive is very difficult.
- Use ammoniated cleaners with vigorous scrubbing to remove dry adhesive.
- Washwater is RCRA non-hazardous. Dispose of in accordance with local regulations.

#### Primary Contents

- Polyvinyl acetate homopolymer (CAS 9003207)
- Polyvinyl alcohol (CAS 25213245)
- Water (CAS 7732185)
- NJTSRN #9500001

#### Warranty

Wilsonart International, Inc., warrants to the user that this product is free of defects for a period of one (1) year from the date of manufacture when it is applied in accordance with manufacturer instructions or the manufacturer will replace the container at no cost or

additional charge to the user, provided the unused portion of the product is returned to the place of purchase within 15 days of the date of purchase. This warranty does not apply to (I) products that are purchased after the expiration of the manufacturer's recommended shelf life as stated on this technical data sheet, (II) misuse or mishandling of the product, (III) improper storage, or (IV) improper fabrication using this product. **NO OTHER WARRANTIES, EXPRESSED OR IMPLIED ARE MADE, INCLUDING MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. UNDER NO CIRCUMSTANCES SHALL THE MANUFACTURER BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE, OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF WILSONART INTERNATIONAL, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATION OF THIS WARRANTY.** This warranty gives you specific legal rights, and you may also have other rights which vary from state to state, therefore, some of the limitations stated above may not apply to you. It is to your benefit to save your documentation upon purchase of product.

#### For More Information

- [www.wilsonart.com](http://www.wilsonart.com) (Adhesive Link) for:
  - Tech Data Sheets
  - Material Safety Data Sheets (MSDS)
  - Adhesive Use Quick Reference Charts
  - Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
- Wilsonart International Adhesives Division
  - 10601 NW Dodgen Loop
  - Temple, TX 76503-6110

#### Safety

**Caution: Inhalation of vapors may irritate respiratory tract. Mildly irritating to eyes upon contact. Prolonged exposure may irritate sensitive skin.**

**HMIS Rating: Health 1, Flammability 0, Reactivity 0**

**24 hr. Chemtrec emergency number: 1-800-424-9300 (US); 703-527-3887 (International)**

**California Proposition 65 Status:** This product contains the following chemicals considered by the State of California Safe Drinking Water and Toxic Enforcement Act of 1986 as causing cancer or reproductive toxicity and for which warnings are now required: Traces of acetaldehyde and formaldehyde

