


Technical Guide

 Hybond®	Product Specifications										Polymer		Packaging				Application					Use					
	Color	% Solids	Weight / gallon	Viscosity	Minimum Application Temp	Shelf Life (months)	Freeze / Thaw Stable	Open Time (minutes)	Press Time / Clamp Time (minutes)	Water Resistant	Poly-Vinyl Acetate (PVA)	Ethylene Vinyl Acetate (EVA)	Gallon	Pail	Drum	Tote	Extrude	Glue Spreader	Spray	Cold Press	Hot Press	Postforming	Laminate	Metals	Difficult Surfaces	Fire Rated Board Stocks	
Vinyl Acetates / Wood Glues																											
HY-GG	Yellow	44%	9.1	5000	50	12	Y	8-10	30-45	G	•	•	•	•	•	•	•						•				
HY-GGE	Yellow	49%	9.0	4400	50	12	Y	8-10	30-45	E	•	•	•	•	•	•	•						•				
XA-2700	White	42%	9.1	6000	50	8	Y	10-20	40-60	G	•	•	•	•	•	•	•		•				•				
XA-2600	White	45%	9.1	5000	50	8	Y	10-15	30-45	G	•	•	•	•	•	•	•		•	•			•				
CBA-538	White	50%	9.1	3500	40	8	Y	10-15	30-45	E	•	•	•	•	•	•	•		•	•			•				
CBA-502	White	48%	9.1	5000	54	8	Y	10-15	2*	E	•	•	•	•	•	•	•		•	•			•				
CBA-530	White	60%	9.1	2500	55	8	Y	2-5	1-2*	G	•	•	•	•	•	•	•	•	•			•	•				
CBA-530T	Lt Blue	60%	9.1	2500	55	8	Y	2-5	1-2*	G	•	•	•	•	•	•	•	•	•			•	•				
CBA-531	White	60%	9.5	8000	50	8	Y	5-10	30-60	G	•	•	•	•	•	•	•		•	•			•	•	•		
CBA-537	White	63%	9.1	3600	55	8	N	5	30-45	G	•	•	•	•	•	•	•		•	•			•	•	•		•
7709TG	Green	55%	9.1	2500	50	6	N	2-5	2*	G	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

- Minimum Application Temp is also known as chalking temperature. This is the minimum application temperature for gluing substrates together. All substrates should also be conditioned to room temperature prior to gluing for best results
- Freeze/Thaw – Products that are freeze thaw stable (Y) are tested for a minimum of 3 freeze cycles and will return to a usable nature. If frozen, some light to moderate agitation might be required. Products that do not pass freeze/thaw testing (N) will not return to a usable form.
- Open Time – the period of time from application of adhesive until the second substrate is brought into contact. Do not exceed the open time.
- Press Time – the period of time that substrates are required to be under pressure. Press times are all stated as laminate to particle board bonds using 8 mils of adhesive. Press pressures should be set at 100 – 150 psi for soft woods, 125 – 175 for medium woods and 150 – 250 psi for hardwoods
- *Press Time – is stated as Hot Press Time with press temps set at 180 deg F.
- Open time and Press Times are stated at 70 deg F and 50% RH condition with a deposition of 8 wet mls. Operating conditions will vary the open time and press time of the adhesive as will porosity of different board substrates.
- Water Resistance – G – Good; E – Excellent
- Metals – to include and tested with Chemmetal and Decometals
- If measured in bars – 1 bar=14.5 psi

All products should be tested to determine their suitability for the end application.