## GLUING & PRESSING

### WOOD GLUE REFERENCE CHART

<table>
<thead>
<tr>
<th>Brand Name and/or No.</th>
<th>Type</th>
<th>Form</th>
<th>% Solids</th>
<th>Working Life (Hrs. at 70°F)</th>
<th>Fed. &amp;/or Mil. Specifications Met by Product</th>
<th>Processing Equipment Required</th>
<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Industrial Adhesives &amp; Tapes Div, Building 220-5E-06, St. Paul, MN 55144 (800) 362-3550 <a href="http://www.3M.com/industrial">www.3M.com/industrial</a></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Fastbond 5</td>
<td>Neoprene</td>
<td>L</td>
<td>19%</td>
<td>30 minutes</td>
<td>MMM-A-121</td>
<td>Spray, brush, roller</td>
<td>Laminating</td>
<td>Rapid strength build-up, heat and creep resistant bond.</td>
</tr>
<tr>
<td>Fastbond 10</td>
<td>Neoprene</td>
<td>L</td>
<td>22%</td>
<td>3 minutes</td>
<td>MMM-A-121</td>
<td>Spray, brush, roller</td>
<td>Laminating</td>
<td>Rapid strength build-up, Brushable with high coverage.</td>
</tr>
<tr>
<td>Jet-melt Adhesive 3762</td>
<td>Thermoplastic</td>
<td>L</td>
<td>100%</td>
<td>Indefinite</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Excellent “hot tack”, fast setting. Bonds chipboard/wood.</td>
<td></td>
</tr>
<tr>
<td>Jet-melt Adhesive 3762-LM</td>
<td>Thermoplastic</td>
<td>L</td>
<td>100%</td>
<td>Indefinite</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Excellent “hot tack”, fast setting. Bonds chipboard/wood.</td>
<td></td>
</tr>
<tr>
<td>Jet-melt Adhesive 3792</td>
<td>Thermoplastic</td>
<td>L</td>
<td>100%</td>
<td>Indefinite</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Clear, multi-purpose product for wood, corrugated, light weight substrates. Furniture, upholstery, novelties.</td>
<td></td>
</tr>
<tr>
<td>Jet-melt Adhesive 3792-LM</td>
<td>Thermoplastic</td>
<td>L</td>
<td>100%</td>
<td>Indefinite</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Clear, multi-purpose product for wood, coated paper, polyolefins and other heat-sensitive materials.</td>
<td></td>
</tr>
<tr>
<td>Scotch-Weld Adhesive TE200</td>
<td>PUR</td>
<td>L</td>
<td>100%</td>
<td>4.5 min.</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Low viscosity. Long open time. Thin glue lines.</td>
<td></td>
</tr>
<tr>
<td>Scotch-Weld Adhesive TE015</td>
<td>PUR</td>
<td>L</td>
<td>100%</td>
<td>2.5 min.</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Extradur. Very fast set time for bonding.</td>
<td></td>
</tr>
<tr>
<td>Scotch-Weld Adhesive TE40</td>
<td>PUR</td>
<td>L</td>
<td>100%</td>
<td>2 min.</td>
<td>Applicator</td>
<td>Assembly</td>
<td>Extradur. Fast set time, low viscosity and strong, flexible bonds for a wide variety of plastics, wood, alum. and glass.</td>
<td></td>
</tr>
<tr>
<td>Scotch-Weld Instant CA40</td>
<td>Cyanoacrylate</td>
<td>L</td>
<td>100%</td>
<td>1 - 30 sec.</td>
<td>MIL-A-46050C</td>
<td>Squeeze bottle</td>
<td>Veneer repair</td>
<td>Very fast setting adhesive with excellent adhesion.</td>
</tr>
<tr>
<td>Scotch-Weld Instant CA40H</td>
<td>Cyanoacrylate</td>
<td>L</td>
<td>100%</td>
<td>5 - 40 sec.</td>
<td>MIL-A-46050C</td>
<td>Squeeze bottle</td>
<td>Veneer repair</td>
<td>A higher viscosity, slower setting version of CA-40.</td>
</tr>
<tr>
<td>Adhesive Products Corp., 3020 W. Carroll, Chicago, IL 60612 (773) 722-GLUE (4583)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>50-2200</td>
<td>Neoprene Contact</td>
<td>L</td>
<td>20</td>
<td></td>
<td>Spray</td>
<td>7, 9, 13</td>
<td>General purpose, flammable.</td>
<td></td>
</tr>
<tr>
<td>50-2201</td>
<td>Neoprene Contact</td>
<td>L</td>
<td>22</td>
<td></td>
<td>Roller/Brush</td>
<td>7, 9, 13</td>
<td>General purpose, flammable.</td>
<td></td>
</tr>
<tr>
<td>50-2210</td>
<td>Neoprene Contact</td>
<td>L</td>
<td>50</td>
<td></td>
<td>Spray</td>
<td>7, 9, 13</td>
<td>Water base.</td>
<td></td>
</tr>
<tr>
<td>50-4505</td>
<td>Hot melt</td>
<td>L</td>
<td>100</td>
<td></td>
<td>Edgebander</td>
<td>2</td>
<td></td>
<td></td>
</tr>
<tr>
<td>50-2205</td>
<td>Neo. Contact 50</td>
<td>L</td>
<td></td>
<td></td>
<td>Spray</td>
<td>7, 9, 13</td>
<td>Non-flammable.</td>
<td></td>
</tr>
<tr>
<td>Asseml-Stik 50-6005</td>
<td>Polyvinyl</td>
<td>L</td>
<td>No limit</td>
<td></td>
<td>Bottle, roll coater</td>
<td>1, 2, 9, 16</td>
<td>General purpose assembly, excellent tack.</td>
<td></td>
</tr>
<tr>
<td>Asseml-Stik 50-6465</td>
<td>Polyvinyl</td>
<td>L</td>
<td>No limit</td>
<td></td>
<td>Bottle, roll coater</td>
<td>1, 2, 9, 16</td>
<td>General purpose assembly, fast setting.</td>
<td></td>
</tr>
<tr>
<td>Plastik 50-6020</td>
<td>Polyvinyl</td>
<td>L</td>
<td>No limit</td>
<td></td>
<td>Cold press, roll coat</td>
<td>7, 9, 12, 22</td>
<td>High pressure laminates; quick clamp.</td>
<td></td>
</tr>
<tr>
<td>Vinyl-Stik 50-7400</td>
<td>Polyvinyl</td>
<td>L</td>
<td>No limit</td>
<td></td>
<td></td>
<td>18</td>
<td>Vinyl molding.</td>
<td></td>
</tr>
<tr>
<td>Vinyl Stik 50-7410</td>
<td>Polyvinyl</td>
<td>L</td>
<td></td>
<td></td>
<td>Roll coater</td>
<td>18</td>
<td>Vinyl laminating.</td>
<td></td>
</tr>
<tr>
<td>Assemble-Stik 50-1020</td>
<td>Modified polyvinyl</td>
<td>L</td>
<td>24</td>
<td>CS-35-61</td>
<td>Hot press or RF</td>
<td>2, 7, 9, 12, 16, 18, 21</td>
<td>Type II adhesive.</td>
<td></td>
</tr>
<tr>
<td>Carpenters-11-111</td>
<td>Mod. PVA</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>General assembly.</td>
<td></td>
</tr>
<tr>
<td>Adhpro Adhesives Inc., 1650 Industrial Boulevard, Magog, QC Canada J1X 4V9 (819) 847-2269 <a href="http://www.adhpro.com">www.adhpro.com</a></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>30575</td>
<td>PVA</td>
<td>L</td>
<td>53-57</td>
<td>N/A</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose assembly grade, 5000 cPs.</td>
<td></td>
</tr>
<tr>
<td>30057</td>
<td>PVA</td>
<td>L</td>
<td>43-45</td>
<td>N/A</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose assembly grade, 6000-7000 cPs, longer open time. Yellow.</td>
<td></td>
</tr>
<tr>
<td>30387</td>
<td>Crosslinking PVA</td>
<td>L</td>
<td>49-52</td>
<td>N/A</td>
<td>ANSI/HPVA Type 2</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose assembly grade, can be used with catalyst 99055 to achieve Type 2 bond.</td>
</tr>
</tbody>
</table>

### FORM: | L = Liquid | P = Powder | G = Granular | S = Solid | E = Emulsion | C = Cement | EM = Extrudable Mastic |

### USE CODE: | Numbers in Wood Glue “Uses” column are keyed to use descriptions below. |

1. Assembly gluing |
2. Edge gluing |
3. Scarf jointing |
4. Particleboard |
5. Laminated timbers |
6. Molded products |
7. Plastic laminate |
8. Exterior plywood |
9. Interior plywood |
10. Veneer edging |
11. Boats (marine uses) |
12. Flush doors |
13. Hardboard |
14. Tapeless edging |
15. Patching |
16. Paper to wood |
17. Metal to wood |
18. Films & paper overlays |
19. Hardboard binder |
20. Particleboard binder |
21. Fingerjointing |
22. Panel-to-frame |
23. Sulfur |
## GLUING & PRESSING

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<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>30120 PVA</td>
<td>L</td>
<td>48-52</td>
<td>N/A</td>
<td>2, 4, 7, 9, 14, 16, 21</td>
<td>-</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose assembly grade.</td>
</tr>
<tr>
<td>30110 PVA</td>
<td>L</td>
<td>48-52</td>
<td>N/A</td>
<td>2, 4, 7, 9, 14, 16, 21</td>
<td>-</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>Yellow version of 30120 grade.</td>
</tr>
<tr>
<td>30194 PVA</td>
<td>L</td>
<td>46-49</td>
<td>N/A</td>
<td>2, 4, 7, 9, 14, 16, 21</td>
<td>-</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose assembly, high viscosity.</td>
</tr>
<tr>
<td>30063 PVA</td>
<td>L</td>
<td>38-40</td>
<td>N/A</td>
<td>2, 4, 7, 9, 14, 16, 21</td>
<td>-</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose economy assembly grade and for HPL laminate.</td>
</tr>
<tr>
<td>30060 PVA</td>
<td>L</td>
<td>33-35</td>
<td>N/A</td>
<td>2, 4, 7, 9, 14, 16, 21</td>
<td>-</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose economy assembly grade, long open time. Yellow.</td>
</tr>
<tr>
<td>30203 PVA</td>
<td>L</td>
<td>41-45</td>
<td>N/A</td>
<td>2, 4, 7, 9, 14, 16, 21</td>
<td>-</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>General purpose economy assembly grade, low viscosity, good for chair backs. Curved plywood.</td>
</tr>
<tr>
<td>30224 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>Precatalyzed crosslinking grade for flush doors, veneer and curved plywood.</td>
</tr>
<tr>
<td>30231 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>Lower viscosity version of 30224, also used for fingerjointing.</td>
</tr>
<tr>
<td>30213 Crosslinking</td>
<td>L</td>
<td>50-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>High viscosity flush door adhesive.</td>
</tr>
<tr>
<td>30204 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,16,22</td>
<td>Precatalyzed crosslinking grade for general assembly, curved plywood, good on hot press, RF grade.</td>
</tr>
<tr>
<td>30283 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>Precatalyzed crosslinking grade, fingerjointing.</td>
</tr>
<tr>
<td>30790 Crosslinking</td>
<td>L</td>
<td>49-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>Used in conjunction with catalyst 98905 to achieve Type 2 bond, hot press, RF grade.</td>
</tr>
<tr>
<td>30211 Crosslinking</td>
<td>L</td>
<td>50-51</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,8,9,13,22</td>
<td>Precatalyzed crosslinking, fortified laminating grade viscosity, hot press, RF grade higher water resistant.</td>
</tr>
<tr>
<td>30212 Crosslinking</td>
<td>L</td>
<td>50-51</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>Precatalyzed crosslinking, fortified fingerjoint viscosity, higher water resistant.</td>
</tr>
<tr>
<td>30229 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,8,9,13,22</td>
<td>Used in conjunction with catalyst 98905, laminating grade, hot press, RF grade.</td>
</tr>
<tr>
<td>30230 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,21,22</td>
<td>Used in conjunction with catalyst 98905, fingerjoint viscosity grade.</td>
</tr>
<tr>
<td>30239 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>30204 with wood floor, hot press, RF grade.</td>
</tr>
<tr>
<td>30299 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>30204 with shell floor, hot press, veneer, RF grade.</td>
</tr>
<tr>
<td>30210 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>A more flexible 30204 for mixer joints, picture framing.</td>
</tr>
<tr>
<td>30201 Crosslinking</td>
<td>L</td>
<td>46-52</td>
<td>N/A</td>
<td>48-52</td>
<td>ANSI/HPVA</td>
<td>Roller/Brush/Roll coater/bottle</td>
<td>1,2,3,7,9,13,22</td>
<td>A higher viscosity version of 30204.</td>
</tr>
</tbody>
</table>

### Canplast Inc., 4797 Couture Blvd., Montreal, PQ, Canada H1R 3H7 (514) 327-9555  www.canplast.com

- **2001 Translucent EVA**
  - **Pallets** 100
  - **1 yr.**
  - **Panel processing centers, edging bander**
  - **2, 4, 7, 9, 14, 16, 29**
  - Premium translucent hotmelt used for rigid PVC, ABS, melamine, polyester, veneer and solid wood.
- **2022 Natural, Brown, Black, White EVA**
  - **Cartridge** 100
  - **1 yr.**
  - **Holz-Her auto. edging bander**
  - **2, 4, 7, 9, 14, 16, 29**
  - Used with Holz-Her cartridge fed system. Suitable for rigid PVC, melamine, polyester, veneer, solid wood and primed H.P. laminate.
- **3021 Natural, Brown, White, Black EVA**
  - **Pallets** 100
  - **1 yr.**
  - **Soft-forming and straight edging banders**
  - **2, 4, 7, 9, 14, 16, 29**
  - General use for wrapping and soft forming veneer and melamine. Suitable for rigid PVC, ABS, melamine, polyester, veneer, solid wood, & primed H.P. laminate.
- **2041 Natural, White EVA**
  - **Pallets** 100
  - **1 yr.**
  - **Straight edging banders**
  - **2, 4, 7, 9, 14, 16, 29**
  - General purpose hotmelt used for thick and thin PVC, ABS, melamine, polyester, veneer & solid wood edging.

### Form:
- L = Liquid
- P = Powder
- G = Granular
- S = Solid
- E = Emulsion
- C = Cement
- EM = Extrudable Mastic

### Use Code:
Numbers in Wood Glue “Uses” column are keyed to use descriptions below:
- 1. Assembly gluing
- 2. Edge gluing
- 3. Scarf jointing
- 4. Particleboard
- 5. Laminated timbers
- 6. Milled products
- 7. Plastic laminate
- 8. Exterior plywood
- 9. Interior plywood
- 10. Veneer edging
- 11. Boats (marine uses)
- 12. Flush doors
- 13. Hardboard
- 14. Tapeless edging
- 15. Patching
- 16. Paper to wood
- 17. Metal to wood
- 18. Films & paper overlays
- 19. Hardboard binder
- 20. Particleboard binder
- 21. Fingerjointing
- 22. Panel-to-frame
- 23. Subflooring
- 24. Fiberboard
# GLUING & PRESSING

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<th>Processing Equipment Required</th>
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</tr>
</thead>
<tbody>
<tr>
<td>KS 201</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Auto. edgebander</td>
<td>2, 4, 7, 9, 16</td>
<td>Multi-purpose hot melt for auto. edgebanders at medium high speeds. Straight line &amp; soft form. High heat resistance. PVC, solid wood, veneers, polyester &amp; melamine.</td>
<td></td>
</tr>
<tr>
<td>KS 205</td>
<td>Modified EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Auto. edgebander</td>
<td>2, 4, 7, 9, 16</td>
<td>Excellent multi-purpose hot melt, high temperature ranges, higher viscosity than KS 217. All E.B., including HPL.</td>
<td></td>
</tr>
<tr>
<td>KS 208</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Auto. edgebander</td>
<td>2, 4, 7, 9, 16</td>
<td>Low cost multi-purpose hot melt for auto. edgebander, suitable for PVC, veneer, polyester, melamine.</td>
<td></td>
</tr>
<tr>
<td>KS 217</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Auto. edgebander</td>
<td>2, 4, 7, 9, 16</td>
<td>Multi-purpose hot melt low viscosity, good heat range. For granular feed systems. Suitable for solid wood, veneer, PVC, polyester, melamine.</td>
<td></td>
</tr>
<tr>
<td>KS 350</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Auto. edgebander</td>
<td>2, 4, 7, 9, 16</td>
<td>Excellent multi-purpose hot melt for auto. E/B. High heat resistance. Straight line &amp; soft form applications. Speciality suited for veneers. Longer open time.</td>
<td></td>
</tr>
<tr>
<td>AS 223</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Semi Automatic Continue Edger</td>
<td>2, 4, 7, 9, 16</td>
<td>Formulated to prep-apply to edgeband. Low application temp. Ideal for PVC, veneer, melamine, and HPL.</td>
<td></td>
</tr>
<tr>
<td>US 241</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>ProfileWrap Equipment, Auto. Edger</td>
<td>2, 4, 7, 9, 16</td>
<td>Low viscosity HM for profile wrap and soft form applications. Specially suited for veneers. Longer open time.</td>
<td></td>
</tr>
<tr>
<td>US 253</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>ProfileWrap Equipment, Auto. Edger</td>
<td>2, 4, 7, 9, 16, 18</td>
<td>Similar to US 241 profile wrap and soft form papers, falls, vinyl.</td>
<td></td>
</tr>
<tr>
<td>HKP 21, HKP 25</td>
<td>Hot Melt Cartridge</td>
<td>S</td>
<td>100%</td>
<td>1 year</td>
<td>Holz-Her Edger</td>
<td>2, 4, 7, 9, 16</td>
<td>All purpose hot melt for the Holz-Her cartridge system.</td>
<td></td>
</tr>
<tr>
<td>HKP 26</td>
<td>PUR Cartridge</td>
<td>S</td>
<td>100%</td>
<td>6 months</td>
<td>Holz-Her Edger</td>
<td>2, 4, 7, 9, 16</td>
<td>PUR based hot melt in cartridge for Holz-Her EBs. High heat resistance; moisture &amp; solvent resistant. Invisible glue line. For thick, thin veneers, melamine, thick &amp; thin PVC, solid wood and HPL.</td>
<td></td>
</tr>
<tr>
<td>AD 060</td>
<td>PVAC</td>
<td>L</td>
<td>1 year</td>
<td>Auto. dowel insert</td>
<td>1, 3</td>
<td>Low viscosity, fast setting, will not dog.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>QH45</td>
<td>EVA Hot Melt</td>
<td>G</td>
<td>100%</td>
<td>1 year</td>
<td>Auto edgebander, BAZ</td>
<td>2, 4, 7, 9, 16</td>
<td>Clear hot melt. High viscosity &amp; heat resistance. Recommended for machines like BAZ and straight line &amp; softform apps. Invisible glue line. Suitable for thick, thin veneers, melamine, thick, thin PVC, solid wood and HPL.</td>
<td></td>
</tr>
</tbody>
</table>

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**Franklin Adhesives & Polymers**, 2020 Bruck St., Columbus, OH 43207 (614) 443-0241/ (800) 877-4583  
www.franklinadhesives.com

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**Multibond 2000 Series**  
Crosslinking PVAc  
L 48–52  
N/A  
ANSI/HPMA Type II  
Roll coater, brush  
1, 2, 3, 7, 9, 21, 22  
Long shelf life PVAc for RF curing & heat or cold pressing.

**Titebond Regular**  
Aliphatic  
L 38–46  
N/A  
AA-H-00600b  
Roll coater, bottle  
1, 2, 12, 21  
Heat & solvent resistant, strong wet tack, sandable, non-staining for cold press or glue reels.

**Titebond Supreme**  
Aliphatic  
L 42  
N/A  
AA-H-00600b  
See above  
1, 3, 7, 15  
For oak & ring porous woods.

**Advantage Series**  
Crosslinking PVAc  
L 50–55  
N/A  
ASTM D5572  
ASTM D5751  
Roll coater, brush  
1, 2, 3, 8, 10, 21, 22  
Water resistant PVA for ASTM D-3110 wet use performance in RF curing, or heat pressing & fingerjointing.

**Assembly Glue #65**  
PVA  
L 60  
N/A  
AA-H-0570a  
AA-H-05600  
MM-I-193  
Roll coater, pressure pot, bottle  
1, 3, 7, 10, 13, 15, 16  
Gap filling, fast setting assembly glue for cold press or Glue reels.

**Assembly Glue High Tack**  
PVA  
L 45  
N/A  
See above  
Roll coater, pressure pot, bottle  
1, 3, 7, 10, 13, 15, 16  
Fast setting, tacky solvent resistant, or cold press or Glue reels.

---

**FORM**:  
L = Liquid  
P = Powder  
G = Granular  
S = Solid  
E = Emulsion  
C = Cement  
EM = Extrudable Mastic

**USE CODE**:  
Numbers in Wood Glue “Uses” column are keyed to use descriptions below.

1. Assembly gluing  
2. Edge Gluing  
3. Scarf joining  
4. Particleboard  
5. Laminated timbers  
6. Molded products  
7. Plastic laminate  
8. Exterior plywood  
9. Interior plywood  
10. Veneer splicing  
11. Boats (marine uses)  
12. Flush doors  
13. Hardboard  
14. Tapeless splicing  
15. Patching  
16. Paper to wood  
17. Metal to wood  
18. Films & paper overlays  
19. Hardboard binder  
20. Particleboard binder  
21. Fingerjointing  
22. Panel-to-frame  
23. Subfloors  
24. Fiberboard

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www.redbookonline.com  
www.doellken-woodtape.com
### GLUING & PRESSING

#### WOOD GLUE REFERENCE CHART

<table>
<thead>
<tr>
<th>Brand Name and/or No.</th>
<th>Type</th>
<th>Form</th>
<th>% Solids</th>
<th>Working Life (Hrs. at 70° F.)</th>
<th>Fed. &amp;/or Mil. Specifications Met by Product</th>
<th>Processing Equipment Required</th>
<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>Multibond 4000 FF</td>
<td>PVA</td>
<td>L</td>
<td>47-50</td>
<td>N/A</td>
<td>ANSI/HPVA-2004 Type II water resist., ASTM D 5572 Dry Use, ANSI/HPVA EF-2002 cyclic soak, CARB Phase 2</td>
<td>Roll coater, brush</td>
<td>2, 9</td>
<td>Formaldehyde-free, water-resistant and suitable for the manufacturing of interior plywood, engineered flooring and edge and face gluing.</td>
</tr>
<tr>
<td>Multibond MX-90</td>
<td>PVA</td>
<td>L</td>
<td>49-52</td>
<td>N/A</td>
<td>ANSI/HPVA 1997 Type II water resist., NWWDCA Type II water resist., Humidity Cycling Test, 180°F Heat Age Test</td>
<td>Roll coater, brush</td>
<td>8,9</td>
<td>One-part, crosslinking PVA that was designed for hot pressing. It can achieve HPVA Type II bonds and is formulated to help bleed through resistance.</td>
</tr>
<tr>
<td>Advantage 425</td>
<td>PVA</td>
<td>L</td>
<td>50-52</td>
<td>N/A</td>
<td>Surpassed ASTM D-5572 wet use finger joint standard (flexure and tension)</td>
<td>Roll coater, brush</td>
<td>21</td>
<td>High performance, water-resistant, two-part crosslinking polyvinyl acetate emulsion adhesive developed for finger jointing.</td>
</tr>
</tbody>
</table>

**Georgia-Pacific Resins Inc., P.O. Box 105734, Atlanta, GA 30348 (404) 652-8569 [www gp.com](http://www gp.com)**

| Real-Stran             | Phenolic resins | L    | 45-57    | 7–10 days                     | Hot press | 4, 20                  | Face & core resins for OSB/finishboard. |
| Real-Bond             | Phenolic-formaldehyde Resin | L    | 40–50    | 7–10 days                     | Hot press | 13, 24                  | PE resin for wet and dry process hardboard. |
| Resorabond           | Phenol-resorcinol-formaldehyde resins | L    | 43-72    | Powder (Slurry)               | 3 mos. - 1 year | ASTM D-2565-99 Liquid/liquid mixer-mixing equipment | 1, 5, 21                          | 2 component slurry adhesives for lumber fabricating, gluing and end jointing. |
| Wood-Well            | Phenol-formaldehyde | P    | 100      | 3-6 mos.                      | Hot press | 4, 20, 24               | Face & core powder resin for OSB. |
| Real-Mix             | Phenolic resins | L    | 42–47    | 7–10 days                     | Sprayline; curtain coater, spreader, hot press | 8                     | Plywood & LVL. |

**Helmitin Inc., 11110 Airport Road, Olive Branch, MS 38654 (800) 634-8761 [www.helmitinadhesives.com](http://www.helmitinadhesives.com)**

| Helmitherm 9405       | EVA hot melt   | G    | 100      | Indefinite                    | N/A       | Menard contour edge, profile wrapper | 2, 4, 7, 9, 16, 24 | Low app. temp., clear, unfilled, contour edge. Will not melt thin edge materials. |
| Helmitherm 430 Series | EVA hot melt   | G    | 100      | Indefinite                    | N/A       | Auto. edgebander                  | 2, 4, 7, 9, 16, 24 | For medium to high speed machinery. Bonds PVC, wood, wood veneer. Available in white, natural & brown. |
| Helmitherm 480C Series| EVA hot melt cart. | S    | 100      | Indefinite                    | N/A       | Holz-Her edgebander              | 2, 4, 7, 9, 16, 24 | Bonds difficult materials inc. HPL Sulfurizing capability. |
| Helmitherm 494        | EVA hot melt   | G    | 100      | Indefinite                    | N/A       | Auto. edgebander                  | 2, 4, 7, 9, 16, 24 | Two-part, crosslinking PVA that was designed for hot pressing. It can achieve HPVA Type II bonds and is formulated to help bleed through resistance. |
| Helmitherm 495C       | EVA hot melt cart. | S    | 100      | Indefinite                    | N/A       | Holz-Her edgebander              | 2, 4, 7, 9, 16, 24 | Clear, unfilled hot melt cartridge. Adhesion to all edge materials, especially solid wood. |
| Helmbond 776          | Waterborne contact cement | E    | 55      | 9 months                      | N/A       | Spray, brush, roll               | 1, 2, 4, 6, 7, 13, 16, 17, 24 | Solvent & VOC free, postformable, long open time. SCAQMD Rule 1168. 1 point credit toward LEED Green Building Certification. |
| Aquanova XL           | Waterborne cement | E    | 45      | 3 months                      | N/A       | Spray, brush, roll               | 1, 4, 7, 13, 16, 17, 24 | Outstanding metal adhesion. Fast drying, long open time. |
| Helmbond 4005         | Neoprene cement | L    | 18      | 9 months                      | N/A       | Spray                            | 1, 2, 4, 6, 7, 13, 16, 17, 24 | Gen. purpose, 5 min. drying time, excellent tack. |
| Helmbond 805          | Type II PVA    | E    | 48      | 3 months                      | CSA Type I Glue spreader, bottle            | 1-4, 7, 9, 13, 21, 22 | Hot & cold pressing. HPL, veneers. Assembly operations where water resistance required. Pre-catalyzed. |

**Characteristics**

<table>
<thead>
<tr>
<th>Form</th>
<th>P = Powder</th>
<th>G = Granular</th>
<th>S = Solid</th>
<th>E = Emulsion</th>
<th>C = Cement</th>
<th>EM = Extractable Plastic</th>
</tr>
</thead>
<tbody>
<tr>
<td>L = Liquid</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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# GLuing & pressing

## wood glue reference chart

<table>
<thead>
<tr>
<th>Brand Name and/or No.</th>
<th>Type</th>
<th>Form</th>
<th>% Solids</th>
<th>Working Life (Hrs. at 70° F.)</th>
<th>Fed. &amp;/or Mil. Specifications Met by Product</th>
<th>Processing Equipment Required</th>
<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>Halmbond 854</td>
<td>PVA</td>
<td>E</td>
<td>44</td>
<td>6 months</td>
<td>N/A</td>
<td>Auto. dowelling</td>
<td>1</td>
<td>For machines with extrusion type ejectors.</td>
</tr>
<tr>
<td>Halmbond 856</td>
<td>EVA</td>
<td>E</td>
<td>36</td>
<td>8 months</td>
<td>N/A</td>
<td>Auto. dowelling</td>
<td>1</td>
<td>For machines with spray type ejectors.</td>
</tr>
<tr>
<td>Halmbond 853</td>
<td>Type II PVA</td>
<td>E</td>
<td>56</td>
<td>6 months</td>
<td>N/A</td>
<td>Glue spreader</td>
<td>1, 2, 3, 8, 9, 10, 21, 22</td>
<td>Hot &amp; cold pressing. HPL, veneers. Assembly operations where water resistance required. Mix w/5% hardener 0550.</td>
</tr>
<tr>
<td>Halmbond 856I</td>
<td>PVA</td>
<td>E</td>
<td>46</td>
<td>6 months</td>
<td>N/A</td>
<td>Squeeze bottle</td>
<td>1, 2, 3, 4, 7, 13, 22</td>
<td>Assembly PVA, +5 min. clamp time possible. Excellent for panel in frame door assembly operations.</td>
</tr>
<tr>
<td>Halmbond 859</td>
<td>Urethane</td>
<td>E</td>
<td>44–47</td>
<td>3 months</td>
<td>N/A</td>
<td>Spray</td>
<td>18</td>
<td>Thermoforming adhesive. Colored white for visibility on parts. Smooth finish, high strength, heat resistance.</td>
</tr>
<tr>
<td>Helmitherm 499</td>
<td>Hot melt cleaner</td>
<td>G</td>
<td>100</td>
<td>1 year</td>
<td>N/A</td>
<td>Auto. edgebander</td>
<td>Glue pot cleaning compound.</td>
<td></td>
</tr>
<tr>
<td>Helmitherm 499C</td>
<td>HM cleaner cart</td>
<td>S</td>
<td>100</td>
<td>1 year</td>
<td>N/A</td>
<td>Holz-Her edgebander</td>
<td>Cleaner in cartridge form for Holz-Her machines.</td>
<td></td>
</tr>
</tbody>
</table>

### Henkel Adhesives, 1345 Gasket Drive, Elgin, IL 60120  (847) 289-2410  [www.henkelcorp.com](http://www.henkelcorp.com)

- DORUS KS 205, 217, 224
  - Hot melt, EVA
  - Form: G
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Hot melt applicator
  - Uses: 2, 16
  - Characteristics: Edgebanding, solid wood.

- DORUS KS 360/2, 360/4
  - Hot melt, Polyolefin
  - Form: G
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Hot melt applicator
  - Uses: 2, 16
  - Characteristics: Edgebanding, heat resistant.

- DORUS HHP 21, HHP 25
  - Hot melt, EVA
  - Form: G
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Hot melt applicator
  - Uses: 2, 16

- DORUS US 24/13
  - Hot melt, EVA
  - Form: G
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Hot melt applicator
  - Uses: 2, 18
  - Characteristics: Saturated for difficult veneer species.

- DORUS US 253/9E
  - Hot melt, EVA
  - Form: G
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Hot melt applicator
  - Uses: 2, 16, 18

- DORUS US 276
  - Hot melt, Polyolefin
  - Form: G
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Hot melt applicator
  - Uses: 2, 16, 18
  - Characteristics: High heat resistance.

### Hexion Specialty Chemicals, 180 E. Broad St., Columbus, OH 43215 (614) 225-4000  [www.hexion.com](http://www.hexion.com)

- Casco Resin CR 583
  - Type: UF
  - Form: L
  - % Solids: 66
  - Life (Hrs.): Variable
  - Equipment: PS-51-71 TYPE II
  - Uses: Hot press and high frequency
  - Characteristics: 2, 9

- Cascozex 355
  - Type: PVA
  - Form: L
  - % Solids: 45
  - Life (Hrs.): Indefinite
  - Equipment: Cold press and clamps
  - Uses: 1, 2, 7, 22
  - Characteristics: Low cost.

- Cascophen SP-6300
  - Type: Phenolic
  - Form: L
  - % Solids: 43
  - Life (Hrs.): 24+ months
  - Equipment: PS-1-74
  - Uses: Hot press; spreader; spray
  - Characteristics: Fast cure; good pre-pressing.

- Cascophen SP-C659
  - Type: Phenolic
  - Form: L
  - % Solids: 45
  - Life (Hrs.): 24+ months
  - Equipment: PS-1-74
  - Uses: Hot press; spreader; curtain coating
  - Characteristics: Long stand time tolerance.

- Cascophen HB-62
  - Type: Phenolic
  - Form: L
  - % Solids: 60
  - Life (Hrs.): Indefinite
  - Equipment: PS-58-73
  - Uses: Hot press
  - Characteristics: Dry process hardboard.

- Cascophen HB-37
  - Type: Phenolic
  - Form: L
  - % Solids: 42
  - Life (Hrs.): Indefinite
  - Equipment: PS-58-73
  - Uses: Hot press
  - Characteristics: Wet process hardboard.

- Cascorez 12S
  - Type: UF
  - Form: P
  - % Solids: 100
  - Life (Hrs.): 4
  - Equipment: MMA-188C
  - Uses: Cold press
  - Characteristics: 2, 4, 7, 9, 22

- Cascophen G-1131
  - Type: RF
  - Form: L
  - % Solids: 62
  - Life (Hrs.): 24 months
  - Equipment: MIL-4605 TYPE I GRADE A
  - Uses: Hot and cold press
  - Characteristics: 2, 3, 5, 11, 12, 21, 22

- Wonderbond WB-865
  - Type: PVA (X-LINK)
  - Form: L
  - % Solids: 90
  - Life (Hrs.): 24 months
  - Equipment: PS-51-71 TYPE II
  - Uses: Hot and cold press
  - Characteristics: 1, 2, 7, 9, 21, 22

- Wonderbond XB-900I
  - Type: PVA (X-LINK)
  - Form: L
  - % Solids: 51
  - Life (Hrs.): 18 months
  - Equipment: PS-51-71 TYPE I ASTM D310-wet use
  - Uses: Hot and cold press
  - Characteristics: 1, 2, 7, 9, 21, 22

- Southeastern Adhesives
  - Type: PVAc, EVA & Unsa
  - Form: L
  - % Solids: 45-65
  - Life (Hrs.): Indefinite
  - Equipment: Roll, spray, etc
  - Uses: 1-7, 8, 9, 10, 12, 14, 16, 18, 20, 21, 22, 24
  - Characteristics: General purpose and specific wood applications.

### ICP Inc.-Veneer Division, 1427-A Boulder Court, Greensboro, NC 27409  (336) 284-9072  [www.icplus.com](http://www.icplus.com)

- ICP 98
  - Type: HMA
  - Form: S
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Edgbander
  - Uses: 2, 4, 7, 9, 16

- ICP 33
  - Type: HMA
  - Form: S
  - % Solids: 100
  - Life (Hrs.): N/A
  - Equipment: Edgbander
  - Uses: 2, 4, 7, 9, 16, 24

**Form:** L = Liquid  P = Powder  G = Granular  S = Solid  E = Emulsion  C = Cement  EM = Extrudable Mastic

**Use Code:**
1. Assembly gluing
2. Edge gluing
3. Scarf jointing
4. Particleboard
5. Laminated timbers
6. Milled products
7. Plastic laminate
8. Exterior plywood
9. Interior plywood
10. Veneer splicing
11. Boats (marine uses)
12. Flush doors
13. Hardboard
14. Tapeless splicing
15. Patching
16. Paper to wood
17. Metal to wood
18. Films & paper overlays
19. Hardboard binder
20. Particleboard binder
21. Fingerjointing
22. Panel-to-frame
23. Subflooring
24. Fiberboard
## GLUING & PRESSING

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<thead>
<tr>
<th>Brand Name and/or No.</th>
<th>Type</th>
<th>Form</th>
<th>% Solids</th>
<th>Working Life (Hrs. at 70°F.)</th>
<th>Fed. &amp;/or Mil. Specifications Met by Product</th>
<th>Processing Equipment Required</th>
<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>ITW TACC, 56 Air Station Industrial Park, Rockland, MA 02370</td>
<td>T162</td>
<td>Contact</td>
<td>Liquid</td>
<td>18.5</td>
<td>45 min</td>
<td>Brush, roll</td>
<td>2,4,7,9</td>
<td>High initial grab.</td>
</tr>
<tr>
<td></td>
<td>T283</td>
<td>Contact</td>
<td>Liquid</td>
<td>20</td>
<td>60 min</td>
<td>Spray</td>
<td>2,4,7,9</td>
<td>Postform, fast dry, flammable, red/green.</td>
</tr>
<tr>
<td></td>
<td>T307</td>
<td>WB Contact</td>
<td>Liquid</td>
<td>50</td>
<td>2 hrs</td>
<td>0% BOCs, 0% CFUs</td>
<td>Spray, brush, roller</td>
<td>2,4,7,9</td>
</tr>
<tr>
<td></td>
<td>T303</td>
<td>N/F Contact</td>
<td>Liquid</td>
<td>8</td>
<td>45 min</td>
<td>Spray</td>
<td>2,4,7,9</td>
<td>Fast dry, hot or cold application.</td>
</tr>
<tr>
<td></td>
<td>T162NF</td>
<td>N/F Contact</td>
<td>Liquid</td>
<td>11</td>
<td>45 min</td>
<td>Brush, roll</td>
<td>2,4,7,9</td>
<td>Fast dry, non-flammable, heat resistance.</td>
</tr>
<tr>
<td></td>
<td>T800</td>
<td>N/F Aerosol Contact</td>
<td>Liquid</td>
<td>10</td>
<td>10 min</td>
<td>Aerosol cylinder</td>
<td>4,7,9,17,24</td>
<td>High temperature, high strength.</td>
</tr>
<tr>
<td></td>
<td>C2153</td>
<td>Contact</td>
<td>Liquid</td>
<td>18.5</td>
<td>45 min</td>
<td>Brush, roll</td>
<td>2,4,7,9</td>
<td>High initial grab.</td>
</tr>
<tr>
<td></td>
<td>C7340</td>
<td>Contact</td>
<td>Liquid</td>
<td>18</td>
<td>45 min</td>
<td>Spray</td>
<td>2,4,7,9</td>
<td>Heat, water, chemical resistant.</td>
</tr>
<tr>
<td></td>
<td>C2725</td>
<td>Contact</td>
<td>Liquid</td>
<td>20</td>
<td>60 min</td>
<td>Spray</td>
<td>2,4,7,9</td>
<td>Postform, fast dry, flammable, red/green.</td>
</tr>
<tr>
<td></td>
<td>C307</td>
<td>WB Contact</td>
<td>Liquid</td>
<td>50</td>
<td>2 hrs</td>
<td>0% BOCs, 0% CFUs</td>
<td>Spray, brush, roller</td>
<td>2,4,7,9,18,22</td>
</tr>
<tr>
<td></td>
<td>C3049</td>
<td>N/F Contact</td>
<td>Liquid</td>
<td>8</td>
<td>45 min</td>
<td>Spray</td>
<td>2,4,7,9</td>
<td>Fast dry, hot or cold application.</td>
</tr>
<tr>
<td></td>
<td>C3498M</td>
<td>N/F Contact</td>
<td>Liquid</td>
<td>25</td>
<td>45 min</td>
<td>Spray</td>
<td>7,11,17</td>
<td>High heat resistance.</td>
</tr>
<tr>
<td></td>
<td>C1568M</td>
<td>N/F Contact</td>
<td>Liquid</td>
<td>11</td>
<td>45 min</td>
<td>Brush, roll</td>
<td>2,4,7,9</td>
<td>Fast dry, non-flammable, heat resistance.</td>
</tr>
<tr>
<td></td>
<td>S159/159</td>
<td>E/F Spray Contact</td>
<td>Liquid</td>
<td>17</td>
<td>4 - 5 min</td>
<td>Auto, Manual Spray</td>
<td>4,7,9,17,24</td>
<td>Industrial premium, High heat resistance, high strength.</td>
</tr>
<tr>
<td></td>
<td>S160/1656</td>
<td>E/F Spray Contact</td>
<td>Liquid</td>
<td>19</td>
<td>4 - 5 min</td>
<td>Auto, Manual Spray</td>
<td>4,7,9,17,24</td>
<td>Hand spray for variable conditions and a variety of materials.</td>
</tr>
<tr>
<td></td>
<td>S140</td>
<td>E/F Spray Contact</td>
<td>Liquid</td>
<td>21</td>
<td>15 - 20 min</td>
<td>Brush, roller, trowel, coater</td>
<td>4,7,9,17,24</td>
<td>Post formable, fast dry, high tack, industrial quality.</td>
</tr>
<tr>
<td></td>
<td>S145</td>
<td>20° Flash Brush</td>
<td>Liquid</td>
<td>18</td>
<td>15 - 20 min</td>
<td>Brush, roller, trowel, coater</td>
<td>4,7,9,17,24</td>
<td>Resists static stress, humidity, water, oil and aliphatic solvents.</td>
</tr>
<tr>
<td></td>
<td>S170/171</td>
<td>MC N/F Spray</td>
<td>Liquid</td>
<td>28</td>
<td>4 - 5 min</td>
<td>Auto, Manual Spray</td>
<td>4,7,9,17,24</td>
<td>Freeze/thaw stable, long open tack, bonds realal humidity/water.</td>
</tr>
<tr>
<td></td>
<td>S100</td>
<td>Brush Contact</td>
<td>Liquid</td>
<td>11</td>
<td>5-10 min</td>
<td>Brush, roller, trowel, coater</td>
<td>4,7,9,17,24</td>
<td>Long open tack, non-flammable and freeze/thaw stable.</td>
</tr>
<tr>
<td></td>
<td>S160/1682</td>
<td>Water Base Contact</td>
<td>Liquid</td>
<td>49/55</td>
<td>45 min</td>
<td>Auto, Manual Spray</td>
<td>4,7,9,17,24</td>
<td>Post formable.</td>
</tr>
<tr>
<td></td>
<td>SPHS</td>
<td>N/F Aerosol PS</td>
<td>Liquid</td>
<td>1 hr</td>
<td>&lt;80 g/l VOC</td>
<td>Aerosol cylinder</td>
<td>4,7,9,17,24</td>
<td>Pressure sensitive, heat and UV stable, non-flammable.</td>
</tr>
<tr>
<td></td>
<td>S202</td>
<td>E/F Aerosol Contact</td>
<td>Liquid</td>
<td>1-2 min</td>
<td>Aerosol cylinder</td>
<td>4,7,9,17,24</td>
<td>Non-chlorinated, ind. grade, flammable, shear strength.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>SPH</td>
<td>Aerosol PS</td>
<td>Liquid</td>
<td>1 hr</td>
<td>Aerosol cylinder</td>
<td>4,7,9,17,24</td>
<td>Pressure sensitive, heat and UV stable.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>SP4H</td>
<td>N/F Non MC</td>
<td>Liquid</td>
<td>1 hr</td>
<td>Aerosol cylinder</td>
<td>4,7,9,17,24</td>
<td>Pressure sensitive, heat and UV stable.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>2 Solvent-Free</td>
<td>Liquid</td>
<td>55</td>
<td>1 hr</td>
<td>Cylinder, spray, brush, roll</td>
<td>2,4,7,10,11,17</td>
<td>Non VOCs, consistent glue line, quick &amp; easy handling.</td>
<td></td>
</tr>
</tbody>
</table>

### Lenderink Technology, 1267 House St., Belmont, MI 49306 (616) 887-8257 www.lenderink.com

- **Dribond Adhesive Film**
  - **Polyester**
  - **Solid Film**
  - **100**
  - **No limit**
  - **FDA approved**
  - **Hot press, High Freq.**
  - **6-9, 11, 16-18, 22**
  - **No VOCs, consistent glue line, quick & easy handling.**

### Form:
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- **G** = Granular
- **S** = Solid
- **E** = Emulsion
- **C** = Cement
- **EM** = Extrudable Mastix

### Use Code:
Numbers in Wood Glue Uses column are keyed to use descriptions below:

1. Assembly gluing
2. Edge gluing
3. Scarf jointing
4. Particleboard
5. Laminated timbers
6. Modified products
7. Plastic laminate
8. Exterior plywood
9. Interior plywood
10. Veneer splicing
11. Boats (marine use)
12. Flush doors
13. Hardboard
14. Tapeback splicing
15. Patching
16. Paper to wood
17. Metal to wood
18. Films & paper overlays
19. Hardboard binder
20. Particleboard binder
21. Fingerjointing
22. Panel-to-frame
23. Subflooring
# GLUING & PRESSING

## WOOD GLUE REFERENCE CHART

<table>
<thead>
<tr>
<th>Brand Name and/or No.</th>
<th>Type</th>
<th>Form</th>
<th>% Solids</th>
<th>Working Life (Hrs. at 70°F.)</th>
<th>Fed. &amp;/or Mil. Specifications Met by Product</th>
<th>Processing Equipment Required</th>
<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>Master Bond Inc., 154 Hobart St., Hackensack, NJ 07601 (201) 343-9883 <a href="http://www.masterbond.com">www.masterbond.com</a></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EP51</td>
<td>Epoxy</td>
<td>L</td>
<td>100</td>
<td>0.1</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1–6, 8–17, 21–24</td>
<td>High physical strength properties, outstanding resistance to water, fuel, etc.</td>
</tr>
<tr>
<td>EP24</td>
<td>Epoxy</td>
<td>L</td>
<td>100</td>
<td>0.3</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1–6, 8–17, 21–24</td>
<td>Same as above.</td>
</tr>
<tr>
<td>EP21LV</td>
<td>Epoxy</td>
<td>L</td>
<td>100</td>
<td>~ 1.0</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1–6, 8–17, 21–24</td>
<td>Same as above.</td>
</tr>
<tr>
<td>EP21LVF</td>
<td>Epoxy</td>
<td>L</td>
<td>100</td>
<td>~ 2.0</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1–6, 8–17, 21–24</td>
<td>Same as above.</td>
</tr>
<tr>
<td>EP21SL-1</td>
<td>Epoxy</td>
<td>L</td>
<td>100</td>
<td>~ 2.0</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1–6, 8–17, 21–24</td>
<td>Recommended especially for teak.</td>
</tr>
<tr>
<td>EP41LV</td>
<td>Epoxy</td>
<td>L</td>
<td>100</td>
<td>~ 2.5</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1–6, 8–17, 21–24</td>
<td>Use when prolonged contact w/ fuels is anticipated.</td>
</tr>
<tr>
<td>X-6</td>
<td>Elastomer modified</td>
<td>C</td>
<td>20</td>
<td>~ 1.0</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>1, 3–6, 9–18, 21–24</td>
<td>For particle boards, plywoods, etc.</td>
</tr>
<tr>
<td>X-9</td>
<td>Elastomer modified</td>
<td>C</td>
<td>30</td>
<td>~ 0.45</td>
<td>Yes</td>
<td>Roller press, etc.</td>
<td>Same as above</td>
<td></td>
</tr>
</tbody>
</table>

| National Casein Co., 601 W. 80th St., Chicago, IL 60620 Tel: (773) 846-7300 www.nationalcasein.com |
| PL-1000 | Crosslinking PVA | L | N/A | Cold, hot press | 4, 7, 22 | Designed for HPL to particleboard laminating. |
| PC-2002 | Crosslinking PVA | L | N/A | ANSI/HPVA (HP-1) Hot press, HF | 1,2,3,7,9,12,22 | Precatalyzed Type II Bond. |
| PC-2365 | Crosslinking PVA | L | N/A | Cold, hot press, HF | 2,3,6,9,12,22 | Precatalyzed Type II Bond. |
| 1862LV | Crosslinking PVA | L | N/A | Cold press | 21 | Dowel gluing, fingerjointing, dry use. |
| PVC 5656 | Copolymer | L | N/A | Laminating line | 18 | For vinyl laminating. |
| 2500, 2238, 1875 | PVA | L | N/A | Cold press | 1,2,22,24 | Fast setting/1875 non-sag. |
| 6000, 6500 | PVA | L | N/A | ASTM D-3024 Cold press | 1, 2, 3, 4, 13, 22 | Low temperature setting, high heat resistance. 5121 PVA. |
| 5121 | PVA | L | N/A | Laminating line | 7, 22 | For HPL laminating. |
| MUF4301-1/DR4611 | Melamine/urea | P | 100 | 4 hours | Membrane press, wood veneers only. |
| PVC 5604 | Copolymer | L | N/A | Laminating/wrapping | 18 | Designed for vinyl wrapping. |
| WP-2200 | Crosslinking PVA | L | N/A | ANSI/HPVA (HP-1) Cold, hot press | 2, 3, 7, 8, 11, 12, 22 | Type I bond used with catalyst. Type I, wood flush doors. |
| CL8098N | Crosslinking PVA | L | N/A | ANSI/HPVA (HP-1) Cold, hot press | 2, 3, 8, 9, 12, 21 | Especially good for fingerjointing, wet use. |
| WP-3300, WP-4379-2 | Crosslinking PVA | L | N/A | ANSI/HPVA (HP-1) Cold, hot press | 2, 3, 8, 9, 12, 21 | Type II bond with catalyst. |
| CI-8800 | Crosslinking PVA | L | N/A | ANSI/HPVA (HP-1) See above | 2, 3, 8, 9, 12, 21 | Type II bond with catalyst. |
| HM-88 | Hot melts | S | 100 | N/A | Hot melt, edge bander | 2 | Fast setting, heat resistant. |
| DR Powder | Series | Urea | P | 100 | 3-4 | MMM-A-188b See above | 2, 3, 6, 7, 9, 12 | Catalyst incorporated. |
| Splyset 200 Series | Melamine | P | 100 | 12-15 | Tapeless splicer | 14 | 3 colors to match various woods. |
| Splyset 400 | Melamine | P | 100 | 10-12 | Tapeless splicer | 14 | Long, open assembly, neutral color. |
| MB-230 | Melamine | P | 100 | 4-6 | MIL-A-46051 PS-51-71 Hot press, HF | 2, 3, 8, 11, 12, 21 | Catalyst incorporated. |
| 4420, NC-230 | Casein | P | 100 | 4-5 | NWWDIA IS-1 Cold press | 7, 9, 12, 13, 22 | Add appropriate amount of water. doors. |

**Form:** L = Liquid  P = Powder  G = Granular  S = Solid  E = Emulsion  C = Cement  EM = Extrudable Mastic

**Use Code:**

redbookonline.com  RED|BOOK
### GLUING & PRESSING

#### WOOD GLUE REFERENCE CHART

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<tr>
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<th>Processing Equipment Required</th>
<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>RAUBOND Universal 122941</td>
<td>EVA Hotmat</td>
<td>G</td>
<td>100</td>
<td>Indefinite</td>
<td>Hot melt glue gun</td>
<td>Edgebander</td>
<td>2, 4, 9, 13, 16</td>
<td>Low viscosity for PVC, ABS, PP, PET, melamine &amp; veneer. Avail. in natural, white.</td>
</tr>
<tr>
<td>RAUBOND Contour 122981</td>
<td>EVA Hotmat</td>
<td>G</td>
<td>100</td>
<td>Contour</td>
<td>Edgebander</td>
<td>2, 4, 9, 13, 16</td>
<td>Low viscosity for contour edgebanding of PVC, ABS, PP, PET paper &amp; polyester at low application temps. &amp; slow feed speeds. Avail. in natural.</td>
<td></td>
</tr>
<tr>
<td>RAUBOND Assembly 124700</td>
<td>EVA Hotmat</td>
<td>G</td>
<td>100</td>
<td>Hot melt glue gun</td>
<td>Edgebander</td>
<td>2, 4, 6, 7, 13, 16, 18, 22, 24</td>
<td>Medium to fast set for general assembly work.</td>
<td></td>
</tr>
<tr>
<td>Practical GS-230</td>
<td>Thermoplastic</td>
<td>S</td>
<td>100</td>
<td>Indefinite</td>
<td>Hot melt glue gun</td>
<td>Bonding</td>
<td>Porous and some non-porous materials.</td>
<td></td>
</tr>
<tr>
<td>Practical GS-269</td>
<td>Thermoplastic</td>
<td>S</td>
<td>100</td>
<td>Indefinite</td>
<td>Hot melt glue gun</td>
<td>Bonding</td>
<td>Production wood glue.</td>
<td></td>
</tr>
<tr>
<td>PAM U1012</td>
<td>EVA</td>
<td>S</td>
<td>100</td>
<td>Unlimited</td>
<td>PAM 190/220</td>
<td>1, 2, 3, 4, 16</td>
<td>Clear economy.</td>
<td></td>
</tr>
<tr>
<td>PAM U11402</td>
<td>EVA</td>
<td>S</td>
<td>100</td>
<td>Unlimited</td>
<td>PAM 190/220</td>
<td>1 — 4, 15, 16, 18, 22</td>
<td>High performance clear.</td>
<td></td>
</tr>
<tr>
<td>PAM U2101</td>
<td>APP</td>
<td>S</td>
<td>100</td>
<td>Unlimited</td>
<td>PAM 500ES PAM 600S</td>
<td>FOAM</td>
<td>Foam to foam, foam to wood.</td>
<td></td>
</tr>
</tbody>
</table>

**Characteristics**

- **Clear economy:**
- **Porous and some non-porous materials:**
- **Production wood glue:**

**Tapes & Tools, P.O. Box 1164, High Point, NC 27261 (336) 884-5371**

- **AD-18**
  - Hot melt
  - G: 100
  - 12 mo.
  - Veneer splicers
  - 10
  - No sanding-good adhesion-no telegraphing.
- **AD-20**
  - Hot melt
  - G: 100
  - 12 mo.
  - Edgebanders
  - 2
  - High-speed edgebanding adhesive for veneer, PVC & melamine.
- **AD-50**
  - Hot melt
  - G: 100
  - 12 mo.
  - Edgebanders
  - 2
  - Multi-purpose veneer—PVC—solid wood, etc.
- **AD-71**
  - Hot melt
  - G: 100
  - 12 mo.
  - Edgebanders
  - 2
  - Clear unfilled hot melt for edgebanding.

**Form:**
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**Use Code:**
- 1. Assembly gluing
- 2. Edge gluing
- 3. Scarf jointing
- 4. Particleboard
- 5. Laminated timbers
- 6. Molded products
- 7. Plastic laminate
- 8. Exterior plywood
- 9. Interior plywood
- 10. Veneer splicing
- 11. Boats (marine uses)
- 12. Flush doors
- 13. Hardboard
- 14. Tapeless splicing
- 15. Patching
- 16. Paper to wood
- 17. Metal to wood
- 18. Films & paper overlays
- 19. Hardboard binder
- 20. Particleboard binder
- 21. Fingerpointing
- 22. Panel-to-frame
- 23. Subfloors
- 24. Fiberboard
## Wood Glue Reference Chart

<table>
<thead>
<tr>
<th>Brand Name and/or No.</th>
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<th>Uses (See Codes Below)</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>AD-905</td>
<td>PVA</td>
<td>L</td>
<td></td>
<td>12 mo.</td>
<td>Assembly</td>
<td></td>
<td>1</td>
<td>Fast drying.</td>
</tr>
<tr>
<td>AD-710</td>
<td>PVA</td>
<td>L</td>
<td></td>
<td>12 mo.</td>
<td>Assembly</td>
<td></td>
<td>1</td>
<td>Medium fast drying.</td>
</tr>
<tr>
<td>AD-815</td>
<td>PVA</td>
<td>L</td>
<td></td>
<td>12 mo.</td>
<td>Assembly</td>
<td></td>
<td>1</td>
<td>Slow drying, high water resistance.</td>
</tr>
<tr>
<td>Cartridge</td>
<td>Hot melt</td>
<td>S</td>
<td>100</td>
<td>12 mo.</td>
<td>Edgelubers</td>
<td></td>
<td>2</td>
<td>Cartridge form hot melt multi-purpose.</td>
</tr>
<tr>
<td>Glue capsules</td>
<td>Polyvinyl acetate</td>
<td>L</td>
<td>80</td>
<td>6 mo.</td>
<td>Dowel gluing</td>
<td></td>
<td>1</td>
<td>Glue in closed capsule for dowel inserting.</td>
</tr>
<tr>
<td>Therm O Web Inc., 770 Glenn, Wheeling, IL 60090 (800) 323-0799 <a href="http://www.thermoweb.com">www.thermoweb.com</a></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Glue Web</td>
<td>Hot melt</td>
<td>Reticulated web</td>
<td>100</td>
<td>Indef.</td>
<td>Laminating sys. heat &amp; pressure apply.</td>
<td>1, 4, 7, 12, 13, 15, 16, 17, 18, 22, 24</td>
<td>Designed for application of plastics &amp; decorative laminates to various core material.</td>
<td></td>
</tr>
<tr>
<td>XR-965</td>
<td>EVA hot melt pellet</td>
<td>G</td>
<td>100</td>
<td>1 yr.</td>
<td>Contour edgebander</td>
<td>2, 4, 7, 16</td>
<td>Low-temp. hot melt for applying PVC, real wood, melamine or polyester on contour edgebanders.</td>
<td></td>
</tr>
<tr>
<td>Type II Granular</td>
<td>EVA hot melt</td>
<td>G</td>
<td>100</td>
<td>1 yr.</td>
<td>Automatic edgebander</td>
<td>2, 4, 7, 16</td>
<td>Multi-purpose hot melt for auto-edgebanders when bonding PVC, real wood, melamine, polyester, HPL.</td>
<td></td>
</tr>
<tr>
<td>Type II Cartridge</td>
<td>EVA hot melt cart.</td>
<td>G</td>
<td>100</td>
<td>1 yr.</td>
<td>Automatic edgebander</td>
<td>2, 4, 7, 16</td>
<td>Same as Type II granular.</td>
<td></td>
</tr>
</tbody>
</table>

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