

# PRODUCT DATA SHEET



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## 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%Open Time:Approx. 5 minutesViscosity:4400 cpsClosed Time:Approx. 20 minutesPress Time:Approx. 30 - 45 minutes @ 40psiColor:Yellow

VOC:18.09 g/l (EPA Method 24)Shelf Life:One year in unopened containerCoverage:240 sq ft/galChalk Temperature:55°FCoverage Rate:6 – 9 wet mlsPackaging: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.
- 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.

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