

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 77 g/L

Weight Per 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

Melamine/Melamine Lap Shears

Melamine/particle Board

Strength

329 psi

339 psi

Substrate Failure

100%

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. KEEP OUT OF REACH OF CHILDREN.**

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 Safety Data Sheet. **KEEP OUT OF THE REACH OF CHILDREN.**

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