



Hybond®

PRODUCT DATA SHEET

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

Product Number: CBA-501, CBA-501G

Description: All Purpose, Pressure Sensitive Canister Adhesive

Typical Physical Properties:

Adhesive:	Flam/Non-Flam (propellant/adhesive)	Pattern:	Web
Dry Time:	2 - 3 Minutes	Solvents:	Methylene Chloride, Propane
Open Time:	30 minutes	Flash Point:	-156 deg F
Color:	Clear, Green	VOC:	420 g/l (EPA Method 24)
Coverage Rate:	3.0 dry grams/sq ft minimum	Clean Up:	Choice 689 or Citrus Cleaner
Shelf Life:	1 Year in unopened container	Class:	Extremely Flammable
Availability:	38, 177 and 355 lb canisters		

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

Properties:

- Suitable for bonding foam, fabrics, duct liner and wrap and other plastics
- Fast drying
- Good heat resistance
- High tack properties suitable for one way bonding when one porous surface is used
- Portable system

Handling and Application:

When hose is connected, keep canister valve open and hose pressurized at all times. Do not disconnect the hose until ready to connect to a new canister. Release pressure in hose before disconnecting from canister.

For optimum performance, store at 70°F (21°C) during use. Canister must be above 50°F (10°C).

Do not use in applications with copper or aluminum components.

This adhesive is not recommended for use with plasticized vinyl, flexible plastics, expanded/extruded polystyrene, polyethylene or polypropylene.

Use in only well ventilated areas. Do not use near ignition sources.



Hybond[®]

PRODUCT DATA SHEET

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

Application:

1. Prepare the surface to be bonded. Ensure both faces are clean and free of dust, dirt and grease. If necessary, wipe clean with CBA-Citrus Cleaner.
2. Hold spray gun at a constant distance of between 6-10 inches (150-250mm) from the surface, allowing adhesive to cobweb across the surface with minimal overlap for thick laminates. For thin laminates allow for approximately 50% overlap of successive passes to prevent telegraphing.
3. Maintain a constant hand speed during spraying. Apply a consistent and thorough coating without allowing the adhesive to puddle or heavily wet the surface. Maximum bond strength is achieved with substrate coverage between 80-100% with a recommended coat weight minimum of 3.0 dry grams per square foot.
4. Maximum adhesion will be obtained by spraying opposing mating faces with an adhesive pattern at 90° angles to each other. (Example: Face one substrate vertically while spraying. Face the other substrate horizontally. Extra coverage is recommended at substrate edges.
5. Hold spray gun at 90° angle to substrate surface while spraying. Release trigger at end of each pass to optimize coverage.
6. 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.
7. Make sure to coat all exposed edges and corners with two coats of adhesives. Allow adhesive to dry completely before attempting assembly. (Dry time may vary due to humidity and temperature variations.) Test for dryness using back of hand only – surface should be tacky, but adhesive should not transfer to the skin.
8. Position substrates carefully and apply pressure. Work from the center of the substrate, out to prevent bubbles and wrinkles. Apply adequate pressure (40 PLI) using nip roller. Proper use of a 3” J-roller will also provide proper pressure.
9. The bonded assembly is immediately able to be trimmed or routed. Full bond strength is achieved after 24-48 hours depending on temperature and humidity.
10. RIGID SURFACES / FLEXIBLE SURFACES – apply adhesive to one or both surfaces / a second coat may be necessary dependent upon porosity of substrates. Position substrates carefully and apply pressure. Bonded substrates should be able to be cut or trimmed immediately. Full bond strength is achieved after 24-48 hours depending on ambient temperature and humidity.

Storage Conditions:

Rotate stock, use oldest first. Do not freeze. Do not store directly on concrete floor. Do not store at temperatures above 120°F (49°C). Do not store in direct sunlight.

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

For further information, consult the Material Safety Data Sheet