



Hybond®

PRODUCT DATA SHEET

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

Product Name: 7709TG

Benefits:

Postformable, dead stack, cold or hot press
Fast Setting
GreenGuard Certified
SCAQMD, OTC and Leed Compliant

Extremely low VOC content
No Urea/ formaldehyde Added
Excellent Mileage

Typical Physical Properties:

Color: Green
Coverage: 240 sq. ft
Coverage Rate: 6-9 wet mils minimum
Solids: 55% +/- 3%
Viscosity: 2500 cps
Chalk Temperature: 50° F

Open Time: 2 – 5 minutes
Set Time: 15 – 20 minutes
Hot Press Time: 1 – 2 minutes (35 psi min.)
VOC Content: 1.29 g/l (Method 24)
Shelf Life: One year in unopened container
Packaging: 5, 55, and 275 gallon containers

Qualifies for Leed Points 3.2, 4.1 and 4.4



Application:

A post-formable vinyl acetate adhesive designed for immediate bonding of Veneer, HPL to particleboard, MDF, plywood and wood. Product can be sprayed or roll coated and processed by dead stacking, nip rolling and stacking, hot laminated and hot pressed. Excellent adhesion to a variety of substrates including, but not limited to veneer, decorative laminates, particleboard, and plywood. Provides good uniform coverage in hand and automatic spray applications

Postforming:

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. The adhesive should be applied at a coating weight of 4.5 dry grams per sq. ft. or 3 mils on both the core and the HPL by spray application or roll coating, with 100% coverage on the post form radius and edges. The approximate atomization pressure at the gun should be 40 to 60 psi and the approximate fluid pressure should be 25 to 30 psi.
3. The HPL and core are to be dried by processing through a drying oven. The adhesive should appear to be approximately 50% clear and 50% opaque when exiting the drying oven. The post form radius and edges should be completely dry or clear.
4. The HPL and core should be indexed and pinch rolled with a temperature of each between 110°F-120°F. Failure to pinch roll at the recommended temperatures may result in spotty or no bond.
5. The edges of the core to be post formed should not have any wet spots. The top can now be post formed through any commercially available flow through post former.

Panel Assembly By Roll Coating:

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive film thickness should be set to a depth of 6 to 9 wet mils. With this application, the adhesive may be applied to one substrate.
3. Index the HPL to the particleboard or plywood core as the substrates exits the roll coater.

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4. At this point, the panel can be:
- dead stacked
 - pinch rolled and stacked for 30 minutes before processing
 - processed through a pinch roll/hot laminating system, allowing immediate processing after the panel has cooled
 - hot pressed for a period of 1 - 2 minutes at approximately 180° F -200° F, allowing immediate processing after the panel has cooled

Recommended Automatic Spray Equipment

Equipment	Binks		DeVilbiss
1-2 traversing heads	M95, M61	Spray Gun	JGA510, MSA510
3 heads, edge and underwrap	68SS	Spray Tip	JGA4040
1-2 traversing heads	66SS		
3 traversing heads	68BP	Air Cap	MD4039, 64HD
Edge and Underwrap	66PJ		
	66R , 66PJ		
	668	Needle	D type

Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be nylon lined or PVC. This material can be pumped with a double diaphragm pump or a piston pump.

General Use Instructions:

Ensure substrates and adhesive are above 65°F
Surfaces should be free of dirt and any contaminants.

Applications To Avoid

Fire retardant treated board
Moisture resistant board
Polyester, metallic and painted surfaces
Tempered hardboard products

Handling:

Clean Up: Use warm soapy water when the adhesive is wet and solvent or diluted ammonia when the adhesive is dry.

Disposal: Dry adhesive residue is usually not considered to be hazardous waste. Do not flush or pour wet adhesive into the sewer adhesive without authorization from local authorities. Thinning the adhesive is not recommended.

Storage Conditions:

Keep adhesive container closed tightly when not in use. Containers should be stored on pallets away from outside walls and off concrete floors. Do not subject to freezing conditions. Insure adhesive and substrates are conditioned above 65°F. Best results are achieved between 55-85°F. Do not store in direct sunlight. Product must be stored indoors.

Please Refer To The Material Safety Data Sheet For Further Safety Information.

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