



Hybond®

PRODUCT DATA SHEET



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

Product Number: **HY-80NFM / HY-80NFMR**

Description: **Neoprene Contact Adhesive, Non-Flammable Brush Grade**

Typical Physical Properties:

Viscosity	900 cps	VOC	240 g/l (EPA Method 24)
Dry Time	2-4 Minutes	Coverage Rate	2.5 dry grams/sq. ft. minimum
Solids	14% +/- 1%	Clean Up	Choice Brands 1000
Open Time	30 minutes	Shelf Life	1 Year in unopened container
Color	Natural	VHAP	6.08 lbs/lbs of solids
Solvents	Organic solvents	Density	10.7 wt/gl
Flash Point	40 deg F	Packaging	5 gal, 54 gal and tote containers
Coverage	134-168 sq. ft./gallon		

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

OTC Compliant

Properties:

- Non-flammable brush and roller 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
- Excellent green strength and high heat resistance
- Contains no ozone depleters
- Spreads easily and provides uniform coverage

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 can be applied with an animal hair or solvent-resistant brush, a short-nap roller, or a roll coater.
5. The adhesive should be applied at approximately 2.5 dry grams/square foot. The adhesive should cover 100% 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.
6. 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.

7. Allowing the contact adhesive to dry completely before assembly is essential 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.
8. 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.
9. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
10. 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.)
11. 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.
12. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

Application Precautions:

Avoid application equipment containing aluminum or copper.

Avoid copper or copper alloy substrates.

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.