



Hybond®

PRODUCT DATA SHEET

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

Product Number: CBA-655

Description: Aerosol Contact Adhesive, Low VOC

Typical Physical Properties:

Viscosity:	>100 cps	Dry Time:	4 – 6 Minutes
Open Time:	60 Minutes	Shipping:	Ground ORM-D
Voc:	<55% by Weight VOC	Can Wt:	13 Fluid Oz.
Color:	Natural	Coverage Rate:	3.0 dry grams/sq.ft. minimum
Class:	Extremely Flammable	Coverage:	≈14 sq ft/can
Shelf Life:	One Year	Clean Up:	Citrus Cleaner or 689 Cleaner

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

Properties:

- California VOC compliant
- Non-Chlorinated
- Adjustable Spray Pattern
- Good heat resistance
- High solids
- Long Open Time
- Portable system
- Easy application control

Applications:

CBA-655 is designed for permanent bonding of materials where immediate bond strength and good heat resistance are required. CBA-655 is suitable for permanent bonding a variety of materials. For bonding to metal, surface preparation is very important – surface must be degreased and lightly abraded with fine abrasive or non-woven material. Always test CBA-655 to determine suitability for your particular application prior to use in production.

NOT RECOMMENDED for use with plasticized vinyls, flexible plastics, expanded/ extruded polystyrene, PE or PP.

Aerosol Application Instructions:

1. Prepare the surface to be bonded, ensuring both faces are clean, free of dust, dirt and grease.
2. Hold spray can 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 or approximately 50% to 70% overlap to successive passes for thin laminates to reduce the risk of telegraphing (note- correct coat weight must be achieved)
3. Maintain a constant speed of application during spraying applying a consistent and thorough coating without allowing the adhesive to puddle or heavily wet the surface. Maximum bond strength is achieved with coverage of between 80-100% with a recommended coat weight of minimum 2.5 dry grams per square foot.
4. Maximum adhesion will be obtained by spraying mating faces at 90° angle to each other, i.e. one face vertically, the other face horizontally. Double coating perimeter of face and edges is recommended.

NOTICE TO PURCHASER: The information, data and suggestions for use of the materials given here are based on our best experience and knowledge, but we do not guarantee the results to be obtained in customer's processes. The products discussed are sold without any warranty regarding merchantability or fitness for a particular purpose or any other warranty express or implied. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Sellers and manufacturers only obligation shall be to replace such quantity of the product proved to be defective. Since the manufacturer of the described in this data sheet has no means of controlling the final use of the product by the consumer or user, it is the responsibility of the immediate purchaser and any intermediate sellers to inform the user of the purposes for which the product may be fit and suitable, and of the properties of the product, including the precautionary measures which must be taken in order to insure the safety of the user and of other third persons and property.



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5. Do not angle spray gun or move in an arc while spraying. Hold gun at 90° angle to 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.
8. Substrates which are difficult to bond, e.g. metal faces, or products with memory, may require a 2nd coat. Best results are obtained by double coating rather than one heavy coat; which may result in heavy wetting of surface and extended drying times.
9. Allow adhesive to 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. Position substrates correctly and press together working from center outwards. Apply adequate pressure using nip roller, of 75mm hand roller and body weight as a minimum, in order to achieve at least 35 psi at the glue line. Note that repositioning is not possible after contact has been made.
10. Immediate trimming/routing is possible. Full strength is achieved after 24-48 hours depending on temperature and humidity.

Special Precautions:

For best results store aerosols above 50° F (10° C). Allow substrates to warm to normal room Temperature 70° F (21° C) for 48 hours before bonding. Keep aerosol off cold concrete floors during use. If adhesive is expelled wet or as a jet, aerosol is too cold – move to a warm environment and allow to thoroughly warm up before reusing.

Caution:

Use in only well ventilated areas.
Do not thin or reactivate with solvents.
Do not puncture or incinerate canister.
Do not expose to extreme heat over 100° F (38° C).
Keep away from sources of ignition.
Test for suitability before use.
Do not store in direct sunlight.

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