

## 19L TITEBOND EXTEND WOOD GLUE



SKU	Option	Part #	Price
9803356		519107	\$349

Model	
Type	Wood Glue
SKU	9803356
Part Number	519107
Barcode	037083091076
Brand	Titebond
Size	19L
Dimensions	
Product Weight (Net Weight)	22.2 kg
Packaging + Shipping	
Shipping Weight (Gross)	22.0 kg

**19L Titebond Extend Wood Glue** The first aliphatic resin emulsion adhesive developed. It has set the standard by which all aliphatics are measured. This premium adhesive has excellent creep and heat resistance, superior solvent resistance and excellent bond strength. An excellent choice for edge and face gluing as well as general assembly of a wide variety of wood species. Regular has a slower speed of set and is suitable for summer months or warmer climates.

**Features:-**

Excellent heat and solvent resistance

Setting speed: medium

Minimal or no joint creep

Formaldehyde-free

Superior performance history with interior furniture

One component great for cold pressing and assembly

175.105 FDA compliant

Low minimum use temperature

Freeze/thaw stable

**Physical Properties:-**

Type Polyvinyl acetate emulsion adhesive

State Liquid

Colour Yellow

Dried film Yellow

Solids 45%

Viscosity 4,000 cps

Storage life 9 months

Weight per gallon 4.35kg

Chalk temperature N/A

Freeze/thaw stability Stable

pH 3.7-5.0

**Application Guidelines:-**



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**Moisture content** Six to eight percent is the recommended moisture content for the gluing stock. High moisture content will dramatically increase the clamp time needed. Panel shrinkage may occur resulting in stress cracks or end-joint delamination. **Stock preparation** The preparation of the stock to be glued is extremely important. Joints cut from rip saws should be free of saw marks. They should also be straight and square. Moulded or jointed stock should be free of knife marks. Glazed or burnished joints will prevent adhesive penetration and should be guarded against. Gluing stock should be uniform in thickness. Variation in thickness should not exceed  $\pm 0.005$  inches/0.12 mm. Sanding to thickness should be performed using higher than 50 grit abrasives. When possible, glue joints should be prepared and glued the same day. **Spread** Generally, 35-50 pounds of adhesive per 1,000 square feet or 170-250 grams per square meter of glue line is adequate. Verify adequate glue coverage by monitoring for squeeze out along the glue line once the panels are under pressure. **Pressure** Pressure is dependent upon the species or material to be glued and joint preparation. Direct contact of the gluing surfaces is required to obtain maximum strength. The use of a compressometer will aid in accurately measuring the amount of pressure being applied to the gluing area. Suggested clamp locations for various wood densities are eight to fifteen inches (20-38 cm) apart and two inches (5 cm) from the end of the panel to evenly distribute pressure along the entire length of the glue line. **Assembly time** The assembly time is influenced by many factors, some of which include glue spread, moisture content of the stock, porosity of the stock, environmental conditions and adhesive choice. Assembly times of 5 -10 minutes are approximate. It is desirable to see a bead of adhesive squeeze out around the perimeter of the bottom panel of the stack.

At 70 °F and 50% relative humidity, approximately 6 wet mils:

Open Assembly Time ≈ 5 minutes

Total Assembly Time ≈ 15 minutes

**Press/clamp time** Press times are dependent on the adhesive used, gluing stock type, moisture content of the stock, and environmental conditions. Press times can range from a minimum press time of 30 minutes to greater than two hours. Shorter times are required under ideal conditions when using soft wood species at moisture content slightly less than eight to ten percent and factory temperatures of 68 degrees Fahrenheit / 20 degrees Celsius. Longer press times will be required for higher density species, higher moisture contents and colder factory temperatures. It is recommended that optimum press times be determined in actual plant conditions recognising that seasonal changes may lead to variable requirements. **Machining/ Post Process**

**Conditioning** After the minimum clamping time period, the panel will develop enough handling strength and can be removed and stacked out of the press. Twenty four hours of cure is recommended before further machining. Three or four days may be required to eliminate sunken joints caused by residual moisture in the glue line. **Minimum Use**

**Temperature** Curing temperatures should be higher than the minimum use temperature of the adhesive. This includes the temperature of the stock to be glued as well as the air



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and adhesive temperatures. If the temperatures are below the minimum use temperatures you will see a white, chalky appearance of the glue line. These bonds are usually weak.

**Clean-up** For easy removal of adhesive from equipment, clean up while it is still wet with warm water (this includes the glue roller and pans). For dried glue, steam and / or hot water are the most effective. Using glue release agents on equipment will also allow for easier clean up.

**Material Data Specifications:-**

MSDS

Data Sheet