

Wilsonart® M Melamine Adhesive

Acrylic Adhesive for Bonding Non-Porous to Porous Materials

General Description

- An acrylic adhesive that can be used to bond non-porous materials to porous materials.

Applications

- Bonds non-porous materials including melamine, vinyl, high pressure laminates, PVC edge banding, wood veneer, metal, stone, tile, and acrylics to wood and other porous, composite surfaces.
- Consumer or professional use

Applications to Avoid

- Exterior use or applications where moisture is present

Availability

- 5 gallon pails
- 1 gallon containers
- 1 pint containers

Physical Properties

- Color: White
- Viscosity: 8,300 cps (typical)
- Density: 8.7 pounds./gallon
- Solids Content: 44.0% ± 2.0%
- pH: 9.5 (typical)
- VOC Content: < 5 grams/liter
- Coverage: 230 ft²/gal @ 6-8 wet mils

Storage/Shelf Life

- Do not allow product to freeze
- Close container when not in use
- Store off the floor (which acts as heat sink)
- Rotate stock
- Warranty expires 1 year from manufacture date

General Application Instructions

- Ensure substrate and glue are at or above 45°F.
- Best results are achieved between 70°F and 85°F.
- At least one of the bonding surfaces must be porous. Surfaces to be bonded must be clean and dry. Apply a generous amount of adhesive to the porous surface. Rub the two surfaces together to ensure wetting. Join the two surfaces while the adhesive is still wet (Assembly Time: 20 minutes at 70°F/50% RH) and lightly clamp the assembly to stabilize the bond for 45-60 minutes or until the adhesive film dries. Staples, screws, and/or other fastening devices will create a tighter joint

and may be used in lieu of clamping. Machining is typically possible 24 hours after assembly.

- Clamping pressure guidelines are as follows:
 - HPL 30-60 psi
 - Softwoods 100-150 psi
 - Hardwoods 125-175 psi

Cleanup

- Clean with hot tap water while glue is wet.
- Removal of dried adhesive is very difficult.
- Use denatured alcohol to clean dry adhesive.
- Washwater is RCRA non-hazardous.
- Dispose of in accordance with regulations.

Primary Contents

- Acrylic-styrene polymer (CAS 25987-66-0)
- Water (CAS 7732-18-5)

Limited Warranty

Wilsonart International, Inc., warrants to the user that this product is free of defects for a period of one (1) year from the date of manufacture when it is applied in accordance with the manufacturer's instructions or the manufacturer will replace the container at no cost or additional charge to the user, provided the unused portion of the product is returned to the place of purchase within 15 days of the date of purchase. This warranty does not apply to (I) products that are purchased after the expiration of the manufacturer's recommended shelf life as stated on this technical data sheet, (II) misuse or mishandling of the product, (III) improper storage, or (IV) improper fabrication using this product. **NO OTHER WARRANTIES, EXPRESS OR IMPLIED ARE MADE, INCLUDING MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. UNDER NO CIRCUMSTANCES SHALL THE MANUFACTURER BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE, OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF WILSONART INTERNATIONAL, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATION OF THIS WARRANTY.** This warranty gives you specific legal rights, and you may also have other rights which vary from state to state, therefore, some of the limitations stated above may

not apply to you. It is to your benefit to save your documentation upon purchase of product.

For More Information

- www.wilsonartadhesives.com for:
- Tech Data Sheets
- Material Safety Data Sheets (MSDS)
- Adhesive Use Quick Reference Charts
- Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
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CAUTION: May cause minor skin and eye irritation.