



## Product Data Sheet

FORMICA is a registered trademark of the Formica Corporation  
Manufactured by: Choice Brands Adhesives

666 Redna Terrace, Suite 500  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

### F714 White Wood Glue

*A general purpose PVA for wood assembly and for cold pressing applications bonding high pressure laminate to particleboard, plywood and MDF.*

#### Benefits:

Fast setting  
Easily sanded  
No harmful vapors  
Freeze/thaw stable (3 cycles)  
Great Mileage  
Low Chalking temperature  
OTC and SCAQMD compliant

#### Uses:

Joint Assembly  
Cold Press  
Consumer or Professional Use  
Conforms with ASTM D4236

#### Specifications:

Solids Content:	48.5% +/-1.5%	Open Time:	Approx. 5minutes
Viscosity:	6500 +/- 1500 cps	Closed Time:	20 minutes
Weight/Gal:	9.0 lbs +/- 0.2 lbs	Press Time:	Approx. 30 -45 minutes @ 40psi
Color:	White	VOC's:	31 grams / liter (EPA Method 24)
Dried Color:	Translucent	Shelf Life:	12 months
Coverage:	255 sq ft/gal	Chalk Temp:	50 degrees F
Coverage Rate:	6 – 8 wet mils	Packaging:	1 gal, 5 gal, 55 gal, 275 gal

#### Application:

General Assembly: Insure the bondline is smooth and free of any dirt, dust or contaminant. Apply by squeeze bottle, hand roller or glue spreader thoroughly over the surface to be bonded. Snugly fit the parts together and apply pressure by clamping or other pressure source with a minimum of 100 psi. There should be a small amount of squeeze out along the edges.

#### Cold Pressing:

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive film thickness should be set to a depth of 6 to 8 wet mils. With this application, the adhesive may be applied to one substrate.
3. Index the HPL to the particleboard or plywood core as the substrates exits the roll coater
4. At this point, the panel can be cold pressed for 30-45 minutes.

#### Applications to Avoid:

Moisture Resistant Board  
Fire retardant treated board materials  
Metallic, polyester or painted surfaces  
Low pressure melamine surfaces  
Tempered hardboard surfaces

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### Limitations:

F714 is not intended for exterior use or where moisture is likely. For exterior applications use 55-5005. Not for structural or load bearing applications. 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.

### Handling & Storage:

- Thinning is not recommended or required. However, should the adhesive become too thick, use water to thin.
- Use water for clean-up.
- Keep adhesive container closed tightly when not in use. Store closed, line containers where temperature will not be less than 50°F (10°C) and should not exceed 90°F (32°C).
- DO NOT ALLOW PRODUCT TO FREEZE
- Product should not be stored in direct sunlight.

**Consult the Material Safety Data Sheet prior to use.**

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