



Hybond®

PRODUCT DATA SHEET



666 Redna Terrace, Suite 600
Cincinnati, OH 45215
Customer Service: (800) 330-5566

Product Number: **HY-31 / HY-31 G**

Description: **Neoprene Water Base Contact Adhesive**

Typical Physical Properties:

Viscosity	600 cps	VOC	53 g/l (EPA Method 24)
Dry Time	15-30 Minutes	Coverage Rate	2.5 dry grams/sq. ft. minimum
Solids	54% +/- 1%	Clean Up	Warm, soapy water
Open Time	60 minutes	Shelf Life	1 Year in unopened container
Color	Natural / Green	VHAP	0.05 lbs/lbs of solids
Solvents	Organic solvents	Density	9.2 wt/gl
Flash Point	None	Packaging	1 gal, 5 gal,
Coverage	375-450 sq. ft./gallon		54 gal and tote containers

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

Properties:

- Excellent room temperature contactability
- Excellent mileage,
- Excellent bond adhesion to a variety of substrates including decorative, laminates, particleboard, plywood, metal, honeycomb and leather.
- Provides good uniform coverage in hand and automatic spray applications.
- Excellent green strength and high heat resistance for high speed postforming applications.
- Extremely low VOC content
- OTC and SCAQMD compliant
- Meets or exceeds Spec A-A-1936 (1996); Type II (supersedes Fed. Spec. MMM-A-130B)



Application:

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Temperature of adhesive and substrates during fabrication should be at least 65°F (18°C) for best results.
3. HY-31 can be brushed, rolled and sprayed. If brushing and rolling, apply 100% coverage (3.0 dry grams/sq. ft. or higher). If spraying, coating weight of 2.5 to 3.5 dry grams should be applied. The atomization pressure at the gun should be 5 to 20 psi and the fluid pressure should be 10 to 15 psi.
4. When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry, apply the second coat and allow to dry properly before bonding. This helps to insure that the adhesive does not soak-in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond.
5. Allow the adhesive to dry properly before bonding. Water borne contact adhesives will change color when dry. However, to check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer to the fingers or opaque areas in the adhesive, the adhesive is ready for bonding. Dry time can vary depending on temperature, humidity and coating weight. Drying time can be reduced using air movement, drying ovens, lamps, etc.

6. Typical drying will occur in 30 minutes, however, dry time can vary depending on temperature. Bonds can be made as soon as the adhesive is dry. However, bonds made any time in the one hour open time will be as strong as those made immediately after dry.
7. Position the pieces carefully, since a strong bond is made instantly upon contact. Spacers such as dowels or strips of laminate should be used to prevent contact prior to proper positioning.
8. Use good uniform pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is applied with a J-roller.
9. The completed panel can be routed or trimmed, cut, filed and machined immediately.

Recommended Equipment:

Commonwealth Equipment				
Product Specifications				
Typical Fluid Pressure		Atomization Pressure		Spray Pattern
5-10 psi		10-20 psi		Pebble
Spray Equipment				
Binks				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip</i>	<i>Needle</i>	<i>Air Cap</i>
95, 2001	M95	66SS		66SD-3, 66SDJG
Devilbiss				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip & Needle</i>		<i>Air Cap</i>
JGA-510, MBC-510	AGX550	FF, FX		797, 7700
CA Technologies				
<i>Gun</i>			<i>Set Up</i>	
Panther SLP			1.3 x 2266-3T 1.3 x 1313	

Application Precautions:

Avoid application equipment containing aluminum or copper.

DO NOT laminate copper with this adhesive.

DO NOT use on plasticized vinyls.

DO NOT exceed the recommended "open time." Thinning the adhesive is not recommended. .

Storage Conditions:

Keep adhesive container closed tightly when not in use.

Store closed, lined containers where temperature will be between 50°F and 80°F

Product should not be stored in direct sunlight.

Product is not freeze/thaw stable. Protect from freezing. Product should not be used after being frozen.

Please Refer To The Safety Data Sheet For Further Information.