



Hybond®

PRODUCT DATA SHEET



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

Product Number: HY-GGE Golden Glue EXTERIOR

Description: Type II Adhesive

HY-GGE is a pre-catalyzed crosslinking adhesive for exterior grade applications. It can also be used for Radio Frequency bonding and Hot Press Applications. Final bonds are water resistant, and will conform to D3/Type 2 specifications.

Benefits:

Exterior Grade Wood Glue
Passes ANSI TYPE 11 Water Resistance
Hot or Cold Press
Fast Set

RF Gluing
Easily Sandable
OTC Compliant
Cal SCAQMD Compliant



Typical Physical Properties:

Solids:	49% +/- 3%	VOC:	18.09 g/l (EPA Method 24)
Open Time:	Approx. 5 minutes	Shelf Life:	One year in unopened container
Viscosity:	4400 cps	Coverage:	240 sq ft/gal
Closed Time:	Approx 20 minutes	Chalk Temperature:	55°F
Press Time:	Approx. 30 - 45 minutes @ 40psi	Coverage Rate:	6 – 9 wet mls
Color:	Yellow	Packaging:	1, 5, 55, and 275 gal container

Qualifies for Leed Points 3.2, 4.1 and 4.4: Contains no added urea-formaldehyde resins

Freezing is not recommended but extensive testing indicates that the glue is freeze thaw stable up to three cycles without any negative impact on performance. If your glue has been frozen, allow it acclimate to room temperature and shake/stir to original form.

Application Instructions:

Hot or Cold Press

1. Apply adhesive via Black Brothers A2158 roll coater (glue spreader). For best results use dual durometer rollers to insure thorough coverage.
2. Apply 6 – 9 wet mls onto the board surface.
3. Working time of the adhesive is 5 – 7 minutes and closed time to move the stack is 15 – 20 minutes. For cold press operations, 1- 2 hours of press time at 40 – 50 psi is recommended. Delay machining for 8 – 12 hours once out of press.
4. For hot press applications, set temperature at 180 – 200° F with dwell of 69 – 90 seconds. Wait 15 minutes after substrate has cooled for machining.

Assembly

1. Apply 6 mls (or at rate of 240 sq ft/gal) via glue spreader, brush/roller or squeeze bottle.
2. The joint have been prepped to fit together snugly.
3. Open time to bring the glue joint together is 5 - 8 minutes.
4. Apply pressure to the bondline with pressure recommendations being 100 – 150 psi for soft woods, 125 – 200 for medium density woods and 150 – 250 psi for hardwoods.

Substrates to Avoid:

Moisture Resistant Boards
Tempered Hardwood Products
Metallized, polyester or painted surfaces
Low Pressure melamine
Fire retardant treated board

Limitations:

Not for structural or load bearing applications. Do not use when temperature, glue or materials are below 55°F. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form. F716Y is not intended for use under conditions submersion or applications below the water line.

Clean Up:

Warm soapy water while adhesive is still wet
Used diluted ammonia to clean dried adhesive
Washer water is NRCA non-hazardous

Storage Conditions:

Do not subject to freezing conditions
Insure adhesive and substrates are conditioned above 65°F.
Best results are achieved between 70 and 85°F.
Do not store in direct sunlight.

Precautions:

For consumer or professional use. Keep out of reach of children.

Please Refer To The Safety Data Sheet For Further Information.