

771-STEP

Advanced Polymer Wood Flooring Adhesive

- **Zero VOCs, Contributes Toward Satisfying Low Emitting Materials Credit Under LEED®**
- **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
- FloorScore® certified by SCS
- Will Not Freeze

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 4-Pack / .75 Gallons Per Unit
4 Units Per Pail
41.18 lbs. / 36 Pails Per Pallet
Product Code: 7714
- Sausage Cartridge Gun / 1 Unit Per Package
3.0 lbs. / 30 Packages Per Pallet
Product Code: 17844

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. Its elastomeric properties allow the adhesive to flex with the wood as it expands and contracts, ensuring long-lasting performance. It offers unparalleled initial grab and strength development, spreads easily, and is easier to clean up 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, marble, cork underlays, and stone inlays for residential and commercial applications. This product has no moisture limitations, and calcium chloride or in-situ RH testing is not necessary. Once cured, this water-resistant product is not adversely affected by exposure to moisture or water. This all-in-one solution saves both time and labor by combining gluing, moisture control, and sound control in a single application.

Alternatively, Titebond 771-Step can be used simply as a one-step adhesive by using a different-sized trowel. Details about specific application guidelines and instructions are found in this document. 771-Step can also be combined with Titebond 531 PLUS Moisture Control System to achieve ultimate moisture protection.

**EASY
CLEANUP**

**UNLIMITED
MOISTURE CONTROL
PROTECTION**

**EXCELLENT
BOND
STRENGTH**



Titebond®
THE PRO'S ADVANTAGE

PHYSICAL PROPERTIES

- **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 below 70°F
- **Calculated VOC:** 0 g/L as sold (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 into the wet adhesive. Planks that are not flat should be weighted for several hours. To qualify for the all-in-one installation warranty, there must be 100% adhesive coverage, with no voids. 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. DO NOT leave gaps without adhesive at chalk lines. Spread past the line and knock down ridges with the back of the trowel. The adhesive will press into the pores of the concrete and ensure moisture protection coverage for the next run or next day of continuing installation.

*If installing a product with a hollow back, STOP! You will not achieve the 100% coverage required for the moisture warranty. Use Titebond 771-Step OVER installation of Titebond 531 Plus instead.

INSTALLATION: ADHESIVE ONLY METHOD

Follow all instructions for subfloor preparations. Titebond 771-Step must be installed using the "wet lay" method with no adhesive flashing. 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). Trowel and immediately install the wood flooring 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:

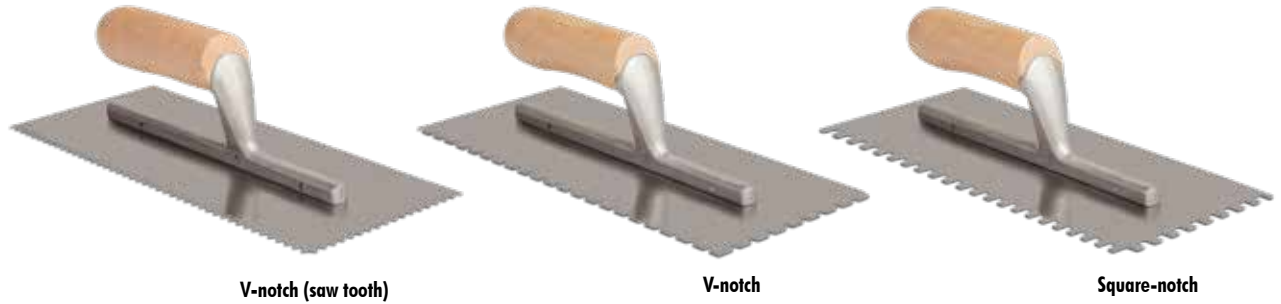
- Less than 3 lbs./1000 sq.ft./24 hours on a Calcium Chloride Test (ASTM F1869)
- Relative humidity (RH) of 75% or less when tested with an in situ probe (ASTM F2170)

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 moisture meter made to test wood moisture levels.

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 the 771-Step one-step adhesive, moisture and sound control method then it will not provide moisture protection for the floor.

APPLICATION GUIDELINES

| ADHESIVE, MOISTURE & SOUND CONTROL INSTALLATION | TROWEL SIZE | COVERAGE |
|--------------------------------------------------------------------------------|-------------------------------------------------------|-----------------------|
| Engineered plank flooring up to 5/8" | 1/4" x 3/16" V-notch (saw tooth) | 35 sq. ft. per gallon |
| Engineered plank flooring > 5/8" to 3/4" | 1/4" x 1/4" Square notched trowel | 20 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 | | |
| Engineered plank flooring up to 5/8" | 3/16" w x 1/4" d x 11/16" c-c (or 1/2" space) V-notch | 65 sq. ft. per gallon |
| Engineered plank flooring > 5/8" to 3/4" | 3/16" x 3/16" x 3/16" Square notch trowel | 35 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 > 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 1/4 inch in thickness | 1/8" x 1/8" x 1/8" Square-notch | 65 sq. ft. per gallon |
| All Parquets measuring 1/4 inch thick to 3/4 inch thickness | 3/16" x 3/16" x 3/16" Square notch trowel | 35 sq. ft. per gallon |
| Cork underlayments | 1/8" x 1/8" Square notched trowel | 65 sq. ft. per gallon |



CLEANUP

Wet adhesive may be cleaned up or removed using water, 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 or impossible to remove. For specific cleaning instructions, call Franklin Technical Service at 1.800.347.4583.

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.



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



Franklin International

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