



Hybond®

PRODUCT DATA SHEET



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

Product Number:

HY-80 PLUS

Description: **Neoprene Contact Adhesive, Consumer Brush Grade**

Typical Physical Properties:

Viscosity	2000 cps	VOC	684 g/l (EPA Method 24)
Dry Time	8 - 10 Minutes	Coverage Rate	2.5 dry grams/sq. ft. minimum
Solids	21% +/- 1%	Clean Up	Choice Brands 689
Open Time	45 minutes	Shelf Life	1 Year in unopened container
Color	Natural	VHAP	1.46 lbs/lbs of solids
Solvents	Organic solvents	Density	7.2 wt/gl
Flash Point	25 deg F	Packaging	5 gal, 54 gal and tote containers
Coverage	140-175 sq. ft./gallon		

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

Properties:

- High performance Flammable 20⁰ flash, brush and roller grade contact adhesive. Can be sold over the counter to consumers or For Professional Use.
- 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
- Spreads easily and provides uniform coverage
- Professional quality adhesive suitable for use by consumers and professionals (Meets CPSC safety flammability requirements)
- One hour open time

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 60⁰F 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. 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.

6. 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.

7. 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.

8. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.

9. 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.)

10. 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.

11. 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.