Hybond®

PRODUCT DATA SHEET

CHOICE ADHESIVES

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

Product Number: **HY-B68 / HY-B68R**

Description: **Contact Adhesive, High Solids, Low VOC**

Typical Physical Properties:

Viscosity	140 cps	**VOC**	241 g/l (EPA Method 24)
Dry Time	4-6 Minutes	**Coverage Rate**	2.5-3.0 dry grams/sq. ft. min
Solids	37% +/- 1%	**Clean Up**	Choice Brands 689
Open Time	60 minutes	**Shelf Life**	1 Year in unopened container
Color	Natural / Red	**VHAP**	0.38 lbs/lbs of solids
Solvents	Organic solvents	**Density**	7.5 wt/gl
Flash Point	-20 deg F	**Packaging**	5 gal, 54 gal and tote containers
Coverage	205-250 sq. ft./gallon		

LEED®-NC & CI EQ Credit 4.4 LEED®-NC & CI EQ Credit 3.2

Properties:

- OTC Compliant, No-Urea Formaldehyde added.
- High solids means extended mileage
- Excellent Heat resistance and bond strength

Application:

1. Agitate adhesive before use.
2. Substrates should be clean and free of moisture, dirt, oil, and other contaminates.
3. For best results, adhesive and substrates should be allowed to acclimate temperature (approximately 60°F or above) before application of adhesive.
4. 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.
5. Make sure to coat all exposed edges and corners with two coats of adhesives.
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 the adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second coat to completely dry before assembly.
7. Allowing contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press a piece of Kraft paper onto the adhesive surface. If there is transfer of adhesive to the paper, more time is required to let the adhesive dry. If there is no transfer, substrates are ready for bonding.

8. If areas exist with excessive adhesive deposition, twist the (gloved) fingers while pressing them onto the adhesive layer. This will break any film that has formed as the adhesive dries from the top surface down. If a skin has been formed, allow more time for evaporation to ensure complete removal of 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 may vary by adhesive).
11. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to insure complete fusion between the two layers of adhesive to be bonded. A pinch roller is ideal for applying uniform pressure. When used properly, a J-roller can also provide adequate pressure for bonding
12. 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				
Manual	*Auto*	*Fluid Tip*	*Needle*	*Air Cap*
95, 2100	21, 95	63ASS	663A, 563A	66SD-3
Devilbiss				
Manual	*Auto*	*Fluid Tip & Needle*		*Air Cap*
JGA-510, MBC-510	AGX	FX		247
CA Technologies				
Gun			*Set Up*	
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:

Store between 60 and 90° F.
Do not store in direct sunlight
If exposed to freezing temperatures, return product to room temperature.

Please Refer To The Safety Data Sheet For Further Information.