



Hybond®

PRODUCT DATA SHEET



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Cincinnati, OH 45215
Customer Service: (800) 330-5566

Product Number: **CBA-655**

Description: **Aerosol Contact Adhesive, Low VOC**

Typical Physical Properties:

Adhesive	Flam / Flam (Propellant / Adhesive)	VOC	<55% by weight
Dry Time	4-6 Minutes	Coverage Rate	3.0 dry grams/sq. ft. minimum
Solvents	Propane	Clean Up	Choice Brands 689 or Citrus Cleaner
Open Time	60 minutes	Shelf Life	1 Year in unopened container
Color	Natural	Pattern	Web
Flash Point	N/A	Packaging	13 oz

Qualifies for LEED®-NC&CI EQ Credit 4.4: laminating adhesives shall contain no added urea formaldehyde resins

Properties:

- California VOC compliant
- Non-Chlorinated
- Adjustable Spray Pattern
- Good heat resistance
- High solids
- Long Open Time
- Portable system
- Easy application control

Applications:

CBA-655 is designed for permanent bonding of materials where immediate bond strength and good heat resistance are required. CBA-655 is suitable for permanent bonding a variety of materials. For bonding to metal, surface preparation is very important – surface must be degreased and lightly abraded with fine abrasive or non-woven material. Always test CBA-655 to determine suitability for your particular application prior to use in production.

NOT RECOMMENDED for use with plasticized vinyls, flexible plastics, expanded/ extruded polystyrene, PE or PP.

Avoid application equipment containing aluminum or copper.

Aerosol Application Instructions:

1. Prepare the surface to be bonded, ensuring both faces are clean, free of dust, dirt and grease.
2. Hold spray can at a constant distance of between 6-10 inches (150-250mm) from the surface, allowing adhesive to cobweb across the surface with minimal overlap for thick laminates or approximately 50% to 70% overlap to successive passes for thin laminates to reduce the risk of telegraphing (note- correct coat weight must be achieved)
3. Maintain a constant speed of application during spraying applying a consistent and thorough coating without allowing the adhesive to puddle or heavily wet the surface. Maximum bond

strength is achieved with coverage of between 80-100% with a recommended coat weight of minimum 2.5 dry grams per square foot.

4. Maximum adhesion will be obtained by spraying mating faces at 90° angle to each other, i.e. one face vertically, the other face horizontally. Double coating perimeter of face and edges is recommended.
5. Do not angle spray gun or move in an arc while spraying. Hold gun at 90° angle to surface while spraying. Release trigger at end of each pass to optimize coverage.
6. Apply a minimum of 3.0 dry grams/sq. ft. For best results, apply two coats of adhesive to any porous surface; one base coat and a secondary top coat. This ensures adequate layup particularly on CARB 2 PARTICLEBOARD and other similar surfaces. Allow the second coat to completely dry before assembly. The adhesive should cover 80% of the surface of the substrate. The coated substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be re-applied to these areas.
7. Make sure to coat all exposed edges and corners with two coats of adhesives.
8. Substrates which are difficult to bond, e.g. metal faces, or products with memory, may require a 2nd coat. Best results are obtained by double coating rather than one heavy coat; which may result in heavy wetting of surface and extended drying times.
9. Allow adhesive to dry (time may vary due to humidity and temperature variations). Test for dryness using back of hand only – surface should be tacky but adhesive should not transfer to the skin. Position substrates correctly and press together working from center outwards. Apply adequate pressure using nip roller, of 75mm hand roller and body weight as a minimum, in order to achieve at least 35 psi at the glue line. Note that repositioning is not possible after contact has been made.
10. Immediate trimming/routing is possible. Full strength is achieved after 24-48 hours depending on temperature and humidity.

Special Precautions:

For best results store aerosols above 50° F (10° C). Allow substrates to warm to normal room Temperature 70° F (21° C) for 48 hours before bonding. Keep aerosol off cold concrete floors during use. If adhesive is expelled wet or as a jet, aerosol is too cold – move to a warm environment and allow to thoroughly warm up before reusing.

Caution:

Use in only well ventilated areas.
Do not thin or reactivate with solvents.
Do not puncture or incinerate canister.
Do not expose to extreme heat over 100° F (38° C).
Keep away from sources of ignition.
Test for suitability before use.
Do not store in direct sunlight.

Please Refer To The Safety Data Sheet For Further Information.

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