

# 771-STEP

## WOOD FLOORING ADHESIVE

Titebond® 771-Step Adhesive, Moisture & Sound Control combines the superior properties of a moisture cure adhesive with the ability to be used as a moisture and sound control system, primarily for wood floor installations. This product enables the installer to protect the floor from subfloor moisture and glue it down in one application, saving labor and time. Once cured, the product is water-resistant and is not adversely affected by exposure to moisture or water. It provides a tough, flexible and tenacious bond to a variety of substrates.

Alternatively, Titebond 771-Step can be used just as a one-part adhesive simply by using a different sized trowel. Please see specific application guidelines in this document for details and instructions. It can also be combined with Titebond 531 or Titebond 531 PLUS Moisture Control Systems to achieve unlimited moisture protection. The elastomeric characteristics allow the adhesive to move with the wood as it expands and contracts over the life of the floor. It has unparalleled green grab and strength development, spreads easily, and cleans-up better than urethane products. Titebond 771-Step is most often used to secure solid wood, bamboo, cork, and engineered hardwood flooring. It can also be used to install plywood, ceramic tile, marble, cork underlayments, and stone inlays for residential and commercial applications.

- **FORMULATED FOR WOOD FLOORING INSTALLATION, MOISTURE AND SOUND CONTROL**
- **ONE-COAT APPLICATION PROCESS TO ACHIEVE FULL ALL-IN-ONE PERFORMANCE**
- **EXTREMELY RAPID CURE RATE**
- **VOC-COMPLIANT WITH ALL FEDERAL AND STATE REGULATIONS AS WELL AS THE SCAQMD**
- **ACHIEVES IIC RATING OF 67 AND STC RATING OF 69 FOR SOUND PERFORMANCE**

### Features and Benefits

- Advanced polymer adhesive technology
- 100% solids - no water or solvent
- Outstanding green grab
- Trowels easily
- Mold and mildew resistant
- Non-slump formula to significantly reduce hollow and popping spots
- Fast strength development saves time
- Easily removed with mineral spirits, dry or moist towel
- Highly moisture-resistant
- Will not cause dimensional changes in wood flooring
- Excellent bond strength
- Unaffected by freezing temperatures
- Product is FloorScore certified by SCS

### Ordering Information

Product Code	Size	Units Per Package	Weight	Packages Per Pallet
7719	3.5 Gallon Metal Pail	1	42.79 lbs.	36



## PHYSICAL PROPERTIES (TYPICAL)

<b>Type:</b> Advanced polymer	<b>Calculated VOC:</b> 0 g/L (<50 g/L during cure)
<b>Color:</b> Light tan	<b>Weight/gallon:</b> 11.2 lbs.
<b>Solids:</b> 100%	<b>Viscosity:</b> 100,000 cps
<b>Flashpoint:</b> >200°F (Pensky-Martens Closed Cup)	
<b>Freeze/Thaw stability:</b> Not affected by freezing	
<b>Storage life:</b> 1 year 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. Hollow spots, popping spots and squeaks are related to unevenness in the subfloor. 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 adhesive over light weight concrete and all gypsum-based materials requires the use of an approved concrete primer prior to application of adhesive.

### INSTALLATION: ONE-STEP ADHESIVE, MOISTURE AND SOUND CONTROL METHOD

Follow all instructions for subfloor preparation. Trowel 771-Step and immediately install the wood flooring into the wet adhesive. Remaining planks must be placed firmly into adhesive. Planks that are not flat should be weighted for several hours. Be sure to cover entire area to be installed. Remember Titebond 771-Step is a rapid cure adhesive. Open time is 30-45 minutes, depending on relative humidity. Be sure to seat the flooring into the adhesive firmly. Any low or high spots may cause voids in the adhesive preventing complete coverage and moisture control, therefore voiding the warranty. Roll the floor with a 150 lb. roller within 30 minutes of application to assist in creating a continuous layer to ensure total coverage and protection for moisture control. The moisture content limit for installations is 15 lbs. or less/1000 sq. ft./24 hours per a Calcium Chloride Test (ASTM F1869) or 85% relative humidity (RH) when tested with an in situ probe (ASTM F2170). To ensure protection against subfloor moisture, 100% substrate coverage and adhesive transfer is required.

### INSTALLATION: ADHESIVE ONLY METHOD

Follow all instructions for subfloor preparations. Titebond 771-Step must be installed using the "wet lay" method. This product cures and builds strength very quickly. Open time is approximately 30 minutes depending on humidity and temperature. Do not trowel more adhesive than can be installed within 30 minutes. Use recommended trowel for installation (see trowel recommendations). In the "wet lay" method you do not flash the adhesive; you begin laying the wood flooring immediately after troweling the adhesive. Once the adhesive has been troweled, the wood flooring may be installed immediately into the wet adhesive. To reduce slippage, secure the first starter row with Titebond Tape. Remaining planks must be placed firmly into adhesive. Planks which are not flat should be weighted for several hours. Normally, ultimate strength will be reached within 24 hours. Wait at least one day before finishing an unfinished floor. Do not walk on the floor during installation. NOTE: Do not trowel more adhesive than can be covered within 30 minutes. In the wet lay method, you should not work on top of the wood.

Titebond 771-Step may be used for above-, on- and below-grade applications and on all substrates listed in this specification guide. All applications are susceptible to moisture and should be tested for moisture prior to installation in several locations within the installation area. Acceptable conditions of concrete for above-, on- and below-grade applications are:

- Less than 3 lbs./1000 sq.ft./24 hours on a Calcium Chloride Test (ASTM F1869)
- Less than a reading of 4.5 on a Tramex Concrete Moisture Encounter
- Relative humidity (RH) of 75% or less when tested with an in situ probe (ASTM F2170)

Acceptable conditions of wood substrates are a moisture reading of less than 12% or be no more than 4% different from the flooring being installed when using a Tramex, Delmhorst or equivalent wood moisture meter.

If subfloor moisture conditions do not meet above guidelines at the time of flooring installation or they could exceed them at any time after installation then a Titebond moisture control system should be used.

## APPLICATION GUIDELINES

### MOISTURE CONTROL & ADHESIVE METHOD:

#### All engineered plank flooring

- Trowel Size - 1/4" x 3/16" V-notch (Saw tooth)
- Coverage - Approximately 35 sq. ft. per gallon



#### Solid flooring and bamboo up to 5/8"

- Trowel Size - 1/4" x 1/4" V-notch (Saw tooth)
- Coverage - Approximately 30 sq. ft. per gallon



#### Cork Underlayment

- Trowel Size - 1/16" x 1/16" x 1/16" (Square-notch)
- Coverage - Approximately 125 to 185 sq. ft. per gallon



### ADHESIVE ONLY METHOD:

#### All engineered plank flooring

- Trowel Size - 3/16" x 1/4" x 11/16" (c-c V-notch)
- Coverage - Approximately 65 sq. ft. per gallon



#### Solid flooring and bamboo with a width of 3" or less and measuring 5/8" or less in thickness

- Trowel Size - 3/16" x 1/4" x 1/2" (c-c V-notch)
- Coverage - Approximately 50 sq. ft. per gallon



#### Solid flooring and bamboo with a width greater than 3" and measuring 5/8" or less in thickness

- Trowel Size - 3/16" x 3/16" x 3/16" (Square-notch)
- Coverage - Approximately 35 sq. ft. per gallon



#### All parquets measuring less than 3/4" thickness

- Trowel Size - 1/8" x 1/8" x 1/8" (Square-notch)
- Coverage - Approximately 65 sq. ft. per gallon



#### Cork Underlayment

- Trowel Size - 1/16" x 1/16" x 1/16" (Square-notch)
- Coverage - Approximately 125 to 185 sq. ft. per gallon



## CLEAN UP

Wet adhesive may be cleaned up or removed using a solvent such as alcohol or mineral spirits. Do not allow adhesive to cure on surface of the flooring, tools, or equipment. Follow solvent manufacturer's directions when working with solvents. Cured adhesive will be difficult to remove. For specific cleaning instructions, call Franklin Technical Service at 1.800.347.4583.

**CAUTION STATEMENT: EYE AND SKIN IRRITANT.** Contains silyl terminated polymers. 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 area persists, contact physician. Product releases methanol during cure. 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 771-Step and all Titebond flooring products can be obtained at [www.Titebond.com](http://www.Titebond.com) or by calling 1.800.347.4583.

TITEBOND.COM

©2013 FF944

**Franklin International**

Sales: 1.800.669.4583 / Technical: 1.800.347.4583

