

Code	Description	Size	Colour
23000	Gorilla Crosslinking PVA	250 ml	White
23001	Gorilla Crosslinking PVA	500 ml	White
23002	Gorilla Crosslinking PVA	1 L	White
23003	Gorilla Crosslinking PVA	5 L	White
23004	Gorilla Crosslinking PVA	20 L	White

1. Description

Gorilla Crosslinking PVA is a pre-catalyzed, fast setting emulsion adhesive with an excellent shelf life. The product is ready for use and requires no mixing of catalysts.

2. Characteristics

- Rapid & high strength cure
- Heat and water resistance (D3 rating)
- Dries clear making it ideal for face/edge joinery
- Suitable for bonding MDF
- Strong bond of carpet/fabrics in automotive uses
- Suitable for interior/exterior use

3. Technical Data

Appearance:	White liquid, clear when dries
Viscosity:	Approx 4,500 cps
Solids:	Approx 48%
pH:	Approx 3.3
Specific Gravity:	Approx 1.15

**This varies according to ambient conditions such as temperature, humidity, substrate etc*

4. Applications

- It is recommended for the bonding of most materials such the manufacture of automotive interior components ie
 - Carpets, fabrics, foam and textiles to timber, compressed cardboard, triflex and fibreglass
- It is suitable for finger jointing, edge gluing, veneering, joinery etc.
- Also suitable for lamination and post forming of high pressure laminates to particle board and MDF board

5. Packaging

250ml, 500ml, 1L, 2 L, 5 L, 20 L.

6. Shelf Life

12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +30°C on a wooden pallet and kept from freezing. Keep out of direct sunlight and away from sources of heat.

7. Application Instructions

Surfaces: Carpets, fabrics, foam and textiles to timber, compressed cardboard, triflex and fibreglass, particle board and MDF board.

State of Surface: Clean, dry and free of dust and grease.

Application

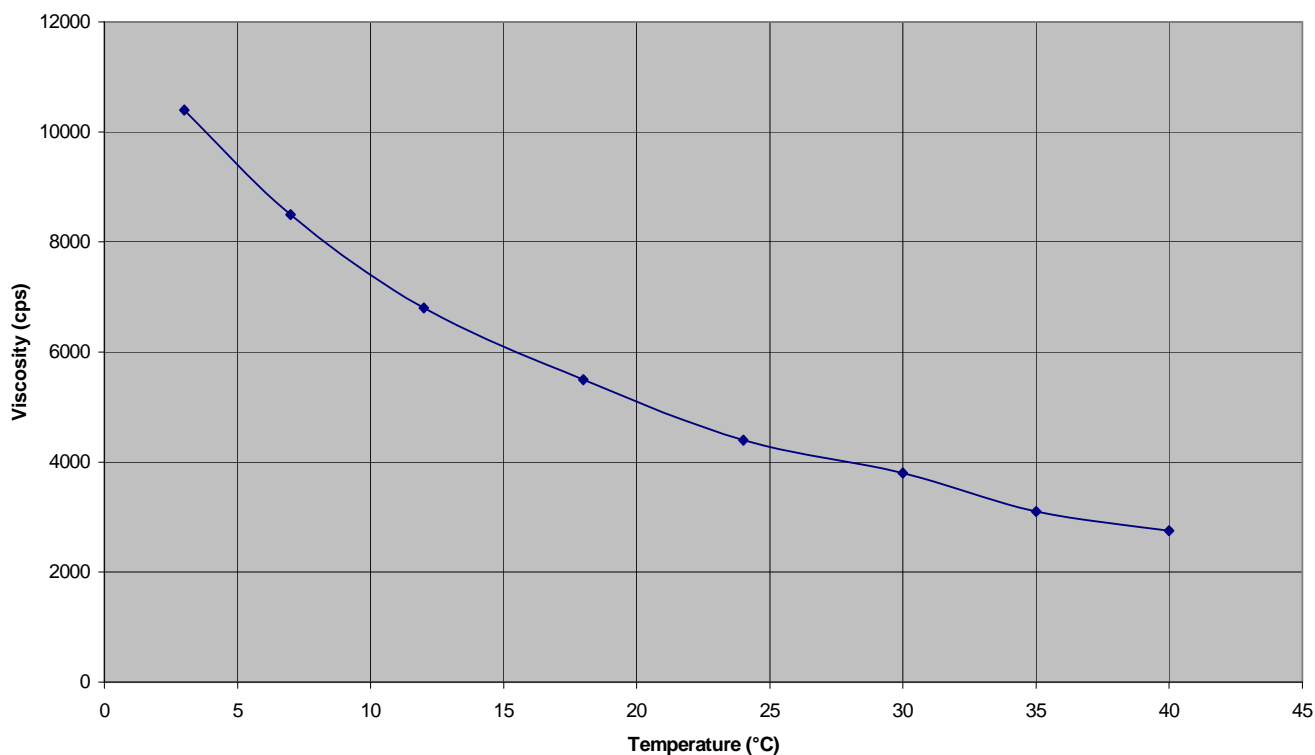
Method: Ensure adhesive is stirred well prior to use. Gorilla Crosslinking PVA may be applied via powered roll glue spreader or air assisted/airless spray equipment, brush hand roller or extrusion and is designed for use with hot press or radio frequency (RF) equipment or standard cold press setups. Timber moisture content should be between 8% and 12% whilst ambient and timber 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 150psi is recommended) until the adhesive has set. See cure requirements below.

Maximum open assembly time: 2 minutes (100gsm adhesive, pinus radiata, 8% MC, 20°C)

Maximum closed assembly time: 2 minutes (100gsm adhesive, pinus radiata, 8% MC, 20°C)

442.3051 Viscosity vs Temperature



Hot Press Cure: Typically 60 - 90 sec @ 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: Minimum press time of 20 - 30 minutes @ 23°C

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

Adhesive coating weight: 70-80gsm

Temperature: 80°C. Press time: 2 minutes, pressure 100-150psi

Cleaning: Equipment can be cleaned up using water while still wet

Repair with: Gorilla Crosslinking PVA

Warning: Gorilla Crosslinking PVA will change in viscosity as the temperature changes, roll coaters and other applicators should be adjusted in order to compensate for these viscosity changes. Higher viscosity can create higher coat weights and vice versa.

8. Health and Safety Recommendation

- Apply the usual industrial hygiene.
- Please refer to MSDS for more detailed information

Remark

The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments.

If any clarification is required, please contact Holdfast Technical Services or email sales@holdfast.co.nz.

Last Updated: 1 July 2016