



Titebond Melamine Glue

Titebond Melamine Glue is designed for bonding wood, particleboard, MDF and other porous substrates to synthetic materials such as melamine, vinyl and HPL as well as metals. It offers a fast initial tack, yet has a longer open time that allows for the accurate alignment of working materials.

Titebond Melamine Glue is a water-based adhesive that is nonflammable, has low odor, dries clear and cleans up with water. Its thicker formulation offers fewer runs and drips, making it easier to use and more effective for precise assemblies.



Conforms to ASTM D-4236

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

Physical Properties

Type Specialized vinyl acetate emulsion

State Liquid

Color White

Dried Film Clear

Solids 57%

Viscosity 12,000 cps

Storage life 24 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.

Calculated VOC 3.0 g/L

Weight/gallon 8.6 lbs.

Chalk temperature * Approximately 40 °F

Flashpoint > 200 °F

Freeze/thaw stability Unstable

pH 4.0

Bond Strength ASTM D-905 (On Hard Maple)

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

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)

Method 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.

Limitations

Titebond Melamine Glue is not intended for exterior use or where moisture is likely. Not for structural or load bearing applications. Vacuum pressing should only be used for veneers up to 1/16 inch in thickness. 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.**

Caution Statements

CAUTION: EYE AND SKIN IRRITANT. Contains oxydipropyl dibenzoate and dipropylene glycol n-butyl ether. Do not swallow. Do not allow eye contact or prolonged skin contact. **FIRST AID:** If swallowed, do not induce vomiting; contact physician. If eye contact occurs, flush with water for 15 minutes. Wash skin contact areas with soap and water. If irritation from eye or skin contact persists, contact physician. For additional information, refer to Material Safety Data Sheet. **KEEP OUT OF THE REACH OF CHILDREN.**

Ordering Information

Part No.	Size	Weight	Units Per Package	Packages Per Pallet
MELAMINE4014-CLEAR	16 Oz. Bottle	14.19	12	100
	Gallon Jug	18.26	2	63
	18.9 Liter Pail	45.81	1	24

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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