

Wilsonart® WA 3000

Polyvinyl Acetate Adhesive for Postforming

Applications

- Glue spreader or spray application
- Glue spreader / pinch roller
- Glue spreader / hot press
- Glue spreader / cold press
- Suitable for postforming
- 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
- Liner grade laminate to plywood

General Description

- An emulsion of water and polyvinyl acetate suitable for bonding decorative laminate to wood products

Availability

- 330 gallon totes (disposable / non-returnable)
- 275 gallon totes (disposable / non-returnable)
- 55 gallon drums
- 5-gallon pails

Physical Properties

- Color: Pink
- Viscosity: 2850 cps (typical)
- Density: 9.0 pounds/gallon
- Solids Content: 58% ± 2%
- 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)

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.

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 spray or glue spreader.
- Ensure substrates and adhesive are at or above 65°F.
- **Open time is a brief 5 minutes**

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 and uniformly with 7-8 wet grams/ft² covering 100% of each surface. Coat each perimeter slightly heavier. 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. **Protect components against pulling, knocking, or stress for one (1) hour.** Bond will usually reach full strength in 24 hours.

Flow Through Postforming Instructions:

- Coat both deck surfaces evenly and uniformly 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 minimum 110°F.
- Prior to beginning the postforming operation, recoat each edge to be formed with additional adhesive. 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 spreader manufacturer's recommendations and apply 6-8 wet mils to one surface using a dual durometer roller (Black Bros. A2158, 16 x ½" pattern).
- Assemble and hot press immediately following exit from the spreader **for 1-2 minutes under 30-40 psi and 180° - 200°**
- Allow the panel to cool for 2 – 5 minutes and proceed with fabrication.

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

DeVilbiss: Gun: JGA 510, MSA 510; Fluid Tip: JGA 4040; Air Cap: MD 4039, 64HD; Needle: D type

Cleanup

- ALWAYS CLEAN BEFORE ADHESIVE DRIES. Clean with a water-wet rag while the adhesive is wet.
- Use ammoniated cleaners with vigorous scrubbing to remove dry adhesive.
- Washwater is RCRA non-hazardous. Dispose of in accordance with local regulations.

Primary Contents

- Vinyl acetate homopolymer (CAS 9003207)
- Water (CAS 7732185)
- NJTSRN #9500001 and #9500002

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 (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

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

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