

771-STEP

Advanced Polymer Wood Flooring Adhesive

- **Formulated for Wood Flooring Installation, Moisture & Sound Control**
- **One-Coat Application Process to Achieve Full All-In-One Performance**
- **VOC-compliant with All Federal & State Regulations Including SCAQMD**
- **Achieves IIC Rating of 69 & STC Rating of 67 for Sound Performance**

FEATURES AND BENEFITS

- Advanced polymer adhesive technology
- 100% solids - no water or solvent
- Non-slump formula to significantly reduce hollow and popping spots
- Mold, mildew & moisture resistant
- Excellent bond strength
- FloorScore® certified by SCS
- Unaffected by freezing temperatures

ORDERING INFORMATION

- 3.5 Gallon Plastic Pail / 1 Unit Per Package
42.79 lbs. / 36 Pails Per Pallet
Product Code: 7719
- 20 oz. Sausage Pack / 20 Units Per Package
36.72 lbs. / 44 Packages Per Pallet
Product Code: 7712
- 771-Step 2-Pack / .75 Gallons Per Unit
2 Units Per Pack / 2 Packs Per Overpack Box
40.05 lbs. / 44 Overpack Boxes Per Pallet
Product Code: 77115
- 771-Step 4-Pack / .75 Gallons Per Unit
4 Units Per Pack / 1 Pack Per Overpack Box
39.15 lbs. / 48 Overpack Boxes Per Pallet
Product Code: 7713
- Sausage Cartridge Gun / 6 Units Per Package
3.0 lbs. / 30 Packages Per Pallet
Product Code: 17842

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 has no moisture limitations and calcium chloride or in-situ RH testing is not necessary. 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. Being able to glue down and control moisture and sound in one application saves both labor and time.

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 ultimate moisture protection. 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.

**EXTREMELY
RAPID
CURE RATE**

**UNLIMITED
MOISTURE CONTROL
PROTECTION**

**EXCELLENT
BOND
STRENGTH**



Titebond®
THE PRO'S ADVANTAGE™

PHYSICAL PROPERTIES (TYPICAL)

- **Type:** Advanced polymer
- **Color:** Light tan
- **Solids:** 100%
- **Flashpoint:** >200°F (Pensky-Martens Closed Cup)
- **Freeze/Thaw stability:** Not affected by freezing
- **Storage life:** 1 year in tightly closed container stored above 60°F
- **Calculated VOC:** 0 g/L (20 g/L during cure)
- **Weight/gallon:** 11.2 lbs.
- **Viscosity:** 100,000 cps

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 and immediately install the wood flooring firmly into the wet adhesive. Planks that are not flat should be weighted for several hours. 100% adhesive coverage, with no voids, is required to qualify for the all-in-one installation warranty. Product is formulated to cure rapidly. Open time is 25-45 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. DO NOT apply over standing water. Roll the floor with a 150 lb. roller within 30 minutes of application to assist in creating a continuous adhesive layer to ensure total coverage and protection for moisture control.

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. 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 the adhesive is not flashed. Begin laying the wood flooring immediately after troweling the adhesive. Once the adhesive has been troweled, the wood flooring should 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.

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 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. If the entire floor was not installed using 771-Step for moisture and sound control, then it will not provide moisture protection for the floor.

APPLICATION GUIDELINES

ADHESIVE, MOISTURE & SOUND CONTROL INSTALLATION

	TROWEL SIZE	COVERAGE
All engineered plank flooring.....	1/4" x 3/16" V-notch (saw tooth)	35 sq. ft. per gallon
Solid flooring & bamboo up to 5/8".....	1/4" x 1/4" V-notch (saw tooth)	30 sq. ft. per gallon

ADHESIVE ONLY INSTALLATION

All engineered plank flooring.....	3/16" w x 1/4" d x 11/16" c-c (or 1/2" space) V-notch	65 sq. ft. per gallon
Solid flooring & bamboo with a width of 3" or less & 5/8" or less in thickness.....	3/16" w x 1/4" d x 1/2" c-c (or 5/16" space) V-notch	50 sq. ft. per gallon
Solid flooring & bamboo with a width greater than 3" & 5/8" or less in thickness.....	3/16" x 3/16" x 3/16" Square-notch	35 sq. ft. per gallon
All parquets measuring less than 3/4" thickness.....	1/8" x 1/8" x 1/8" Square-notch	65 sq. ft. per gallon



V-notch (saw tooth)

V-notch

Square-notch

CLEAN UP

Wet adhesive may be cleaned up or removed using alcohol, mineral spirits or Titebond Adhesive Remover Cleaning Wipes. 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 or impossible to remove. For specific cleaning instructions, call Franklin Technical Service at 1.800.347.4583.



WARNING. Causes eye irritation. May cause an allergic skin reaction. Wear protective gloves. Avoid breathing vapor. Wash hands thoroughly after handling. **FIRST AID:** IF ON SKIN: Wash with plenty of soap and water. Wash contaminated clothing before reuse. If skin irritation or rash occurs: Get medical attention. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. If eye irritation persists: Get medical attention. Dispose of contents and container in accordance with all local, regional, national and international regulations.

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 or by calling 1.800.347.4583.

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VISIT WWW.TITEBOND.COM FOR THE MOST UP-TO-DATE PRODUCT INFORMATION



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