WILSONART ADHESIVES REFERENCE SHEET





																			Avail	abilit	v				/	Appli	catio	n I	Job	T
	Color	Coverage Rate (Bonded ft²/gal)	% Solids by weight	Open Time (minutes)	Dry Time (minutes)	Viscosity (cps) typical	Density (lbs/gallon)	VOC (less water & exempt solvent) g/L	VOC/liter of material g/L (calculated)	VHAP (lbs VHAP/lbs solids)	Greenguard . Certified	California Compliant	OTC State Compliant Non-flammable	Qualifies for LEED* credit(s)	14.2 oz Aerosol Can	Quart	Gallon	5-Gallon Pail	275-Gallon Tote	330-Gallon Tote	9-lb. Canister	30-lb. Canister	140-lb. Canister	300-lb. Canister	Brush-On	Roll-On	Spray-On	Aerosol	Flat-work	Postforming
Contact Ad	nesives																													
500	Brown	104@3.0 dry grams/ft ²	20.5%±1.0%	~60	10-15	600	6.7	601	448	0.83				Θ			•			•					•	•		\square	•	
600	Natural	111@3.0 dry grams/ft ²	21.0%±1.0%		20-30			671	669	1.25		(9	Θ		•	•	•	,						•	•	П	$\Box I$	•	Π
700A	Near White	14.4 ft ² /can@2.5 dry grams/ft ²	17.9%	~15	1-5	N/A	6.6	N/A	<55%	N/A	12	©	9	Θ	•												•	•	•	
700/701	Red/Natural	20-25 ft ² /lb@2.5 dry grams/ft ²	N/A	~30	3-5	N/A	5.9	490	N/A	0.21		П		Θ			П	\top			•	•	•	•		\Box	•	• 11	•	Π
30/731	Red/Natural	20-27 ft ² /lb@2.5 dry grams/ft ²	N/A	~30	2-5	N/A	7.9	<40	N/A	0.00	12	Ø	9	Θ								27 Њ	128 lb	270 lb			•	•	•	1
′40A	Near White	14.4 ft ² /can@2.5 dry grams/ft ²	17.9%	~15	1-5	N/A	6.6	N/A	<55%	N/A	12	@ (9	Θ	•		\neg	\neg	\top	\top						\Box	•	•	•	Т
40/741	Red/Natural	20-25 ft ² /lb@2.5 dry grams/ft ²	N/A	~30	2-5	N/A	_	489	N/A	0.20				Θ								•	•	•		_	•	•	•	
300/801	Red/Natural	144@2.0 dry grams/ft²	19.0%±1.0%	~30	3-5	90	6.6	596	418	0.66				Θ				•	, 🗆	•					il T		•		•	•
310/811	Red/Natural	163@2.0 dry grams/ft ²	21.0%±0.5%	~30	3-5	160		534	283	0.08				0			-		_	•						_	•		$\overline{}$	•
344	Red	143@2.0 dry grams/ft ²	19.0%±1.0%	~30	3-5	100	6.6	575	372	0.39				Θ				•	,	•						\Box	•		•	•
860/861	Red/Natural	136@2.0 dry grams/ft ²	18.0%±1.0%	~30	3-5	80	6.6	603	419	0.70				Θ						•							•		•	•
50/951	Red/Natural	131@2.0 dry grams/ft ²	17.5%±0.5%	~60	3-5	150	6.6	606	435	0.75				Θ			-	•	•	•					il 🗆		•		•	
81	Natural	136@2.0 dry grams/ft ²	18.0%±1.0%	~60	3-5	150		602	417	0.70				Θ						•							•		•	
700/1701	Red/Natural	254@2.5 dry grams/ft² (spray)	36.0%±1.0%	~40	3-5	760	7.7	8**	3**	0.00	12	(9	Θ			-	•	•						•	•	•	$\Box I'$	•	
730/1731		230@3.0 dry grams/ft ²	36.0%±1.0%	~30	3-5	1400	8.4	78	31	0.03	12	@ (9	Θ.			•								•	•	•		•	
H ₂ O		357@3.0 dry grams/ft ²	52.0%±2.0%	~60	20-30	N/A	9.1	<0.1	N/A	<0.035	10	(CA) (6	9 (6)	Θ				•								•	•		•	•

Dry Time - The time that it takes a contact adhesive to dry before both laminate and substrate are ready to bond.

Open time is the window of time that begins when an adhesive is dry enough to bond and ends when the adhesive is too dry to bond. Temperature and humidity alter open time and dry time.

Contact your Wilsonart Adhesives Representative for more information

**TBAC IS RECOGNIZED IN 40 C.F.R. 51.100(s) AND BY THE EPA AS A VOC EXEMPT COMPOUND. ALASKA, CALIFORNIA, KANSAS, WYOMING AND WASHINGTON D.C. HAVE NOT FORMALLY RECOGNIZED THIS EXEMPTION. CONTACT YOUR LOCAL REGULATORY AGENCY TO PROVIDE CLARIFICATION ON THE EXEMPTION STATUS.

Wilsonart LLC 10601 NW HK Dodgen Loop Temple, Texas 76504 1.800.433.3222 Email: adhesives@wilsonart.com www.wilsonartadhesives.com ©2013 Wilsonart LLC Revised 05/2015

WILSONART ADHESIVES REFERENCE SHEET

PVA & SPECIALTY ADHESIVES



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	Color	Coverage Rate (Bonded ft²/gal)	% Solids by weight	Open Time (minutes)	Closed Time (minutes)	Press Time (minutes @ 40-50 psi)	Viscosity (cps) typical	Density (lbs/gallon)	VOC (less water & exempt solvent) g/L	VHAP (lbs VHAP/lbs solids)	Greenguard * Certified	California Compliant	OTC State Compliant	Qualifies for LEED® credit(s)	Type II Water Resistance	Fluorescent Dye Added	Pint	5-Gallon Pail	45-Pound Pails	55-Gallon Drum	200-Pound Drum	275-Gallon Tote	2500-Pound Tote	Brush-On / Squeeze Bottle	Spray & Pinch Roller	Glue Spreader & Pinch Roller	Glue Spreader & Cold Press	Ш	High-Speed Postforming	Joint Assembly	High-Speed Postforming Edge	Metals to Wood
VA Adhes																																
)	White		45%±2%		20	30-60^	5600		<20	< 0.032		@ (9 6	0		•		•		•	4	•		•		4	•	110	4	•	\Box	
	Yellow		47%±2%	5	20	20-60^		9.0	<20	< 0.032		(A) (9 6	0	_	•	_	•	$\overline{}$	•	_	•	\perp	•		_	•	•		•	\sqcup	
)	Yellow		47%±2%			N/A		9.8	<20	< 0.032		0 (9 0	0				•	_	•		•		•		•	•	115	4	•	\square	
00	Pink	~229* bonded ft²/gallon @ 7 wet mils		2-5	N/A	1-2-		9.0	<20	< 0.032		(0)	9 6	\sim	_	ш		•	$\overline{}$	•	_	•	\perp	\vdash	•	•			•	\perp	ш	_
001	Green		58%±2%	5	N/A	1-2°		9.0	<20	< 0.032		© (9 6	0				•	_	•	_	•			•	•	4	115	•		\blacksquare	Д
004	White	~229* bonded ft²/gallon @ 7 wet mils	58%±2%	2-5	N/A	1-2°		9.0	<20	< 0.032		(A)	9 6		-	_		•	_	•	_	•	\perp		•	• •	<u>'</u>	╨	•	\perp		
)34	Blue	~229* bonded ft²/gallon @ 7 wet mils	55%±2%		N/A	1-2"		9.1	<20	<0.020		0 (9 6	0		•				•		•				-	_	₩	+	#	•	
)35	Blue	~229* bonded ft²/gallon @ 7 wet mils		2-5	N/A	1-2-		8.8	<20	< 0.020		(A)	9 6	0	-	•		•		•		•	_			_		╫	+	\perp	•	
100	White		43%±2%	5	30	30-60^		9.4	<20	<0.042		0	9 6	0					•	9			•			-	-	₩	#	-	\blacksquare	H
105	White		45%±2%	5	20	30-60^		9.3	<20	< 0.040		(a)	9 6	_	-	ш				_		_	•	_		\rightarrow	•		4	\perp	ш	
116	White	~229 bonded ft²/gallon @ 7 wet mils	43%±2%		20	30-60^		9.1	<20 <20	<0.043		0 (· 6	0 0						-	_		•				-	₩	#			H
25 31	White White	~229 bonded ft²/gallon @ 7 wet mils	53%±1%	5 3-5	20	30-60^ 2-3=		9.5	<20	<0.032		@) (9 ©		•				•		_		·				-	ᄩ	+			
32	White	~229 bonded ft²/gallon @ 7 wet mils ~229 bonded ft²/gallon @ 7 wet mils	62%±2% 58%±2%		15-20 10-15	2-3°		9.4	<20	<0.042		@ (0						-								١	+	+	\blacksquare	
40	White		45%±2%	5	15-20	30-60^ 2-3 [□]		9.5	<20	< 0.031	10	0 0) @	0									i			•		ᄩ	+			
10	White		63%±2%	5	20	45-60^		8.9	<20	< 0.031	74	a 6	3 8	9					•								-	١	-	+		•
	Off-White	~229 bonded ft²/gallon @ 7 wet mils	57%±1%			N/A		9.0	7	< 0.042		@ () @	0									i					ᄩ				Ĭ
kweld	White	~229 bonded ft²/gallon @ 7 wet mils	49%±1%	5	20	30-60^		9.1	<20	< 0.003	_	0		0							7					٠,		ᄩ	+			
pe II Glue kweld								\vdash	<20		_	9	y 💯	_	•		• •	_		_	+	_		•		•	• •	╨	_	•	\sqcup	_
elamine	Off-White	~229 bonded ft²/gallon @ 7 wet mils	57%±2%	N/A	N/A	N/A	3800	9.0	7	<0.005		@ (9 0	Θ			• •)						•				П				
kweld ite Glue	White	~229 bonded ft²/gallon @ 7 wet mils	45%±2%	5	20	30-60^	5600	9.1	<20	<0.032	12	(A)	9 @	Θ		•	• •	,			T			•			•	TI•	, 📉	•		
kweld	Yellow		47%±2%			N/A		9.8	<20	<0.032	_	@ (· (a)	0			•							•		+		11				
od Glue	White	~229 bonded ft²/gallon @ 7 wet mils ~229 bonded ft²/gallon @ 7 wet mils	49%±1%		20	30-60^			<20	<0.032		0 4	· (f)	_	•	-	_	•		•	٠,							11.	+			A
/pe II 'A M			49%±1% 57%±2%		$\overline{}$	N/A		9.1	<20	< 0.032		9	7 6	0	•	ш	_	-		•	•	_	\perp			—•	•	┰╚	-	-	\square	

*Spray~255 ft²/gal (bonded)

Hot Press Time

^ Cold Press Time

All Wilsonart PVAs are Non-Flammable
*Spray: ~255 ft²/gal (bonded)
□Hot Press Time
^Cold Press Time

Open Time is the window of time that begins when an adhesive is applied to the substrate and ends when the laminate is applied to make an assembly. Temperature and humidity alter open time.

Once the assembly has been made, the user has a window of opportunity (**Closed Time**) for the project to be placed in the press and pressure applied by the press. If the user misses the closed time the adhesive has already formed a skin.

Wilsonart LLC 10601 NW HK Dodgen Loop Temple, Texas 76504 1.800.433.3222 Email: adhesives@wilsonart.com www.wilsonartadhesives.com ©2013 Wilsonart LLC