

### Description

A post-formable vinyl acetate adhesive designed for immediate bonding of HPL to particleboard, plywood, MDF and wood. Product can be roll coated or sprayed and processed by hot bonding, hot laminating, hot pressing, dead stacking and pinch rolling and stacking.

### Benefits

- Non-flammable.
- Solvent free.
- Fast setting.
- Excellent mileage.
- Provides good uniform coverage in hand and automatic spray applications.
- Excellent for high speed post-forming applications.
- Excellent bond adhesion to a variety of substrates including but not limited to DHPL, particleboard and plywood.

### Specifications

- **Solids Content:** 58.0% +/- 2.0%
- **Viscosity:** 2400 cps +/- 400 cps
- **Weight/Gal:** 9.08 lbs +/- 0.2 lbs
- **pH:** 5.0
- **Coverage/Gal:** 265 ft<sup>2</sup> completed bond @ 6 wet mils
- **Recommended Deposition:** 6 – 7 wet mils
- **Shelf Life:** 1 year
- **Color:** Green or Natural
- **Packaging:** Totes, drums and pails
- **Freeze/Thaw Stability:** Not stable, protect from freezing

### Handling & Storage

- Keep adhesive container closed tightly when not in use.
- Containers should be stored on pallets and away from outside walls and off concrete floors.
- Store containers where temperatures will not be less than 50°F (10°C) and will not exceed 90°F (32°C).
- Product should not be stored in direct sunlight.
- Product should not be used after freezing.
- Thinning the adhesive is not recommended.
- Consult the Material Safety Data Sheet prior to use.

### Clean Up

Use water when the adhesive is in the wet state and solvent when the adhesive is dry.

### Disposal

Dry adhesive residue is usually not considered to be hazardous waste. Do not flush or pour wet adhesive into the sewer system without authorization from local authorities.

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## Application Guidelines

### Post-Forming

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. The adhesive should be applied at a coating weight of 4.5 dry grams per sq. ft. or 3 mils on both the core and the HPL by spray application or roll coating, with 100% coverage on the post-form radius and edges. The approximate atomization pressure at the gun should be 40 to 60 psi and the approximate fluid pressure should be 25 to 30 psi.
3. The HPL and core are to be dried by processing through a drying oven. The adhesive should appear to be approximately 50% clear and 50% opaque when exiting the drying oven. The post-form radius and edges should be completely dry or clear.
4. The HPL and core should be indexed and pinch rolled with a temperature of each between 110°F – 120°F. Failure to pinch roll at the recommended temperatures may result in spotty or no bond.
5. The edges of the core to be post-formed should not have any wet spots.
6. The top can now be post-formed through any commercially available flow through post-former.

### Panel Assembly By Roll Coating

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive film thickness should be set to a depth of 6 to 8 wet mils. With this application, the adhesive may be applied to one substrate.
3. Index the HPL to the particleboard or plywood core as the substrates exits the roll coater.
4. At this point, the panel can be:
  - a: dead stacked
  - b: pinch rolled and stacked for 30 minutes before processing
  - c: processed through a pinch roll/hot laminating system, allowing immediate processing after the panel has cooled
  - d: hot pressed for a period of 1 - 2 minutes at approximately 180°F – 200°F, allowing immediate processing after the panel has cooled

## Recommended Automatic Spray Equipment

	<b>Binks</b>	<b>DeVilbiss</b>
<b>Spray Gun</b>	61, 95A, 610	AGX
<b>Fluid Tip</b>	66SS, 67SS, 68SS	E, D, AC
<b>Fluid Needle</b>	765, 767, 768	E, D, AC
<b>Air Cap</b>	66SD-3, 67PB, 68PB	770, 64HD, 62HD

**Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be nylon lined or PVC. This material can be pumped with a double diaphragm pump or a piston pump.**