

# TITEBOND<sup>®</sup> MELAMINE GLUE

## PHYSICAL PROPERTIES (TYPICAL)

**Type** Specialized vinyl acetate emulsion  
**State** Liquid  
**Color** White  
**Dried film** Clear  
**Solids** 57%  
**Viscosity** 12,000 cps  
**pH** 4.0

**Calculated VOC:** 3.0 g/L  
**Weight/gallon** 8.9 lbs.  
**Chalk temperature\*** Approx. 40°F.  
**Flashpoint** >200°F.  
**Freeze/thaw stability** Unstable  
**Storage life** 12 months in tightly closed containers at 75°F.

\*Chalk temperature indicates the lowest recommended temperature at which the glue, air and materials can be during application, to assure a good bond.

## APPLICATION GUIDELINES

**Application temperature** Above 40°F.  
**Open assembly time** 5 minutes (70°F./50%RH)  
**Total assembly time** 10-15 minutes (70°F./50%RH)  
**Minimum required spread** Approximately 6 mils or 250 square feet per gallon  
**Required clamping pressure** Enough to bring joints tightly together (generally, 30-80 psi for HPL, 100-150 psi for softwoods, 125-175 psi for medium woods and 175-250 psi for hardwoods)  
**Methods of application** Easily spread with a roller spreader or brush, or may be transferred to plastic bottles for finer gluing applications.  
**Cleanup** Damp cloth while glue is wet. Scrape off and sand dried excess.

## BOND STRENGTH

Substrates	Strength psi	% Substrate Failure
Melamine/Melamine Lap Shears	329	100
Melamine/Particle Board	339	100

## PRODUCT FEATURES

- **Bonds melamine, vinyl coated products, and HPL to porous materials**
- **Thicker formulation – fewer runs and drips**
- **Fast setting – excellent strength**
- **Dries clear**
- **Long open time**
- **Fast initial tack**

## LIMITATIONS

Titebond Melamine Glue is not intended for exterior use or where moisture is likely. Not for structural or load bearing applications. Do not use when temperature, glue or materials are below 40°F. If product has been frozen (gel-like appearance), it cannot be used. Read MSDS before use. **KEEP FROM FREEZING. KEEP OUT OF REACH OF CHILDREN.**

## ORDERING INFORMATION

Cat. No.	Size	Units per Package	Weight	Packages per Pallet
4014	16 oz. Bottle	12	15	100
4016	Gallon Bottle	2	19	63
4017	5 Gallon Plastic Pail	1	49	24
4018	55 Gallon Drum	1	523	4

**Important Notice:** Our recommendations, if any, for the use of this product are based on tests believed to be reliable. Since the use of this product is beyond the control of the manufacturer, no guarantee or warranty, expressed or implied, is made as to such use or effects incidental to such use, handling or possession or the results to be obtained, whether in accordance with the directions or claimed so to be. The manufacturer expressly disclaims responsibility therefore. Furthermore, nothing contained herein shall be construed as a recommendation to use any product in conflict with existing laws and/or patents covering any material or use.

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