



Wilsonart® WA 20

Yellow PVA Wood Glue for Assembly and Cold Press Applications

General Description

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

Applications

- Joint assembly
- Glue spreader / 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, polyester, and painted surfaces

Availability

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

Physical Properties

- Color: Yellow
- Viscosity: 4750 cps (typical)
- Density: 9.0 lbs / gallon
- Solids Content: 47% ± 2%
- pH: 4 - 5
- VOC Content: < 20 g / L (Meth. 24)
- VHAP Content: < 0.032 lbs / lbs solids
- Coverage: ~ 229 ft² / gal @ 7 wet mils
- Chalking Temp. 50°F
- Use Temperature: 70°F - 85°F

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 and store off the floor in a well ventilated area.
- Rotate stock.
- Warranty expires 1 year from manufacture date.

General Use Instructions

- May be applied by squeeze bottle or glue spreader.
- Ensure substrates and adhesive are above 65°F.
- Best results are achieved between 70°F and 85°F.
- 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

- Follow the glue spreader manufacturer's recommendations.
- Use a dual durometer roller (Black Bros. A2158, 16 x 1/2" pattern).
- Apply 6-8 wet mils with glue spreader.
- Open time is 5 minutes.
- Closed time is 20 minutes.
- Press time is 30 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 hot tap water while adhesive is wet.
- Removal of dried adhesive is very difficult.
- Use diluted ammonia to clean dry adhesive.
- Washwater is RCRA non-hazardous.
- Dispose of in accordance with 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.wilsonartadhesives.com 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

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)

The GREENGUARD INDOOR AIR QUALITY CERTIFIED Mark is a registered certification mark used under license through the GREENGUARD Environmental Institute.

© 2005, 2007 Wilsonart International, Inc.
Rev. 11/07