

# WA 10

## Polyvinyl Acetate Wood Glue for Assembly and Cold Pressing

### Applications

- Joint Assembly
- Cold Press Laminating
- 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 surfaces
- Polyester surfaces
- Painted surfaces

### General Description

- An emulsion of water and vinyl 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: White
- Viscosity: 5600 cps (typical)
- Density: 9.1 lbs/gal
- Solids Content: 45% ± 2%
- pH: 4 - 5
- VOC Content: < 20 grams/liter
- VHAP Content: <0.032 lbs./lbs. solids
- Coverage ~229 sq. ft./gallon
- Chalking Temperature: 50°F
- Use Temperature: 70° – 85°F

### Performance Properties

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

Overnight Cure Temp.	Strength	% Wood Failure
Room Temp	3550 psi	77%
150 F	1600 psi	15%

- Speed of Set (torsion test using hard maple and tangential face)

Time from Clamping to Rupture	Strength Development
3 minutes	170 inch pounds
5 minutes	280 inch pounds

### Storage/Shelf Life

- *Do not allow product to freeze*
- Close container when not in use
- Store off the floor (which acts as heat sink)
- Rotate stock
- Warranty expires 1 year from manufacture date
- Agitation may be required if product thickens

### Safety

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

### General Application Instructions

- May be applied by squeeze bottle or glue spreader
- Surfaces must be clean and dry

### Wood and Pottery

- Spread glue evenly and clamp for at least 30 minutes or until the moisture in the bond dissipates.
- Bond reaches full strength in 24 hours

### Paper and Cloth

- Spread glue 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

### High Pressure Decorative Laminate

- Ensure laminate and substrate have acclimated to the same temperature before bonding

### Cold Press Laminating

- Apply the adhesive with a glue spreader adjusted to deposit 6-8 wet mils.
- Consult the spreader manufacturer for their recommended roller groove configuration. For Black Bros. equipment, use #A2158 (16 x ½" pattern)
- Keep the adhesive application area and the substrates at 70°F or above in order to avoid longer press and curing times.
- Use the following recommendations for temperatures between 70°-85°F and 45% RH:
  - Apply adhesive at 6-8 mils wet
  - 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 glue is wet. Removal of dried adhesive is very difficult
- Use ammoniated cleansers with vigorous scrubbing to remove dry adhesive
- Washwater is RCRA non-hazardous
- Dispose of in accordance with regulations

### Primary Contents

- Vinyl 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, and when it is applied in accordance with manufacture instructions, it will perform to the user's satisfaction, 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

**California Proposition 65 Status:** This product contains the following chemical considered by the State of California's 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.

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

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