

Titebond®
THE PRO'S ADVANTAGE™

670

RESILIENT FLOORING ADHESIVE

Titebond® 670 provides a strong and permanent bond on heavy traffic areas including commercial, institutional and industrial installations. It is durable against solid, rubber backed tile, LVT, and cork underlayment. It may be used for indoor installations over standard construction surfaces, and has no unpleasant or lingering odor. Titebond 670 is perfect for wet lay installations, and can also be rolled for pressure sensitive installations. Titebond 670 does not contain volatile solvents, hazardous materials or carcinogens, and it will not promote plasticizer migration. It is freeze-thaw stable, non-flammable and non-toxic. Titebond 670 provides the professional installer with a fast setting, water-resistant and environmentally-safe adhesive.

- **DESIGNED FOR LVT, SOLID VINYL TILE & RUBBER FLOORING**
- **STRONG PERMANENT BOND**
- **FAST SETTING**
- **DOES NOT PROMOTE PLASTICIZER MIGRATION**
- **CAN BE ROLLED FOR PRESSURE SENSITIVE INSTALLS**

Features and Benefits

- Provides a strong, permanent bond to solid, rubber backed tile and LVT
- Non-flammable
- Water-resistant
- Environmentally safe
- Guaranteed against discoloration
- May be used for indoor installations over standard construction surfaces



PHYSICAL PROPERTIES (TYPICAL)

Type: Latex	Calculated VOC: 13.9 g/L
Color: Beige	Weight/gallon: 10.4 lbs.
Solids: 71%	Viscosity: Trowel Grade
Flashpoint: >200°F (Pensky-Martens Closed Cup)	
Freeze/Thaw stability: Stable (5 cycles at 20° F.)	
Storage life: 24 months in tightly closed container	

SUBFLOOR PREPARATION

All substrates must be clean, dry, structurally sound, properly cured and free of dirt, oil, paint, old adhesive, wax, sealers and curing agents. General scouring with 20 grit or #3 1/2 open-coat sandpaper will remove most compounds. All loose materials must be vacuumed from the surface after scouring. The subfloor must be flat to a tolerance of 3/16" in a 10' radius. Grinding concrete floors is preferred over the use of filling compounds. If filling/flattening compounds are used, they must be Portland-based cementitious material and have a compressive strength equal to or greater than 3000 psi when cured. Use of Titebond 670 over lightweight concrete and all gypsum-based materials requires the use of acrylic-based concrete primer or equivalent prior to application of adhesive.

INSTALLATION

Wet Lay Method - Porous Substrates

Open time is between 10 and 30 minutes. Adhesive must transfer to backing in order to promote adhesion. Employ a 100 pound roller in both directions within one hour of installation to work out any air pockets and produce solid bonding. It is recommended to use water to remove adhesive spots, and clean tools when adhesive is still wet. Removal of dry adhesive may require mineral spirits or other solvents. Follow solvent manufacturer's safety precautions.

Concrete subfloors should be tested for moisture prior to installation. Moisture levels cannot be greater than 8 lbs./1000sq.ft./24 hours on a Calcium Chloride Test (ASTM F1869), or relative humidity (RH) of 90% or less when tested with an in situ probe (ASTM F2170). When installing directly over wood subfloors the moisture content of the subfloor should be 13% or less. Installation over single-layer wood subfloors is not recommended.

Pressure Sensitive Method - Non-Porous Substrates

When using a 3/8" nap, coverage will be approximately 150 – 200 square feet per gallon, depending on the amount of pressure used to apply the adhesive. The adhesive offers adequate strength to bond an LVT floor as a pressure sensitive when given up to 72 hours of open time. Allow adhesive to dry until a firm touch does not transfer adhesive. Keep the adhesive free from dust and dirt during long open times. Dust and dirt will negatively affect strength.

When using a 1/16 x 1/32 x 1/32 trowel, coverage will be approximately 250 to 300 sq. ft. per gallon. Spread adhesive and let it become dry to touch, where there is no transfer to fingers. This will take approximately 35-90 minutes depending on temperature and humidity. Do not install floor before adhesive is ready. Installing product too soon can lead to slippage and gaps between pieces. Install LVT per manufacturer's directions with no more than three hours of open time.

APPLICATION GUIDELINES

LVT and Rubber Flooring

- Trowel Size - 1/16" X 1/16" X 1/16" Square-notch
- Coverage - 150 Sq. ft./gallon



Cork underlayment

- Trowel Size - 1/16" X 1/16" X 1/16" Square-notch
- Coverage - 150 Sq. ft./gallon



LVT/Pressure Sensitive

- Trowel Size - 1/16" X 1/32" X 5/64" U-notch
- Coverage - 250-300 Sq. ft./gallon



LVT/Pressure Sensitive

- Nap Size - 3/8" Nap
- Coverage - 150-200 Sq. ft./gallon



LIMITATIONS

Do not use over high alkaline concrete (over 9.0 pH). Do not use to bond two non-porous substrates unless using pressure sensitive method. Product must dry to build strength. Do not store below freezing. Use in well-ventilated area. Warranty covers subfloor moisture resistance but does not cover damage from flooding or other surface moisture contamination.

ORDERING INFORMATION

Product Code	Size	Units Per Case	Weight	Cases Per Pallet
9246	Gallon Plastic Pail	4	45 lbs.	30
9244	4 Gallon Plastic Pail	1	44 lbs.	36

WARNING: EYE AND SKIN IRRITANT. 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 eyes with water for 15 minutes. Wash skin contact areas with soap and water. If irritation from eye or skin contact areas persist, contact physician. For additional information, refer to Material Safety Data Sheet. **KEEP OUT OF THE REACH OF CHILDREN.**

IMPORTANT NOTICE: Our recommendations, if any, for the use of this product are based on tests believed to be reliable. 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.

WARRANTY: The full warranty for Titebond 670 and all Titebond flooring products can be obtained at www.Titebond.com or by calling 1.800.347.4583.

TITEBOND.COM

©2014 FF960

Franklin International

Sales: 1.800.669.4583 / Technical: 1.800.347.4583

