

TITEBOND® II DARK WOOD GLUE

PHYSICAL PROPERTIES (TYPICAL)

Type Cross-linking polyvinyl acetate
State Liquid
Color Light brown
Dried film Brown
Solids 48%
Viscosity 4,000 cps
pH 3.0

Calculated VOC: 5.5 g/L
Weight/gallon 9.1 lbs.
Chalk temperature* Approx. 55°F.
Flashpoint >200°F.
Freeze/thaw stability Stable
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 55°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, 100-150 psi for softwoods, 125-175 psi for medium woods and 175-250 psi for hardwoods)
Methods of application Plastic bottles for fine applications; glue may also be spread with a roller spreader or brush.
Cleanup Damp cloth while glue is wet. Scrape off and sand dried excess.

BOND STRENGTH ASTM D-905 (ON HARD MAPLE)

Temperature	Strength psi	% wood failure
Room Temperature	3,750	72
150°F. Overnight	1,750	6

PRODUCT FEATURES

- Passes ANSI Type II water-resistance
- Designed for interior and exterior applications
- Excellent sandability
- Unaffected by finishes
- Ideal for radio frequency (R-F) gluing systems
- Easy cleanup with water

LIMITATIONS

Titebond II Dark Wood Glue is not for continuous submersion or for use below the waterline. Not for structural or load bearing applications. Do not use when temperature, glue or materials are below 55°F. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form. Because of variances in the surfaces of treated lumber, it is a good idea to test for adhesion. Not FDA approved for indirect food contact. Read MSDS before use. **KEEP FROM FREEZING. KEEP OUT OF THE REACH OF CHILDREN.**

ORDERING INFORMATION

Cat. No.	Size	Units per Package	Weight	Packages per Pallet
3703	8 oz. Bottle	12	8	160
3704	16 oz. Bottle	12	16	100
3705	Gallon Jug	2	20	63
3707	5 Gallon Plastic Pail	1	51	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.

2020 Bruck Street, Columbus, Ohio 43207
 CUSTOMER SERVICE 1-800-669-4583
 TECH SERVICE 1-800-347-GLUE
 www.titebond.com

Franklin International

© 2007 Franklin International. All rights reserved. (Rev. 01/07)