



Titebond Doweling L.V.

Titebond Doweling Glue L.V. is designed for use with automatic doweling equipment. Its low viscosity (140 cps.) allows the appropriate flow through the narrow feed lines and injectors of European-made doweling machinery.

Titebond Doweling sets fast to reduce assembly time, offers excellent strength and provides a translucent glue line. It is formulated for use on solid woods, particleboard, MDF, plywood and other porous materials.



Product Features

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

Physical Properties

Calculated VOC 9.6 g/L

Weight/gallon 9.0 lbs.

Chalk temperature Approximately 45°F.

Flashpoint > 200°F.

Freeze/thaw stability Unstable

pH 4.7

*Chalk temperature indicates the lowest recommended temperature at which the glue, air and materials can be during application, to assure a good bond.

State Liquid

Color White

Dried Film Translucent

Solids 43.6%

Viscosity 140 cps

Storage life 12 months in tightly closed containers at 70°F.

Bond Strength ASTM D-905 (On Hard Maple)

| Temperature | Strength | Wood Failure |
|------------------|-----------|--------------|
| Room Temperature | 2,711 psi | 32% |
| 150°F. Overnight | 1,890 psi | 0% |

Application Guidelines

Application Temperature Above 45°F.

Assembly Time After Glue Application 0-5 minutes (70°F./50% RH)

Method 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.

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.

Caution Statements

CAUTION: EYE AND SKIN IRRITANT. Contains oxydipropyl dibenzoate. Do not swallow. Do not allow eye contact or prolonged skin contact. **FIRST AID:** If swallowed, do not induce vomiting; contact physician. If eye contact occurs, flush with water for 15 minutes. Wash skin contact areas with soap and water. If irritation from eye or skin contact persists, contact physician. For additional information, refer to Material Safety Data Sheet. **KEEP OUT OF THE REACH OF CHILDREN.**

Ordering Information

| Part No. | Size | Weight | UPC | Case UPC | Units Per Package | Packages Per Pallet |
|----------|---------------|--------|--------------|----------|-------------------|---------------------|
| 3817 | 5 Gallon Pail | 47.83 | 037083038170 | | 1 | 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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