



Hybond®

PRODUCT DATA SHEET

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

Product Number:

HY30 / HY-30G

Description: Neoprene Contact Adhesive; Water Base, Spray, Roller Grade

Typical Physical Properties:

Viscosity: 1100 cps

Dry Time: 15 - 30 Minutes

Solids: 54% +/- 1%

Open Time: 60 minutes

Color: White, Dries Clear / Green

Solvents: Organic solvents

Flash Point: None

Coverage: 400 sq ft/gallon

VOC: 0 g/l (EPA Method 24)

Coverage Rate: 2.5 dry grams/sq ft minimum

Clean Up: Warm, soapy water

Shelf Life: 6 months in unopened container

Packaging: Gallons, Pails, Drums & Totes

LEED®-NC & CI EQ Credit 4.1 LEED®-NC & CI EQ Credit 4.4 LEED®-NC & CI EQ Credit 3.2



Properties:

- **SCAQMD Rule 1168 Compliant, OTC Compliant, No-Urea Formaldehyde added.**
- 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
- 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 contaminants.
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 2.5 dry grams/square foot. The adhesive should cover 100% of the substrate surface if rolled and 80% if sprayed. 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. 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.
6. 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.
7. 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.

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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 vary by adhesive. See specification on Page 1.)
10. 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.
11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

Equipment Recommendations:

MANUAL EQUIPMENT

US Legends C.A. Technologies
95 Tornado Gun Panther P100G 1.8 X 1590
spray gun.
System 500 – 5 gallon pressure pot and hoses
with non-corrosive fluid paths.
Fluid Pressure: 5-15 psi
Atomization Pressure: 20-40 psi
System 5000 – 55 gallon drum pressure system
Fluid Pressure: 2-8 psi
Atomization Pressure: 20-40 psi

AUTOMATIC EQUIPMENT

Binks Binks
Mach 1A HVLP spray gun Mach 1 HVLP spray
gun
94 fluid tip, 47 – 478 needle
94 fluid tip, 54 – 3941 needle 94P air cap
Fluid Pressure: 10-30 psi
Atomization Pressure: 10-30 psi

Spray Equipment must have stainless steel fittings, passages, fluid nozzles and needles. Hoses must be nylon lined or plastic. An in-line filter between the pump and spray gun is required. Apply a uniform, finely atomized, spray.

Application Precautions:

Do not use in applications with copper or aluminum components.
Do not use on polystyrene foams or plasticized vinyls
Do not mix with other adhesives. Thinning the adhesive is not recommended.
Do not store in direct sunlight.

REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER INFORMATION