



CHOICE BRANDS
ADHESIVES
www.choicebrands.com

PRODUCT DATA SHEET

CHOICE BRANDS ADHESIVES, 666 REDNA TERRACE #500, CINCINNATI, OH 45215 513-772-1234

Product: CBA-502 Crosslinking Hot Press Adhesive

Description: Vinyl Acetate Emulsion (PVA)

Typical Physical Properties:

Solids: 48% +/- 2%	Open Time: 4 - 8 minutes
Viscosity: 5000 cps +/- 1500 cps	Closed Time: Approx 20 minutes
Coverage Rate: 6 – 8 wet mls	Cold Press Time: 40 – 60 minutes
Color: White	Clean Up: Warm soapy water
Shelf Life: One year in unopened container	Coverage: 225 sq ft/gal
Chalk Temperature: 54°F	Packaging: 5, 55, 275 gal containers

OTC and SCAQMD compliant

Certified Leed NC and CI Credit 4.4: *Laminating Adhesives shall contain no added urea formaldehyde resins*

SUGGESTED USE:

- Crosslinkable polyvinyl acetate emulsion that is pre-catalyzed and formulated to be ready for use.
- Can be used in a cold or hot press and can be used in RF gluing applications
- Used in an automated glue spreader or manually applied.
- Excellent machinability and stability

APPLICATION (Cold and Hot Press)

- Substrates must be acclimated to at least 65 deg F – ideally 70 – 85 deg for best results
- Make sure substrates are clean, free of dust or contaminants.
- Use dual durometer roller (Black Bros. #2158 16 x 1/2" pattern)
- Apply 6 – 8 wet mls with glue spreader or roller to board
- Open time is about 4 – 8 minutes
- Closed time is 15 – 20 minutes
- Cold Press is 40 – 60 minutes at 40 – 50 psi
- Wait till board is cool to do any machining in hot press applications

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HOT LAMINATION MACHINERY (EVANS #4260 PANEL EXPRESS)

- Apply 6 – 8 mls to single surface
- Oven Dwell time of 1 minute with exit temperature of 150 – 160 deg F
- Each sequential roller to be set at 50 psi
- Allow assembly to cool completely prior to machining

APPLICATIONS TO AVOID

- Tempered Hardboard products
- Fire retardant treated board materials
- Boards treated to be moisture resistant
- Low pressure melamine surfaces
- Metallic, polyester or painter surfaces

STORAGE CONDITIONS:

- **DO NOT ALLOW PRODUCT TO FREEZE**
- **DO NOT STORE BELOW 55 DEG F**
- Keep container lid closed when not in use
- Store product off of concrete floors
- Rotate inventory

CLEAN UP / DISPOSAL

- Clean up with hot soapy water while adhesive is still wet.
- Use mildly ammoniated water to clean up dried material. Clean-up will be difficult
- Rinse water and water used for clean up is RCRA non hazardous
- Dispose of waste water appropriately

PRECAUTIONS:

Please refer to the Material Safety Data Sheet for further safety information.

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