

Cross Linking PVA Adhesive

Trade Essentials Cross Linking PVA Adhesive is a unique single pack PVA that provides superior bonding properties to normal PVA. It provides excellent bond strength, high heat and humidity resistance.



APPLICATIONS

Cross Linking PVA Adhesive is fast setting, develops high bond strength and heat and humidity resistance, without Catalyst addition, when dried at normal or elevated temperatures.

The properties of Trade Essentials Cross Linking PVA are superior to normal PVA, and conform to BS EN 204 - Exposure Group D3.

Applications for Cross Linking PVA include:

- Edge gluing timber
- Solid timber veneer to core stock
- Finger jointing
- Panel to frame gluing

PROPERTIES

Colour	White liquid, dries clear
Solids	High (approx. 48%)
pH	3.3
Viscosity	Medium (4,500 cps)
Open Assembly Time	5 mins. maximum at 20°C
Closed Assembly Time	10 mins. maximum at 20°C
ASW	945637 (5 litre) 945638 (20 litre)

DIRECTIONS

Cross Linking PVA Adhesive may be applied via brush, roller or squeeze bottle. It is also suitable for use on powered roll glue spreader or air assisted / airless spray equipment.

Cross Linking PVA Adhesive is designed for use with hot press, radio frequency (RF) equipment, or standard cold press setups.

- All surfaces to be bonded must be clean, dry and free from dust, oil, grease etc
- Timber moisture content should be between 8% and 12%
- Ambient and panel temperatures should be above 10°C
- Adhesive should be applied as a thin, even coating to one surface only. Parts should be combined, while the adhesive is wet, using good even pressure (30 to 130 psi is recommended) until the adhesive has set
- Clamp time details are listed in table on page 2
- Excessive adhesive can be removed with a damp cloth while adhesive is still wet
- Not suitable for below waterline applications or for continuous submersion

ADHESIVE CURE TIMES

Hot Press Cure	Typically 60-90 secs @ 100°C (depending on coating weight & substrate thickness)
Rf Cure	A LOW power setting is preferred to produce workable amperage without arcing. A minimal change after the initial amperage drop-off will indicate adhesive is sufficiently set.
Cold Press	20-30 minutes @ 23°C

COVERAGE

The rate of usage of Trade Essentials Cross Linking PVA Adhesive is governed by the type of application, substrate and ambient conditions.

Coverage shall fall in the range of 75 to 150 grams per square metre (6 to 14m² per litre), for most applications.

CLAMP TIMES (MINIMUM)

Temperature	Low Density Timbers	High Density Timbers
20°C	60 minutes	120 minutes
30°C	30 minutes	60 minutes

When the minimum clamp time is used, the freshly bonded panels should be stacked for a minimum of 24 hours before machining.

For lamination of High Pressure Laminates to particleboard or MDF board using a hot press, the following settings have been found to be generally suitable:

Adhesive Coating Weight: 70-80gsm	Press time: 2 mins
Temperature: 80°C	Pressure: 100-150psi

STORAGE

Keep containers sealed and away from direct sunlight. Recommended storage temperature is 5-30°C. Cross Linking PVA has a shelf life of 6 months. Material Safety Data Sheets are available on request.

LIMITATIONS

Cross Linking PVA should not be used when timber or ambient temperatures are below 10°C. Cross Linking PVA is not suitable for load bearing applications.

Adhesive Selection Guide

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Safety & Usage Recommendations for PVA Adhesives

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