

1. **Manufacturer**

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2. **Product Overview**

General Description

- Formulated specifically for HPL use on PVC panel substrates
- High bond strength for HPL to additional non-porous, hard-to-bond materials including melamine (TFL), vinyl, and acrylic
- Versatile, all-weather, fast drying, easy application by hand or automated equipment

Availability

1 gallon, 5 gallon, 55 gallon

Storage/Shelf Life

- Rotate stock and close container when not in use.
- Store off of the floor in a cool, well-ventilated area and away from exterior walls.
- Shelf life expires 1 year from manufacture date.

Shipping Information

Ships domestic ground: Adhesives, 3, UN 1133, PG II I

3. **Technical Data**

Physical Properties

| | |
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| Color | Natural |
| Viscosity | 150 cps (typical) |
| Density | 6.6 lbs/gallon |
| Solids Content | 18.0% + 1.0% |
| VOC/liter of material¹ | 417 g/Liter |
| VHAP Content | 0.70 lbs./lbs. solid |
| Coverage (Spray) | 136 bonded sq.ft./gal.@ 2.0 dry grams/sq.ft. |
| Flashpoint | -15 °C/5 °F(PMCC) |
| Open Time | ~60 min. |
| Dry Time | 3 – 5 min. |

Primary Contents

Toluene(CAS 108883), Acetone (CAS 67641), Light hydrotreated distillate (CAS 68410979), Polychloroprene (CAS 9010984), Resin (CAS 26022004)

4. General Use Instructions

Coverage Instructions

Apply a minimum of 2.0 dry grams/sq. ft. on both surfaces

Recommended Tools and Equipment

CA Technology: Hand Gun; Panther; Fluid Tip 1.5; Air Cap: 2266-3T

Binks: Hand Gun: 95, 7B/C, 62, 69, 2001SS, or 2001; Auto Gun: M95 Auto, M61, M610;
Fluid Tip: 63BSS (Hand or Auto Gun); Air Cap: 66SDJG (Hand or Auto Gun)

DeVilbiss: Hand Gun: JGA 510 or MSA 510; Auto Gun: AGX 550; Fluid Tip: FF (Hand or
Auto Gun); Air Cap: 797 (Hand or Auto Gun)

Graco: Gun: P700, P800, P900; Fluid Tip: 03; Air Cap: 03

General: Fluid Pressure: 10-15 psi; Pump Pressure: 30-50 psi; Air Source: Continuous
100 psi at 20 CFM; Fluid Line: Minimum 3/8" ID*

*This line diameter is critical due to thickness of product.

DO NOT USE THIS PRODUCT IF YOU HAVE NOT READ, OR DO NOT UNDERSTAND THE
WARNINGS, SAFETY MEASURES, AND FIRST AID INSTRUCTIONS PRINTED ON THE CONTAINER
OR LABEL.

- For best results, do not apply the adhesive at temperatures below 65-degrees Fahrenheit.
- Ensure spray system oil and water traps are functioning, and are a minimum of 25-feet in distance from the compressor.
- Allow substrates to acclimate to room temperature for 48 hours before bonding.
- Assemble glued parts at or above 65-degrees Fahrenheit, and ensure each surface is clean and dry.
- Apply adhesive uniformly to both surfaces in a smooth, pebbled pattern, and cover each surface a minimum of 80%. Cover edges 100%. Some porous surfaces may require 2 coats.
- Allow approximately 3 to 5 minutes to dry after application and before bonding. When ready to bond, surface will be tacky, but should not transfer or "leg" to a firmly pressed fingertip. If parts do not stick immediately, they are over-dry and can be reactivated by applying a light coat of fresh adhesive on both parts. Open time is approximately 30 minutes.
- Apply uniform downward pressure (30-40 psi minimum) over the entire bonded surface by mechanical pinch roller (recommended,) or by using a 3" wide rubber J-Roller. Use of a wooden block or other hand rollers is not recommended.
- Immediate trimming, routing, or finishing is possible.
- DO NOT THIN THIS PRODUCT.

Usage Tips and Troubleshooting

- Moisture from condensation must be dry prior to bonding.
- A dull appearance is a symptom of under-applying adhesive.
- A shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time.

Clean-Up and Disposal

- Clean equipment with Wilsonart® WA 110 Solvent, and finished assembly with Wilsonart WA 121 Cleaner or Wilsonart WA 131 Cleaner.

Applications to Avoid

- Copper or copper alloy substrates
- Use of copper-containing application systems or components
- Surfaces with dirt, grease, or excessive moisture
- Vinyl surfaces containing plasticizers that may attack the bond (conduct pre-testing if in doubt)
- Dispose of waste in accordance with regulations.

Precautionary Information

Refer to product label and Safety Data Sheet for health and safety information before using this product.

5. Warranty**No Warranty**

WILSONART MAKES NO WARRANTIES, EXPRESS OR IMPLIED. NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR 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 other damages arising from the purchase or use of the product. Wilsonart’s liability will in no event exceed the purchase price of the product.

6. Technical Services

Customer Service: 1-800-433-3222 or Adhesives@Wilsonart.com. Visit [Wilsonart Adhesives](#) online for more information.

Specification Form:

Adhesive shall be Wilsonart® PVC Panel Premium Contact Adhesive, produced by Wilsonart LLC, Temple, Texas 76503-6110

Wilsonart® PVC Panel Premium Contact Adhesive

Technical Data

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