

TITEBOND®

COLD PRESS FOR HPL

PHYSICAL PROPERTIES (TYPICAL)

Type Polyvinyl acetate emulsion
State Liquid
Color Off White
Dried film Translucent
Solids 42.0%
Viscosity 4,500 cps
pH 4.9

Calculated VOC: 3.2 g/L
Weight/gallon 9.7 lbs.
Chalk temperature* Approx. 50°F.
Flashpoint >200°F.
Freeze/thaw stability Stable
Storage life 6 months in tightly closed containers at 70°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 50°F.
Open assembly time 15 minutes (70°F./50% RH)
Closed assembly time 15-20 minutes (70°F./50% RH)
Minimum required spread Approximately 6 mils or 250 square feet per gallon
Required pressure application 30-80 psi for HPL, 100-150 psi for Panel-on-Frame, 100-250 psi for Veneer
Methods of application For most consistent coverage a mechanical spreader is recommended.
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	2,711	32
150°F. overnight	1,890	1

PRODUCT FEATURES

- **Moderate speed of set**
- **Economical alternative to contact cement**
- **Suitable for large-scale flat laminating and panel-on-frame cold press applications**
- **Dries translucent**
- **Water cleanup & non-toxic**

LIMITATIONS

Titebond Cold Press for HPL is specifically designed for laminating flexible materials and is not suited for other types of assembly applications. Do not use when temperature, glue or materials are below 50°F. Not recommended for exterior use or where moisture is likely. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form. Read MSDS before use. NOTE: STIR PRODUCT BEFORE USE TO ENSURE UNIFORMITY. KEEP FROM FREEZING.

ORDERING INFORMATION

Cat. No.	Size	Units per Package	Weight	Packages per Pallet
4617	5 Gallon Plastic Pail	1	52	24
4618	55 Gallon Drum	1	587	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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