



# Hybond®

## PRODUCT DATA SHEET



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**Product Number:** **HY-HS+ / HY-HSR+**

**Description:** **Neoprene Contact Adhesive,  
Premium High Solids Spray Grade**

### Typical Physical Properties:

<b>Viscosity</b>	135 cps	<b>VOC</b>	546 g/l (EPA Method 24)
<b>Dry Time</b>	3-5 Minutes	<b>Coverage Rate</b>	2.0-2.5 dry grams/sq. ft. minimum
<b>Solids</b>	24% +/- 1%	<b>Clean Up</b>	Choice Brands 689
<b>Open Time</b>	30 minutes	<b>Shelf Life</b>	1 Year in unopened container
<b>Color</b>	Natural / Red	<b>VHAP</b>	0.357 lbs/lbs of solids
<b>Solvents</b>	Aromatic/ketone blend	<b>HAP %</b>	8.55%
<b>Flash Point</b>	-4 deg F	<b>Density</b>	6.82 wt/gl
<b>Coverage</b>	185 bonded sq. ft./gallon	<b>Packaging</b>	5 gal, 54 gal and tote containers

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

### Properties:

- High solids flammable spray grade adhesive.
- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, rubber and metal.
- Excellent room temperature contact-ability.
- Excellent green strength and high heat resistance.
- Postformable in manual and heated spray systems
- 30-min 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 60°F or above) before application of adhesive.
4. The adhesive should be applied at approximately 2.0-2.5 dry grams per square foot. 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. 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.

6. 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.
7. 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.
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 may vary by adhesive).
10. 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
11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed, and machined.

### Recommended Equipment:

Product Specifications				
Typical Fluid Pressure		Atomization Pressure		Spray Pattern
10-20 psi		30-50 psi		Pebble
Spray Equipment				
Binks				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip</i>	<i>Needle</i>	<i>Air Cap</i>
95, 2100	21, 95	63ASS	663A, 563A	66SD-3
Devilbiss				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip &amp; Needle</i>		<i>Air Cap</i>
JGA-510, MBC-510	AGX	FX, FF		24, 797
CA Technologies				
<i>Gun</i>			<i>Set Up</i>	
Panther			1.5 x 2266-3T	
Tomcat			1.5 x 2266-3	

### 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.

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