Hybond®

PRODUCT DATA SHEET

CHOICE BRANDS ADHESIVES, 666 REDNA TERRACE #500, CINCINNATI, OH 45215 513-772-1234

Product Number: **HY-75NFM / HY-75NFMG**

Description: **Contact Adhesive, High Solids, OTC Compliant**

Typical Physical Properties:

Viscosity:	350 cps	**Coverage:**	225 sq ft/gallon
Dry Time:	2 – 5 Minutes	**VOC:**	0 g/l (EPA Method 24)
Solids:	26% +/- 1%	**Coverage Rate:**	3.0 dry grams/sq ft minimum
Open Time:	30 minutes	**Clean Up:**	Choice Brands 1000
Color:	Natural/Green	**Shelf Life:**	1 Year in unopened container
Solvents:	Organic solvents	**Class:**	Non- Flammable
Flash Point:	None	**Packaging:**	5 gal, 54 gal and Tote container

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

OTC Compliant

Properties:

- High solids, non-flammable spray grade contact cement
- 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
- Non ozone depleting
- Excellent green strength and high heat resistance
- Excellent sprayability

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 to room temperature (approximately 60°F 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. 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.
6. Make sure to coat all exposed edges and corners with two coats of adhesives.

7. 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.
8. 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.
9. 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.
10. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
11. 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.)
12. 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.
13. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

Suggested Equipment:

	Manual Systems		Automatic Systems	
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	95, 2001,2100	JGA510, MSA510	21,95A	AGX550
Fluid Tip	63B-SS	FX	63C-SS	FX
Fluid Needle	663A, 563A	FX	263A,663A	FX
Air Cap	66SD-3	24	66SD-3	24

Application Precautions:

Do not apply using equipment that is made of or contains parts made of copper or aluminum.

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 Material Safety Data Sheet For Further Information.