



# Custom Work Deserves a Custom Bond

## VENEER

**TYPE:** Polyvinyl Acetate Emulsion

**TECHNICAL DATA:**

Viscosity	Cps	8,000
Solids	%	45-47
Density	Lbs./gallon	9.6
Minimum Use Temperature		35°F
Freeze Thaw Stable	5 cycles	Yes
Storage Life @ 70°F		6+ Months
Color		Tan

**CHARACTERISTICS:** Moderate set speed. Good heat resistance. Low minimum use temperature. Long storage life. Meets ASTM D 4317-86 Type III specification.

**APPLICATIONS:** Excellent adhesive for laminating veneer or high pressure laminates to a given substrate, as well as general assembly gluing where a heavier, filled product is desired.

**DIRECTIONS FOR USE:**

- Moisture content of veneer should be 6 to 8%
- Apply with roller or roll spreader to the core being used
- Spread rates:
  - Veneering 4-7 wet mil (2.5 to 4 lbs per hundred square feet single glue line). Lower spread rates will reduce potential for bleedthrough, as will longer open assembly time. Take care to ensure glue does not dry out or skin over prior to applying veneer.
  - Solid wood 6-9 wet mil (3.5 to 5.5 lbs per hundred square feet single glue line)
  - High-pressure laminate 4-6 wet mil (2.5 to 3.5 lbs per hundred square feet single glue line)
- Assembly time is 5 to 15 minutes depending on temperature, moisture content, species and porosity
- Pressing/Clamping - 30 to 45 minutes at:
  - 35 - 50 PSI for laminate
  - 75 - 200 PSI for veneer
  - 75 - 200 psi for solid wood or edge gluing
- Dead stack overnight before machining

**CLEANUP:** Cleans up easily with warm soapy water while still wet.

**STORAGE:** Cool temperatures - 55° to 80° ideal. Use polyethylene, aluminum or fiberglass containers. Avoid contact with iron.