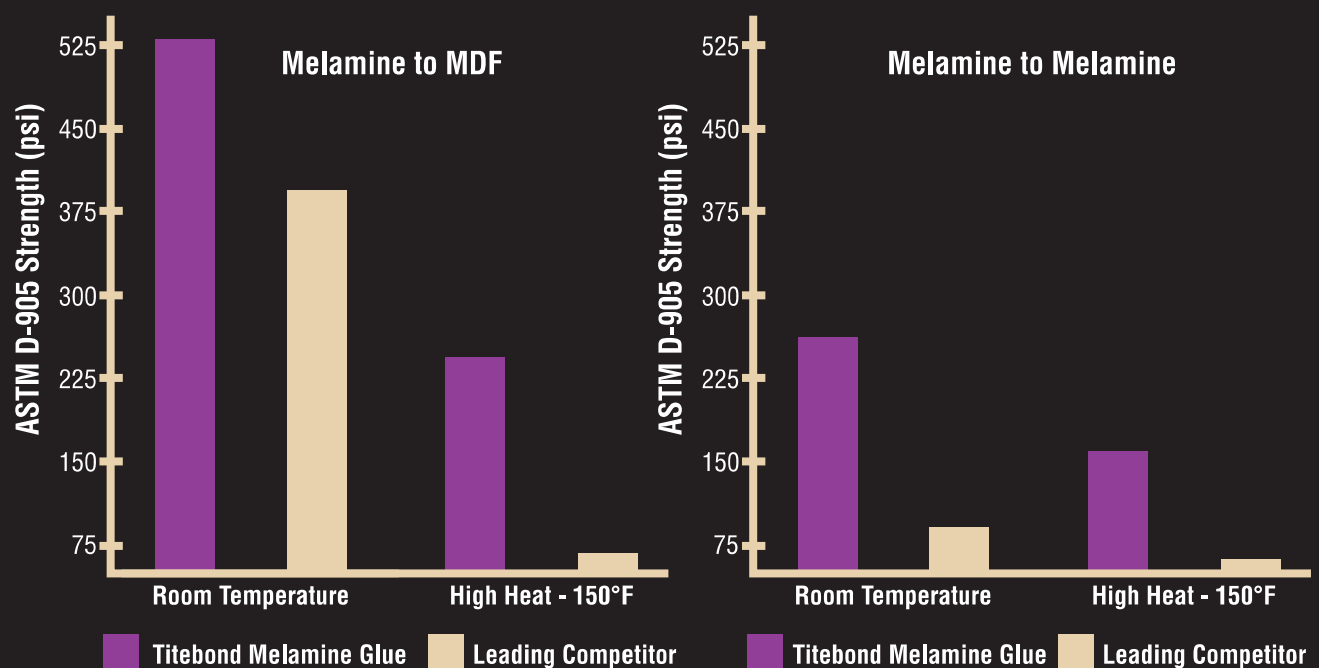


# 3 Times Stronger

## Now Do We Have Your Attention?

As the leader in bonding wood and wood-based substrates for over 70 years, our strong tradition has been built on superior product quality, technical support and total value. We are proud to uphold that tradition with the introduction of our NEW! Titebond® Melamine Glue. With up to 3 times the strength over the leading competitor, it is the ideal choice for cabinet shop operations.



- Strong initial tack
- Superior heat-resistance
- Dries clear – Low odor
- Water cleanup – Nonflammable
- Single-source supplier



**1-800-347-GLUE (4583) • [www.titebond.com](http://www.titebond.com)**

# TITEBOND® MELAMINE GLUE

## PHYSICAL PROPERTIES (TYPICAL)

**Type** Specialized Vinyl Acetate Emulsion  
**State** Liquid  
**Color** White  
**Dried film** Clear  
**Solids** 59%  
**Viscosity** 12,000 cps  
**pH** 3.5-4.5

**Calculated VOC** (less water): 2.32 g/L  
**Weight/gallon** 9.1 lbs.  
**Chalk temperature\*** Approx. 35°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.  
**Assembly time after glue application** 10-15 minutes (70°F./50%RH)  
**Minimum required spread** 6-7 mils (typical)  
**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 dried excess.

## PRODUCT FEATURES

- Bonds melamine and vinyl coated products to porous materials
- Thicker formulation for fewer runs and drips
- Superior heat-resistance
- Dries clear – Low odor
- Water cleanup – Nonflammable

## LIMITATIONS

Titebond Melamine Glue is not intended for exterior use or where moisture is likely. For exterior applications, use Titebond III Ultimate Wood Glue or Titebond II Premium Wood Glue. If product has been frozen (gel-like appearance), it cannot be used. KEEP FROM FREEZING.

## ORDERING INFORMATION

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

## TESTING PROCEDURES

Results were obtained using the ASTM D-905 method. Twenty specimen were set up for each glue/substrate combination, using melamine and MDF. A 5/16" drawdown bar was used to apply the glue to one surface, with a closed assembly time of two minutes. A torque wrench was used to apply 125 psi. The specimen were clamped overnight and allowed to cure at room temperature for seven days. Ten specimen each were used for room temperature and 150°F shear testing.

**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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