



## Product Data Sheet

FORMICA is a registered trademark of the Formica Corporation  
Manufactured by: Choice Brands Adhesives

666 Redna Terrace, Suite 500  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

### PRODUCT NAME: 7709TG LAMINATING ADHESIVE

**BENEFITS:** Postformable, dead stack, cold or hot press Fast Setting  
Excellent Mileage Extremely low VOC content  
GreenGuard Certified, SCAQMD, OCT and Leed Compliant  
No Urea/ formaldehyde Added

#### TYPICAL TECHNICAL DATA:

Color: Green	Open Time: 2 – 5 minutes
Coverage: 255ft <sup>2</sup>	Set Time: 15 – 20 minutes
Deposition: 6-7 wet mils minimum minimum)	Hot Press Time: 1 – 2 minutes (35 psi)
Solids: 57%	VOC Content: < 1 gram/liter (Method 24)
Viscosity: 2400 cps	Shelf Life: 1 year when stored at Room Temperature
Weight/Gal: 9.07 lbs/gal totes	Packaging: 5 gal pail, 55 gal drum, 275 gal totes

*Qualifies for Leed Points 3.2, 4.1 and 4.4*



#### APPLICATION:

A post-formable vinyl acetate adhesive designed for immediate bonding of Veneer, HPL to particleboard, MDF, plywood and wood. Product can be sprayed or roll coated and processed by dead stacking, nip rolling and stacking, hot laminated and hot pressed. Excellent adhesion to a variety of substrates including, but not limited to veneer, decorative laminates, particleboard, and plywood. Provides good uniform coverage in hand and automatic spray applications

#### POSTFORMING

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. The adhesive should be applied at a coating weight of 4.5 dry grams per sq. ft. or 3 mils on both the core and the HPL by spray application or roll coating, with 100% coverage on the post form radius and edges. The approximate atomization pressure at the gun should be 40 to 60 psi and the approximate fluid pressure should be 25 to 30 psi.
3. The HPL and core are to be dried by processing through a drying oven. The adhesive should appear to be approximately 50% clear and 50% opaque when exiting the drying oven. The post form radius and edges should be completely dry or clear.
4. The HPL and core should be indexed and pinch rolled with a temperature of each between 110OF - 120OF. Failure to pinch roll at the recommended temperatures may result in spotty or no bond.
5. The edges of the core to be post formed should not have any wet spots. The top can now be post formed through any commercially available flow through post former.
3. The HPL and core are to be dried by processing through a drying oven. The adhesive should appear to be approximately 50% clear and 50% opaque when exiting the drying oven. The post form radius and edges should be completely dry or clear.
4. The HPL and core should be indexed and pinch rolled with a temperature of each between 110OF - 120OF. Failure to pinch roll at the recommended temperatures may result in spotty or no bond.

NOTICE TO PURCHASER: The information, data and suggestions for use of the materials given here are based on our best experience and knowledge, but we do not guarantee the results to be obtained in customer's processes. The products discussed are sold without any warranty regarding merchantability or fitness for a particular purpose or any other warranty express or implied. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Sellers and manufacturers only obligation shall be to replace such quantity of the product proved to be defective. Since the manufacturer of the product described in this technical data sheet has no means of controlling the final use of the product by the consumer or user, it is the responsibility of the immediate purchaser and any intermediate seller or sellers to inform the user of the purposes for which the product may be fit and suitable, and of the properties of the product, including the precautionary measures which must be taken in order to insure the safety of the user and of other third persons and property.



# Product Data Sheet

FORMICA is a registered trademark of the Formica Corporation  
Manufactured by: Choice Brands Adhesives

666 Redna Terrace, Suite 500  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

5. The edges of the core to be post formed should not have any wet spots. The top can now be post formed through any commercially available flow through post former.

### PANEL ASSEMBLY BY ROLL COATING

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive film thickness should be set to a depth of 6 to 8 wet mils. With this application, the adhesive may be applied to one substrate.
3. Index the HPL to the particleboard or plywood core as the substrates exits the roll coater.
4. At this point, the panel can be:
  - a) dead stacked
  - b) pinch rolled and stacked for 30 minutes before processing
  - c) processed through a pinch roll/hot laminating system, allowing immediate processing after the panel has cooled
  - d) hot pressed for a period of 1 - 2 minutes at approximately 180° F -200° F, allowing immediate processing after the panel has cooled

### RECOMMENDED AUTOMATIC SPRAY EQUIPMENT

Equipment	Binks		DeVilbiss
1-2 traversing heads	M95, M61	<b>Spray Gun</b>	JGA510, MSA510
3 heads, edge and underwrap	68SS	<b>Spray Tip</b>	JGA4040
1-2 traversing heads	66SS		
3 traversing heads	68BP	<b>Air Cap</b>	MD4039, 64HD
Edge and Underwrap	66PJ		
	66R , 66PJ		
	668	<b>Needle</b>	D type

Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be nylon lined or PVC. This material can be pumped with a double diaphragm pump or a piston pump.

### General Use Instructions

- Ensure substrates and adhesive are above 65°F
- Surfaces should be free of dirt and any contaminants.

### Applications to Avoid

- Fire retardant treated board
- Moisture resistant board
- Polyester, metallic and painted surfaces
- Tempered hardboard products

### HANDLING:

**CLEAN UP:** Use warm soapy water when the adhesive is wet and solvent or diluted ammonia when the adhesive is dry.

**DISPOSAL:** Dry adhesive residue is usually not considered to be hazardous waste. Do not flush or pour wet adhesive into the sewer adhesive without authorization from local authorities. Thinning the adhesive is not recommended.

### STORAGE CONDITIONS:

Keep Adhesive container closed tightly when not in use. Containers should be stored on pallets away from outside walls and off concrete floors. Closed, lined containers where temperature will not be less than 50OF and should not exceed 90OF. Product should not be stored in direct sunlight. Product should not be used after freezing.

### PRECAUTIONS:

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

NOTICE TO PURCHASER: The information, data and suggestions for use of the materials given here are based on our best experience and knowledge, but we do not guarantee the results to be obtained in customer's processes. The products discussed are sold without any warranty regarding merchantability or fitness for a particular purpose or any other warranty express or implied. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Sellers and manufacturers only obligation shall be to replace such quantity of the product proved to be defective. Since the manufacturer of the product described in this technical data sheet has no means of controlling the final use of the product by the consumer or user, it is the responsibility of the immediate purchaser and any intermediate seller or sellers to inform the user of the purposes for which the product may be fit and suitable, and of the properties of the product, including the precautionary measures which must be taken in order to insure the safety of the user and of other third persons and property.