



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:

<b>Solids:</b>	48% +/- 2%	<b>Open Time:</b>	4 - 8 minutes
<b>Viscosity:</b>	5000 cps +/- 1500 cps	<b>Closed Time:</b>	Approx 20 minutes
<b>Coverage Rate:</b>	6 – 8 wet mls	<b>Cold Press Time:</b>	40 – 60 minutes
<b>Color:</b>	White	<b>Hot Press Time:</b>	2 - 3 minutes at 180 F & 40 – 50psi
<b>Shelf Life:</b>	One year in unopened container	<b>Coverage:</b>	225 sq ft/gal
<b>Chalk Temperature:</b>	54°F	<b>Packaging:</b>	5, 55, 275 gal containers
<b>Clean Up:</b>	Warm soapy water		

**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 ½" 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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