

# TITEBOND® DOWELING GLUE L.V.

## PHYSICAL PROPERTIES (TYPICAL)

**Type** Polyvinyl acetate emulsion  
**State** Liquid  
**Color** White  
**Dried film** Translucent  
**Solids** 43.6%  
**Viscosity** 140 cps  
**pH** 4.7

**Calculated VOC:** 9.6 g/L  
**Weight/gallon** 9.0 lbs.  
**Chalk temperature\*** Approx. 45°F.  
**Flashpoint** >200°F.  
**Freeze/thaw stability** Unstable  
**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 45°F.  
**Assembly time after glue application** 0-5 minutes (70°F./50% RH)  
**Methods of application** Compatible with most European-made automatic doweling machines. See your machine's owner manual for details.  
**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        | 0              |

## PRODUCT FEATURES

- **For use with European-made doweling equipment**
- **Very low viscosity for better flow**
- **Excellent flow characteristics**
- **Dries translucent**
- **Excellent strength**
- **Fast setting**

## LIMITATIONS

Titebond Doweling Glue L.V. is specifically formulated for use with European-made doweling equipment. Because of its extreme low viscosity, it is not well suited for other assembly applications. THIS PRODUCT SHOULD BE USED AS SUPPLIED AND NOT DILUTED. Not recommended for exterior use or where moisture is likely. Do not use when temperature, glue or materials are below 45°F. This product is NOT freeze/thaw stable. 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 |
|----------|-----------------------|-------------------|--------|---------------------|
| 3817     | 5 Gallon Plastic Pail | 1                 | 49     | 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.

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