



# Hybond®

## PRODUCT DATA SHEET



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

**Product Number:** **HY-75NFM / HY-75NFMG**

**Description:** **Contact Adhesive, High Solids, OTC Compliant**

### Typical Physical Properties:

<b>Viscosity</b>	350 cps	<b>VOC</b>	0 g/l (EPA Method 24)
<b>Dry Time</b>	2-5 Minutes	<b>Coverage Rate</b>	3.0 dry grams/sq. ft. minimum
<b>Solids</b>	27% +/- 1%	<b>Clean Up</b>	Choice Brands 1000
<b>Open Time</b>	30 minutes	<b>Shelf Life</b>	1 Year in unopened container
<b>Color</b>	Natural / Green	<b>VHAP</b>	2.75 lbs/lbs of solids
<b>Solvents</b>	Organic solvents	<b>Density</b>	10.1 wt/gl
<b>Flash Point</b>	None	<b>Packaging</b>	5 gal, 54 gal and tote containers
<b>Coverage</b>	200-240 sq. ft./gallon		

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

### OTC Compliant

### Properties:

- High solids, non-flammable spray grade contact cement
- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber and metal
- Excellent room temperature contactability
- Non ozone depleting
- Excellent green strength and high heat resistance
- Excellent sprayability

### Application:

1. Agitate adhesive before use.
2. Substrates should be clean and free of moisture, dirt, oil and other contaminants.
3. For best results, adhesive and substrates should be allowed to acclimate to room temperature (approximately 60°F or above) before adhesive application.
4. The adhesive should be applied at approximately 3.0 grams/square foot. The adhesive should cover 80% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied to these areas.
5. 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.
6. Make sure to coat all exposed edges and corners with two coats of adhesives.

7. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly.
8. Allowing the contact adhesive to dry completely before assembly is essential
  1. to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, the substrates are ready for bonding.
  9. If areas exist with excessive adhesive deposition, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, allow additional dry time to ensure complete evaporation of the solvent before bonding.
10. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
11. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive. (Open times vary by adhesive. See specification on Page 1.)
12. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
13. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

### Suggested Equipment:

Product Specifications				
Typical Fluid Pressure		Atomization Pressure		Spray Pattern
10-20 psi		30-50 psi		Web
Spray Equipment				
Binks				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip</i>	<i>Needle</i>	<i>Air Cap</i>
95, 2100	21, 95	63ASS	663A, 563A, 236A, 763A	66SD-3
Devilbiss				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip &amp; Needle</i>		<i>Air Cap</i>
JGA-510, MBC-510	AGX	FX		247
CA Technologies				
<i>Gun</i>			<i>Set Up</i>	
Panther			1.5 x 2266-3T	
Tomcat			1.5 x 2266-3	

### Application Precautions:

Avoid application equipment containing aluminum or copper.  
 Do not use on polystyrene foams or plasticized vinyls  
 Do not mix with other adhesives. Thinning the adhesive is not recommended.

### Storage Conditions:

Rotate stock, use oldest first. Keep covered to prevent solvent loss and contamination.  
 Do not freeze. Store product between 60 – 80°F. Do not store in direct sunlight.

### Please Refer To The Safety Data Sheet For Further Information.

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