

GLUING & PRESSING

WOOD GLUE REFERENCE CHART

Brand Name and/or No.	Type	Form	% Solids	Working Life (Hrs. at 70° F.)	Fed. &/or Mil. Specifications Met by Product	Processing Equipment Required	Uses (See Codes Below)	Characteristics
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3M Industrial Adhesives & Tapes Div, Building 220-5E-06, St. Paul, MN 55144 (800) 362-3550 www.3M.com/industrial

Fastbond 5	Neoprene	L	19%	30 minutes	MMM-A-121	Spray, brush, roller	Laminating	Rapid strength build-up, heat and creep resistant bond.
Fastbond 10	Neoprene	L	22%	3 minutes	MMM-A-121	Spray, brush, roller	Laminating	Rapid strength build-up; Brushable with high coverage.
Jet-melt Adhesive 3762	Thermoplastic	L	100%	Indefinite		Applicator	Assembly	Excellent "hot tack", fast setting. Bonds chipboard/wood.
Jet-melt Adhesive 3762-LM	Thermoplastic	L	100%	Indefinite		Applicator	Assembly	Excellent "hot tack", fast setting. Bonds chipboard/wood.
Jet-melt Adhesive 3792	Thermoplastic	L	100%	Indefinite		Applicator	Assembly	Clear, multi-purpose product for wood, corrugated, light weight substrates. Furniture, upholstery, novelties.
Jet-melt Adhesive 3792-LM	Thermoplastic	L	100%	Indefinite		Applicator	Assembly	Clear, multi-purpose product for wood, coated paper, polyolefins and other heat-sensitive materials.
Jet-melt Adhesive 3738	Thermoplastic	L	100%	Indefinite		Applicator	Assembly	General purpose for foundry sand cores, wood bonding, corgated, selected plastics and chipboard.
Scotch-Weld Adhesive TE200	PUR	L	100%	4.5 min.		Applicator	Assembly	Low viscosity. Long open time. Thin glue lines.
Scotch-Weld Adhesive TE015	PUR	L	100%	1.5 min.		Applicator	Assembly	Extrudable. Very fast set time for bonding.
Scotch-Weld Adhesive TE40	PUR	L	100%	2 min.		Applicator	Assembly	Extrudable. Fast set time, low viscosity and strong, flexible bonds for a wide variety of plastics, wood, alum. and glass.
Scotch-Weld Instant CA40	Cyanoacrylate	L	100%	1 - 30 sec.	MIL-A-46050C	Squeeze bottle	Veneer repair	Very fast setting adhesive with excellent adhesion.
Scotch-Weld Instant CA40H	Cyanoacrylate	L	100%	5 - 40 sec.	MIL-A-46050C	Squeeze bottle	Veneer repair	A higher viscosity, slower setting version of CA-40.
Hi-Strength 90 Spray Adhesive	SBR	L	23%	15 min.		Spray, brush, roller	Laminating	High contact bond strength. One minute dry time. High temperature resistance. Decorative laminate bonding.

Adhesive Products Corp., 3020 W. Carroll, Chicago, IL 60612 (773) 722-GLUE (4583)

50-2200	Neoprene Contact	L	20			Spray	7, 9, 13	General purpose - flammable.
50-2201	Neoprene Contact	L	22			Roller/brush	7, 9, 13	General purpose - flammable.
50-2210	Neoprene Contact	L	50			Spray	7, 9, 13	Water base.
50-4506	Hot melt	L	100			Edgebander	2	
50-2205	Neo. Contact 50	L				Spray	7, 9, 13	Non-flammable.
Assemble-Stik 50-6005	Polyvinyl	L		No limit		Bottle, roll coater	1, 2, 9, 16	General purpose assembly; excellent tack.
Assemble-Stik 50-6465	Polyvinyl	L		No limit		Bottle, roll coater	1, 2, 9, 16	General purpose assembly; fast setting.
Plastik 50-6020	Polyvinyl	L		No limit		Cold press, roll coat	7, 9, 12, 22	High pressure laminates; quick clamp.
Vinyl-Stik 50-7400	Polyvinyl	L		No limit			18	Vinyl moulding.
Vinyl Stik 50-7410	Polyvinyl	L				Roll coater	18	Vinyl laminating.
Assemble Stik 50-1020	Modified polyvinyl	L		24	CS-35-61	Hot press or RF	2, 7, 9, 12, 16, 18, 21	Type II adhesive.
Carpenters 11-111	Mod. PVA	L						General assembly.

Adhpro Adhesives Inc., 1650 Industrial Boulevard, Magog, QC Canada J1X 4V9 (819) 847-2269 www.adhpro.com

30575	PVA	L	53-57	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose assembly grade, 5000 cPs.
30057	PVA	L	43-45	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose assembly grade, 6000-7000 cPs, longer open time, Yellow.
30367	Crosslinking PVA	L	49-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose assembly grade, can be used with catalyst 99005 to achieve Type 2 bond.

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30120	PVA	L	48-52	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose assembly grade.
30110	PVA	L	48-52	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	Yellow version of 30120 grade.
30194	PVA	L	45-49	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose assembly, high viscosity.
30063	PVA	L	38-40	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose economy assembly grade and for HPL laminate.
30060	PVA	L	33-35	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose economy assembly grade, long open time, Yellow.
30203	PVA	L	41-45	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	General purpose economy assembly grade, low viscosity, good for chair backs, curved plywood.
30224	Crosslinking PVA	L	48-52	N/A	NWWDA Type 1	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	Precatalysed crosslinking grade for flush doors, veneer and curved plywood.
30231	Crosslinking PVA	L	48-52	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	Lower viscosity version of 30224, also used for fingerjointing.
30213	Crosslinking PVA	L	50-52	N/A	NWWDA Type 1	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	High viscosity flush door adhesive.
30204	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,16,22	Precatalyzed crosslinking grade for general assembly, curved plywood, good on hot press, RF grade.
30828	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	Precatalyzed crosslinking grade, fingerjoint viscosity.
30760	Crosslinking PVA	L	49.5-52.5	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	Used in conjunction with catalyst 99005 to achieve Type 2 bond, hot press, RF grade.
30211	Crosslinking PVA	L	50-51	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,8,9,13,22	Precatalyzed crosslinking, fortified laminating grade viscosity, hot press, RF grade higher water resistant.
30212	Crosslinking PVA	L	50-51	N/A		Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	Precatalyzed crosslinking, fortified fingerjoint viscosity, higher water resistant.
30529	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 1	Roller/Brush/Roll coater/bottle	1,2,3,7,8,9,13,22	Used in conjunction with catalyst 99005, laminating grade, hot press, RF grade.
30530	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 1	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,21,22	Used in conjunction with catalyst 99005, fingerjoint viscosity grade.
30830	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	30204 with wood floor, hot press, RF grade
30829	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	30204 with shell floor, hot press, veneers, RF grade.
30210	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	A more flexible 30204 for miter joints, picture framing.
30201	Crosslinking PVA	L	48-52	N/A	ANSI/HPVA Type 2	Roller/Brush/Roll coater/bottle	1,2,3,7,9,13,22	A higher viscosity version of 30204.

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

2001 Translucent	EVA	Pellets	100	1 yr.		Panel processing centers, edgebander	2, 4, 7, 9, 14, 16, 29	Premium translucent hotmelt used for rigid PVC, ABS melamine, polyester, veneer and solid wood.
2020 Natural	EVA	Pellets	100	1 yr.		Manual contour edgebander	2, 4, 7, 9, 14, 16, 29	Low temp., low viscosity hot-melt suitable for rigid PVC, ABS, veneers, melamine, polyester, solid wood and primed H.P. laminate.
2022 Natural, Brown, Black, White	EVA	Cartridge	100	1 yr.		Holz-Her auto. edgebander	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.
2031 Natural, Brown, White, Black	EVA	Pellets	100	1 yr.		Soft-forming and straight edgebanders	2, 4, 7, 9, 14, 16, 29	General use for wrapping and soft forming veneer and melamine. Suitable for rigid PVC, ABX, melamine, polyester, veneer, solid wood, & primed H.P. laminate.
2041 Natural, White	EVA	Pellets	100	1 yr.		Straight edgebanders	2, 4, 7, 9, 14, 16, 29	General purpose hotmelt used for thick and thin PVC, ABS, melamine, polyester, veneer & solid wood edging.

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Doellken-Woodtape Ltd., 30 Orenda Rd., Brampton, ON Canada L6T 1E9 (800) 461-0061 www.doellken-woodtape.com								
KS 201	EVA Hot Melt	G	100%	1 year		Auto. edgebander	2, 4, 7, 9, 16	Multi-purpose hot melt for auto. edgebanders at medium to high speeds. Straight line & soft form. High heat resistance. PVC, solid wood, veneers, polyester & melamine.
KS 205	Modified EVA Hot Melt	G	100%	1 year		Auto. edgebander	2, 4, 7, 9, 16	Excellent multi-purpose hot melt; high temperature range, higher viscosity than KS 217. All E.B. including HPL.
KS 208	EVA Hot Melt	G	100%	1 year		Auto. edgebander	2, 4, 7, 9, 16	Low cost multi-purpose hot melt for auto. edgebander, suitable for PVC, veneers, polyester, melamine.
KS 217	EVA Hot Melt	G	100%	1 year		Auto. edgebander	2, 4, 7, 9, 16	Multi-purpose hot melt low viscosity, good heat range. For granular feed systems. Suitable for solid wood, veneers PVC, polyester, melamine.
KS 350	EVA Hotmelt	G	100%	1 year		Auto. edgebander	2, 4, 7, 9, 16	Excellent multi-purpose clear hotmelt for auto E/B/ High heat resistance. Straightline and softform apps. Excellent yield, invisible glue line. For thick, thin veneers, melamine, thick & thin PVC, solid wood, and HPL.
AS 223	EVA Hot Melt	G	100%	1 year		Semi Automatic Contour Edgebander	2, 4, 7, 9, 16	Formulated to pre-apply to edgeband. Low application temp. Ideal for PVC, veneer, melamine and polyester.
US 241	EVA Hot Melt	G	100%	1 year		ProfileWrap Equipment, Auto. Edgebander	2, 4, 7, 9, 16	Low viscosity H/M for profile wrap and soft form applications. Specially suited for veneers. Longer open time.
US 253	EVA Hot Melt	G	100%	1 year		ProfileWrap Equipment, Auto. Edgebander	2, 4, 7, 9, 16, 18	Similar to US 241 profile wrap and soft form papers, foils, vinyl.
HKP 21, HKP 25	Hot Melt Cartridge	S	100%	1 year		Holz-Her Edgebander	2, 4, 7, 9, 16	All purpose hot melt for the Holz-Her cartridge system.
HKP 26	PUR Cartridge	S	100%	6 months		Holz-Her Edgebander	2, 4, 7, 9, 16	PUR based hot melt in cartridge for Holz-Her E/Bs. High heat resistance; moisture & solvent resistant. Invisible glue line. Good init. tack. Suitable for thick, thin veneers, melamine, thick, thin PVC, solid wood and HPL.
AD 060	PVAC	L		1 year		Auto. dowel inserter	1, 3	Low viscosity, fast setting, will not clog.
Q645	EVA Hot Melt	G	100	1 year		Auto edgebander, BAZ	2, 4, 7, 9, 16	Clear hot melt. Hi viscosity & heat resistance. Recommended for machines like BAZ and straightline & softform apps. Invisible glue line Suitable for thick, thin veneers, melamine, thick, thin PVC, solid wood and HPL.

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

www.franklinadhesives.com

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 & hot or cold pressing.
Titebond Regular	Aliphatic	L	38-46	N/A	AA-H-00600b	Roll coater, bottle	1, 2, 12, 21	Heat & solvent resistance, 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, 9, 10, 21, 22	Water resistant PVA for ASTM D-3110 wet use performance in RF curing, hot or cold pressing & fingerjointing.
Assembly Glue #65	PVA	L	60	N/A	AA-H-570a AA-H-00600b MMM-A-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.

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Multibond 4000 FF	PVA	L	47-50	N/A	ANSI/HPVA HP-1-2004 Type II water resist., ASTM D 5572 Dry Use, ANSI/HPVA EF-2002 cyclic soak, CARB Phase 2	Roll coater, brush	2, 9	Formaldehyde-free, water-resistant and suitable for the manufacturing of interior plywood, engineered flooring and edge and face gluing.
Multibond MX-90	PVA	L	49-52	N/A	ANSI/HPVA 1994 Type II water resist., NWWDA Type II water resist., Humidity Cycling Test, 180°F Heat Age Test	Roll coater, brush	8, 9	One-part, cross-linking PVA that was designed for hot pressing. It can achieve HPVA Type II bonds and is formulated to help bleed through resistance.
Advantage 425	PVA	L	50-52	N/A	Surpassed ASTM D-5572 wet use finger joint standard (flexure and tension)	Roll coater, brush	21	High performance, water-resistant, two-part crosslinking polyvinyl acetate emulsion adhesive developed for finger jointing.

Georgia-Pacific Resins Inc., P.O. Box 105734, Atlanta, GA 30348 (404) 652-8589 www.gp.com

Resi-Stran	Phenolic resins	L	45-57	7-10 days		Hot press	4, 20	Face & core resins for OSB/waferboard.
Resi-Bond	Phenol-formaldehyde Resins	L	40-50	7-10 days		Hot press	13, 24	PE resin for wet and dry process hardboard.
ResorsaBond	Phenol-resorcinol-formaldehyde resins	L	43-72 Powder (Slurry)	3 mos. - 1 year	ASTM D-2559-99 ANSI/AITC A190.1-992	Liquid/liquid meter-mixing equipment	1, 5, 21	2 component slurry adhesives for lumber fabricating, gluing and end jointing.
Wood Weld	Phenol-formaldehyde	P	100	3-6 mos.		Hot press	4, 20, 24	Face & core powder resin for OSB.
Resi-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

Helmitherm 0405	EVA hot melt	G	100	Indefinite	N/A	Manual 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 Softforming capability.
Helmitherm 494	EVA hot melt	G	100	Indefinite	N/A	Auto. edgebander	2, 4, 7, 9, 16, 24	Inv. glue lines, translucent, unfilled hot melt. Excellent adhesion to all edge materials esp. solid wood. Straightline & softform applications.
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.
Helmibond 776	Waterborne contact cement	E	55	6 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.
Helmibond 4005	Neoprene cement	L	18	6 months	N/A	Spray	1, 2, 4, 6, 7, 13, 16, 17, 24	Gen. purpose, 5 min. drying time, excellent tack.
Helmibond 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.

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Helmibond 834	PVA	E	44	6 months	N/A	Auto. doweling	1	For machines with extrusion type ejectors.
Helmibond 836	EVA	E	36	6 months	N/A	Auto. doweling	1	For machines with spray type ejectors.
Helmibond 853	Type II PVA	E	55	6 months	N/A	Glue spreader	1, 2, 3, 8, 9, 10, 21, 22	Hot & cold pressing, HPL, veneers. Assembly operations where water resistance required. Mix w/5% hardener 0590.
Helmibond 856l	PVA	E	46	6 months	N/A	Squeeze bottle	1, 2, 3, 4, 7, 13, 22	Assembly PVA, <5 min. clamp time possible. Excellent for panel in frame door assembly operations.
Helmibond 859	Urethane	E	44-47	3 months	N/A	Spray	18	Thermofforming adhesive. Colored white for visibility on parts. Smooth finish, high strength, heat resistance.
Helmitherm 499	Hot melt cleaner	G	100	1 year	N/A	Auto. edgebander		Glue pot cleaning compound.
Helmitherm 499C	HM cleaner cart.	S	100	1 year	N/A	Holz-Her edgebander		Cleaner in cartridge form for Holz-Her machines.

Henkel Adhesives, 1345 Gasket Drive, Elgin, IL 60120 (847) 289-2410 www.henkelcorp.com

DORUS KS 205, 217, 224	Hot melt, EVA	G	100		N/A	Hot melt applicator	2, 16	Edgebanding, solid wood.
DORUS KS 360/2, 360/4	Hot melt, Polyolefin	G	100		N/A	Hot melt applicator	2, 16	Edgebanding, heat resistant.
DORUS HKP 21, HKP 25	Hot melt, EVA	G	100		N/A	Holz-Her applicator	2, 16	Holz-Her cartridge edgebanders.
DORUS US 241/3	Hot melt, EVA	G	100		N/A	Hot melt applicator	2, 18	Suited for difficult veneer species.
DORUS US 253/9E	Hot melt, EVA	G	100		N/A	Hot melt applicator	2, 16, 18	Standard for paper wrapping.
DORUS US 276	Hot melt, Polyolefin	G	100		N/A	Hot melt applicator	2, 16, 18	High heat resistance.

Hexion Specialty Chemicals, 180 E. Broad St., Columbus, OH 43215 (614) 225-4000 www.hexion.com

Casco Resin CR 583	UF	L	65	Variable	PS-51-71 TYPE II	Hot press and high frequency	2, 9	Low formaldehyde emitting.
Cascorez 355	PVA	L	45	Indefinite		Cold press and clamps	1, 2, 7, 22	Low cost.
Cascophen SP-6300	Phenolic	L	43	24+	PS-1-74	Hot press; spreader; spray	8	Fast cure; good pre-pressing.
Cascophen SP-C659	Phenolic	L	45	24+	PS-1-74	Hot press; spreader; curtain coater	8, 9	Long stand time tolerance.
Cascophen HB-62	Phenolic	L	60	Indefinite	PS-58-73	Hot press	19	Dry process hardboard.
Cascophen HB-37	Phenolic	L	42	Indefinite	PS-58-73	Hot press	19	Wet process hardboard.
Cascamite 12S	UF	P	100	4	MMMA-188C	Cold press	2, 4, 7, 9, 22	Catalyzed and filled UF powder.
Cascophen G-1131	RF	L	62	4	MILA-4605 TYPE I GRADE A	Hot and cold press	2, 3, 5, 11, 12, 21, 22	High quality, general purpose resorcinol.
Wonderbond WB-957	PVA (X-LINK)	L	50	24	PS 51-71 TYPE II	Hot and cold press RF	1, 2, 7, 9, 21, 22	High frequency cure Type II.
Wonderbond XB-90MI	PVA (X-LINK)	L	51	10-18	PS 51-71 TYPE I ASTM D310-wet use	Hot and cold press RF	1, 2, 7, 9, 21, 22	Type I, low arc tendency on high freq.
Southeastern Adhesives	PVAc, EVA & Urea	L	45-65	Indefinite		Roll, spray, etc	1-7, 9, 10, 12, 14, 16, 18, 20, 21, 22, 24	General purpose and specific wood applications.

ICP Inc.-Veneer Division, 1427-A Boulder Court, Greensboro, NC 27409 (336) 294-9072 www.icplus.com

ICP 58	HMA	S	100	N/A		Edgebander	2, 4, 7, 9, 16	
ICP 33	HMA	S	100	N/A		Edgebander	2, 4, 7, 9, 16, 24	

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| 4. Particleboard | 8. Exterior plywood | 12. Flush doors | 16. Paper to wood | 20. Particleboard binder | 24. Fiberboard |

GLUING & PRESSING

WOOD GLUE REFERENCE CHART

Brand Name and/or No.	Type	Form	% Solids	Working Life (Hrs. at 70° F.)	Fed. &/or Mil. Specifications Met by Product	Processing Equipment Required	Uses (See Codes Below)	Characteristics
ITW TACC, 56 Air Station Industrial Park, Rockland, MA 02370 (800) 503-6991 www.itwtacc.com								
T162	Contact	Liquid	18.5	45 min		Brush, roll	2,4,7,9	High initial grab.
T283	Contact	Liquid	20	60 min		Spray	2,4,7,9	Postform, fast dry, flammable, red/green.
T357	W/B Contact	Liquid	50	2 hrs	0% BOCs, 0% CFCs	Spray, brush, roll	2,4,7,9,18,22	Waterborne, postform, fast dry, premium quality.
T393	N/F Contact	Liquid	8	45 min		Spray	2,4,7,9	Fast dry, hot or cold application.
T162NF	N/F Contact	Liquid	11	45 min		Brush, roll		Fast dry, non-flammable, heat resistance.
T980	N/F Aerosol Contact	Liquid		10 min		Aerosol cylinder	4,7,9,17,24	High temperature, high strength.
C2153	Contact	Liquid	18.5	45 min		Brush, roll	2,4,7,9	High initial grab.
C773-40	Contact	Liquid	18	45 min		Spray	2,4,7,9	Heat, water, chemical resistant.
C2725	Contact	Liquid	20	60 min		Spray	2,4,7,9	Postform, fast dry, flammable, red/green.
C357	W/B Contact	Liquid	50	2 hrs	0% BOCs, 0% CFCs	Spray, brush, roll	2,4,7,9,18,22	Waterborne, postform, fast dry, premium quality.
C2849	N/F Contact	Liquid	8	45 min		Spray	2,4,7,9	Fast dry, hot or cold application.
C3498M	N/F Contact	Liquid	25	45 min		Spray	7,11,17	High heat resistance.
C1560M	N/F Contact	Liquid	11	45 min		Brush, roll		Fast dry, non-flammable, heat resistance.
S158/159	E/F Spray Contact	Liquid	17	4 - 5 min		Auto, Manual Spray	4,7,9,17,24	Industrial premium, High heat resistance, high strength.
S155/156	E/F Spray Contact	Liquid	19	4 - 5 min		Auto, Manual Spray	4,7,9,17,24	Hand spray for variable conditions and a variety of materials.
S140	E/F Spray Contact	Liquid	21	15 - 20 min		Brush, roller, trowel, coater	4,7,9,17,24	Post formable, fast dry, high tack, industrial quality.
S145	20° Flash Brush	Liquid	18	15 - 20 min		Brush, roller, trowel, coater	4,7,9,17,24	Resists static stress, humidity, water, oil and aliphatic solvents.
S170/171	MC N/F Spray	Liquid	28	4 - 5 min		Auto, Manual Spray	4,7,9,17,24	Freeze/thaw stable, long open tack, bonds resist humidity/water.
S100	Brush Contact	Liquid	11	5-10 min		Brush, roller, trowel, coater	4,7,9,17,24	Long open tack, non-flammable and freeze/thaw stable.
S160/ S162	Water Base Contact	Liquid	49/55	45 min		Auto, Manual Spray	4,7,9,17,24	Post formable.
SPHS	N/F Aerosol PS	Liquid		1 hr	<80 g/l VOC	Aerosol cylinder	4,7,9,17,24	Pressure sensitive, heat and UV stable, non-flammable.
S202	E/F Aerosol Contact	Liquid		1-2 min		Aerosol cylinder	4,7,9,17,24	Non-chlorinated, ind. grade, flammable, shear strength.
SPH	Aerosol P/S	Liquid		1 hr		Aerosol cylinder	4,7,9,17,24	Pressure sensitive, heat and UV stable.
SP4H	N/F Non MC Liquid	Liquid		1 hr		Aerosol cylinder	4,7,9,17,24	Pressure sensitive, heat and UV stable.
	2 Solvent-Free	Liquid	55	1 hr		Cylinder, spray, brush, roll	2, 4,7,10,11, 17	
Lenderink Technology, 1267 House St., Belmont, MI 49306 (616) 887-8257 www.lenderink.com								
Dibond 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.

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GLUING & PRESSING

WOOD GLUE REFERENCE CHART

Brand Name and/or No.	Type	Form	% Solids	Working Life (Hrs. at 70° F.)	Fed. &/or Mil. Specifications Met by Product	Processing Equipment Required	Uses (See Codes Below)	Characteristics
Master Bond Inc., 154 Hobart St., Hackensack, NJ 07601 (201) 343-8983 www.masterbond.com								
EP51	Epoxy	L	100	0.1	Yes	Roller press, etc.	1-6, 8-17, 21-24	High physical strength properties, outstanding resistance to water, fuel, etc.
EP24	Epoxy	L	100	0.3	Yes	Roller press, etc.	1-6, 8-17, 21-24	Same as above.
EP21LV	Epoxy	L	100	- 1.0	Yes	Roller press, etc.	1-6, 8-17, 21-24	Same as above.
EP21LVF	Epoxy	L	100	- 2.0	Yes	Roller press, etc.	1-6, 8-17, 21-24	Same as above.
EP21SL-1	Epoxy	L	100	- 2.0	Yes	Roller press, etc.	1-6, 8-17, 21-24	Recommended especially for teak.
EP41LV	Epoxy	L	100	- 2.5	Yes	Roller press, etc.	1-6, 8-17, 21-24	Use when prolonged contact w/ fuels is anticipated.
X-5	Elastomer modified	C	20	- 1.0	Yes	Roller press, etc.	1, 3-6, 9-18, 21-24	For particle boards, plywoods, etc.
X-9	Elastomer modified	C	30	- 0.45	Yes	Roller press, etc.	Same as above	
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	2,3,6,7,9,12,22	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 CL1809HV	Crosslinking PVA Crosslinking PVA	L L		6-20 N/A	ASTM D-3110 NWWDA IS-1	Cold, hot press Cold, hot press	2, 3, 7, 8, 11, 13 6, 7, 12, 22	Type I bond-used with catalyst. Type I, wood flush doors.
WP-3300, WP-4379-2	Crosslinking PVA	L		6-20	ANSI/HPVA (HP-1)	Cold, hot press	2, 3, 6, 7, 9, 12, 21	Especially good for fingerjointing, wet use.
CL-8800	Crosslinking PVA	L		6-30	ANSI/HPVA (HP-1)	See above	2, 3, 6, 7, 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.
700-750	Urea	L		1-48	MMM-A-188b	Cold, hot press	4, 7, 9, 12, 20	Used with catalysts & extenders.
DR Powder	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 Urea	P	100	10-12		Tapeless splicer	14	Long, open assembly, neutral color.
MB-330 MUF 952	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	NWWDA IS-1	Cold press	7, 9, 12, 13, 22	Add appropriate amount of water, doors.

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GLUING & PRESSING

WOOD GLUE REFERENCE CHART

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5638	PVA	L		N/A		Cold/hot nip	4, 7	Designed for cold/hot nip rolling of HPL to PB or MDF.
5695	PVA	L		N/A		Cold press	4, 7, 13	Laminating fire-rated board.
4508	Copolymer	L		N/A		Cold, hot press	17	Metal to wood

PAM Fastening Technology Inc., 2120 Gateway Blvd., Charlotte, NC 28208 (704) 394-3141 www.pamfast.com

PAM U1012	EVA	S	100	Unlimited		PAM 190/220	1, 2, 3, 4, 16	Clear economy.
PAM UX1402	EVA	S	100	Unlimited		PAM 190/220	1 — 4, 15, 16, 18, 22	High performance clear.
PAM U2101 PAM U2191	APP	S	100	Unlimited		PAM 500ES PAM 600S	FOAM	Foam to foam, foam to wood.
PAM U1351	EVA	S	100	Unlimited		PAM 500E, 600	15, 16, 18	Low viscosity.
PAM U6338	Moisture cure urethane	S	100	Unlimited		PAM 500K or KS	1, 2, 3, 4, 6, 7, 11, 17, 22	Thermoset glue line.

Practical Products Co., 3925 Virginia Ave., Cincinnati, OH 45227 (513) 561-6560 www.practicalprods.com

Practical GS-230	Thermoplastic	S	100	Indefinite		Hot melt glue gun	Bonding	Porous and some non-porous materials.
Practical GS-269	Thermoplastic	S	100	Indefinite		Hot melt glue gun	Bonding	Production wood glue.

Rehau Inc., 1501 Edwards Ferry Road N.E., Leesburg, VA 20176 (703) 777-5255 www.rehau.com

RAUBOND Universal 122941	EVA Hotmelt	G	100			Edgebander	2,4,9,13,16	Low viscosity for PVC, ABS, PP, PET, melamine & veneer. Avail. in natural, white.
RAUBOND Cartridge 122951	EVA Hotmelt	C	100			Cartridge-type Edgebander	2,4,9,13,16	For use w/cartridge-type edgebanders. Avail. in natural, white.
RAUBOND Superior 122990	EVA Hotmelt	G	100			Edgebander	2,4,9,13,16	High viscosity, high heat resistance & cold flexibility, suitable for PVS, ABS, PP, PET, solid wood, veneer, melamine & HPL. Also used for soft-forming & post-forming applications. Avail. in clear only.
RAUBOND Premium 122870	EVA Hotmelt	G	100			Edgebander	2,4,9,13,16	Medium-high viscosity suitable for edgebanding PVC, ABS, PP, PET veneer, solid wood, melamine, & primed HPL. Avail. in natural, white, brown, black.
RAUBOND Contour 122981	EVA Hotmelt	G	100			Contour Edgebander	2,4,9,13,16	Low viscosity for contour edgebanding of PVC, ABS, PP, PET paper & polyester at low application temps. & slow feed speeds. Avail. in natural.
RAUBOND Unfilled 122880	EVA Hotmelt	G	100			BAZ, combiformer, edgebander	2,4,9,13,16	High end, high viscosity for automatic edgebanding of PVC, solid wood, veneer & melamine. Avail. in natural.
RAUBOND HPL Primer 124600	EVA Emulsion	G	73			Hand brush	2, 4, 7, 9, 13	For priming of high pressure laminate (HPL) strips, vinyl films, melamine.
RAUBOND Assembly 124700	EVA Hotmelt	G	100			Hot melt glue gun Edgebander	2, 4, 6, 7, 13, 16, 18, 22, 24	Medium to fast set for general assembly work.

Tapes & Tools, P.O. Box 1195, High Point, NC 27261 (336) 884-5371 www.adwood.com

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

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AD-905	PVA	L		12 mo.		Assembly	1	Fast drying.
AD-710	PVA	L		12 mo.		Assembly	1	Medium fast drying.
AD-815	PVA	L		12 mo.		Assembly	1	Slow drying, high water resistance.
Cartridge	Hot melt	S	100	12 mo.		Edgebanders	2	Cartridge form hot melt multi-purpose.
Glue capsules	Polyvinyl acetate	L	60	6 mo.		Dowel gluing	1	Glue in closed capsule for dowel inserting.

Therm O Web Inc., 770 Glenn, Wheeling, IL 60090 (800) 323-0799 www.thermoweb.com

Glue Web	Hot melt	Reticulated web	100	Indef.		Laminating sys. w/heat & pressure applic.	1, 4, 7, 12, 13, 15, 16, 17, 18, 22, 24	Designed for application of plastics & decorative laminates to various core material.
XR-965	EVA hot melt pellet	G	100	1 yr.		Contour edgebander	2,4,7,16	Low-temp. hot melt for applying PVC, real wood, melamine or polyester on contour edgebanders.
Type II Granular	EVA hot melt	G	100	1 yr.		Automatic edgebander	2, 4, 7, 16	Multi-purpose hot melt for auto.edgebanders when banding PVC, real wood, melamine, polyester, HPL.
Type II Cartridge	EVA hot melt cart.	G	100	1 yr.		Automatic edgebander	2, 4, 7, 16	Same as Type II granular.

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