

# Titebond®

## Original Wood Glue

### Physical Properties (Typical)

**Type** Aliphatic resin emulsion  
**State** Liquid  
**Color** Yellow **Dried film** Translucent **Solids** 46%  
**Viscosity** 3,200 cps  
**pH** 4.0

**Calculated VOC** (less water): 10.7 g/L  
**Weight/gallon** 9.2 lbs. **Chalk temperature\*** Approx. 50°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 50°F. **Assembly time after glue application** 5 minutes (70°F./50%RH) **Minimum required spread** 40 lbs. per 1,000 square feet  
**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 dried excess.

### Bond Strength ASTM D-905 (on hard maple)

Temperature	Strength psi	% wood failure
Room Temperature	3,600	77
150°F. Overnight	1,600	10

### Product Features

- **Fast set—shortens clamp time**
- **Bonds stronger than wood**
- **Excellent heat and solvent-resistance**
- **Excellent sandability**
- **Unaffected by finishes**
- **Versatile—bonds wood, hardboard, high pressure laminates and particleboard**
- **Easy cleanup with water**
- **Conforms to ASTM D4236**

### Limitations

Titebond Original Wood Glue is not intended for exterior use or where moisture is likely. For exterior applications use Titebond III Ultimate Wood Glue or Titebond II Premium Wood Glue. Do not use when temperature, glue or materials are below 50°F. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form. **KEEP FROM FREEZING. KEEP OUT OF THE REACH OF CHILDREN.**

**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.