



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

Golden Glue *EXTERIOR*

Part No: F716Y - Type II Adhesive



F716Y is a pre-catalyzed crosslinking adhesive for exterior grade applications. It can also be used for Radio Frequency bonding and Hot Press Applications. Final bonds of F716Y are water resistant, and will conform to D3/Type 2 specifications.

Benefits:

Exterior Grade Wood Glue
Hot or Cold Press
RF Gluing
OTC Compliant
Cal SCAQMD Compliant

Passes ANSI TYPE 11 Water Resistance
Fast Set
Easily Sandable

Typical Properties:

Solids Content: 49%
Viscosity: 4400 cps
Weight/Gal: 9.0 lbs +/- 0.2 lbs
Color: Yellow
Dried Color: Translucent
Coverage: 255 sq ft/gal
Coverage Rate: 6 – 8 wet mls

Open Time: Approx. 5 minutes
Closed Time: Approx. 20 minutes
Press Time: Approx. 30 - 45 minutes @ 40psi
VOC's: 2 grams / liter (EPA Method 24)
Shelf Life: 6 months
Chalk Temperature: 50 degrees F
Packaging: 1 gal, 5 gal, 55 gal, 275 gal

Qualifies for Leed Points 3.2, 4.1 and 4.4

Application Instructions:

Hot or Cold Press

1. Apply adhesive via Black Brothers A2158 roll coater (glue spreader). For best results use dual durometer rollers to insure thorough coverage.
2. Apply 6 – 8 wet mls onto the board surface.
3. Working time of the adhesive is 5 – 7 minutes and closed time to move the stack is 15 – 20 minutes. For cold press operations, 1- 2 hours of press time at 40 – 50 psi is recommended. Delay machining for 8 – 12 hours once out of press.
4. For hot press applications, set temperature at 180 – 200 deg F with dwell of 69 – 90 seconds. Wait 15 minutes after substrate has cooled for machining.

Assembly

1. Apply 6 mls (or at rate of 255 sq ft/gal) via glue spreader, brush/roller or squeeze bottle.
2. The joint have been prepped to fit together snugly.
3. Open time to bring the glue joint together is 5 - 8 minutes.
4. Apply pressure to the bondline with pressure recommendations being 100 – 150 psi for soft woods, 125 – 200 for medium density woods and 150 – 250 psi for hardwoods.

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Substrates to Avoid:

Moisture Resistant Boards
Tempered Hardwood Products
Metallized, polyester or painted surfaces
Low Pressure melamine
Fire retardant treated board

Limitations:

Not for structural or load bearing applications. Do not use when temperature, glue or materials are below 55°F. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form. F716Y is not intended for use under conditions submersion or applications below the water line.

Clean Up:

Warm soapy water while adhesive is still wet
Used diluted ammonia to clean dried adhesive
Washer water is NRCA non-hazardous

Storage Conditions:

Do not subject to freezing conditions
Insure adhesive and substrates are conditioned above 65 deg F.
Best results are achieved between 70 and 85 deg F.

Precautions:

For consumer or professional use. Keep out of reach of children.

Please refer to the Material Safety Data Sheet for further safety information

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