

Technical Datasheet

Bostik, Inc.



ISOSET™ WD3-A322 Structural EPI Adhesive Resin

Description ISOSET WD3-A322 resin is a crosslinkable aqueous emulsion polymer. This resin is used in conjunction with ISOSET CX-47 crosslinker. The system is useful in a wide variety of applications. It has been tested successfully on laminations of wood to wood and wood to plastic and foams. It is suitable for cold, RF and hot pressing operations. This resin formulation provides good suitability on highly porous substrates such as mineral core used in fire doors.

Typical Resin Properties

Appearance	White, Opaque Fluid
Solids (%)	43.0 – 46.0
Viscosity, Brookfield, cps, Spindle No. 4 @ 10 rpm, 25°C (77°F)	4,500 – 6,500
Specific Gravity, 25°C (77°F)	1.15 – 1.25
pH (as is), 25°C (77°F)	6.0 – 7.0
Flash Point, °F (Seta Flash)	>200
Pounds Per Gallon @ 25°C (77°F)	10.0
Freeze-Thaw Stability	None

Physical properties are values, based on material tested in our laboratories, but are subject to a standard deviation from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot.

Mixing Instructions ISOSET CX-47 crosslinker (hardener) should be used in the range of 10 to 20 parts per 100 parts emulsion by weight depending on the degree of durability required. High agitation rates reduce the working life of the adhesive. Slow crosslinker addition to the emulsion is desired. Mixed ISOSET adhesive systems should not be placed into closed containers because carbon dioxide is generated causing pressure build-up.

Working Life Working life will vary with ambient conditions and the amount of crosslinker used. Once mixed with the crosslinker the adhesive should be used within 30 minutes. Adding freshly mixed adhesive to the roll coater will maintain a relatively constant viscosity through the work day.



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Handling	ISOSET WD3-A322 adhesive contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided, and appropriate protective equipment and clothing should be worn. For important health, safety and handling information, consult Bostik's Safety Data Sheet before using this product. Our Safety Data Sheets should be read and understood by all of your supervisory personnel and employees before using Bostik products in your facility. For best results and assembly time information, refer to the Laminating Guide.
Clean Up	When ISOSET adhesive is liquid it can be cleaned up easily with water. Warm water and the use of detergent enhances clean-up.
Packaging	55 gallon (208 liters) fiber drums, 5 gallon (19 liters) pails, 330 gallon disposable tote bins, and 45,000 lb tankwagons.
Recommended Storage	Store at temperatures between 45 °F and 75 °F. When stored under these conditions, shelf life is 3 months from date of receipt for Domestic customers and 2 months from date of receipt for overseas customers. Storing at higher temperatures decreases shelf life. Keep away from heat and direct sunlight. Keep containers covered to prevent contamination.
DOT Label Requirements	None
Notice	<p>All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Bostik, Inc. assumes legal responsibility. Any warranties, including warranties of merchantability, fitness for use or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.</p> <p>Since the user's product formulations, specific use applications and conditions of use are beyond the control of Bostik, Bostik makes no warranty or representation regarding the results which may be obtained by the user. It shall be the sole responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application.</p>



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Bostik requests that the user reads, understands and complies with the information contained herein and the current Safety Data Sheet.

More Information

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