


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.



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WOOD GLUE PRODUCT GUIDE

Golden Glue Assembly Adhesive PVA (Part No HY-GG)

- *Fast set speed*
- *Bonds hard and soft woods*
- *Economical compared to name brands*
- *Easily sanded*
- *Interior use only*
- *OTC and California Compliant*
- *GreenGuard Gold Certified*

Solids: 44%
Viscosity: 5000 cps
Working Time: 8-10 minutes
Clamp Time: 30-45 minutes

Color: Yellow
Application Temp: 50 Deg F or above
Freeze Stable: Yes
Shelf Life: 12 months

Golden Glue is an excellent, fast setting assembly adhesive for bonding hard & soft woods. This is an economical product with great sandability.

Golden Glue Exterior Assembly Adhesive PVA (Part No HY-GGE)

- *Interior or Exterior wood glue*
- *Bonds hard and soft woods*
- *Meets Ansi/ASTM standards for water resistance*
- *Easily sanded*
- *OTC and California Compliant*
- *GreenGuard Gold Certified*

Solids: 49%
Viscosity: 4400 cps
Working Time: 8-10 minutes
Clamp Time: 30-45 minutes

Color: Yellow
Application Temp: 50 Deg F or above
Freeze Stable: Yes
Shelf Life: 12 months

Golden Glue Exterior is an excellent exterior assembly adhesive for bonding hard & soft woods. It is suitable for all exterior applications with excellent water resistance.



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LAMINATING ADHESIVE PRODUCT GUIDE

Cold Press PVA (Part no XA-2700)

- Medium set speed
- Medium viscosity for most board stocks
- Clean machining
- Most economical press adhesives
- OTC and California Compliant
- GreenGuard Gold Certified

Solids: 42%
Viscosity: 6000 cps
Working Time: 10-20 minutes
Press Time: 40-60 minutes

Color: White, translucent when dry
Application Temp: 50 Deg F or above
Freeze Stable: Yes
Shelf Life: 8 months

XA-2700 is an excellent, medium viscosity cold press adhesive for High Pressure Laminate to particle board and plywood surfaces. This is our most economical product with medium press time required.

Cold Press or Hot Press PVA (Part No XA-2600)

- Fast setting leads to reduced press time
- Medium viscosity for porous board stock
- Easy clean up
- E-84 fire and smoke spread rated – Class C
- OTC and California Compliant
- GreenGuard Gold Certified

Solids: 45%
Viscosity: 5000 cps
Working Time: 10-15 minutes
Cold Press Time: ~ 30 – 45 minutes
Hot Press Time: 2 minutes @ 180-200 deg F

Color: White
Application Temp: 50 Deg F or above
Freeze Stable: Yes
Shelf Life: 8 months

XA-2600 is a faster setting cold press adhesive excellent for HPL and veneer pressing on most board stocks. It has a fast set time and is ideal with facilities that need high output due to limited presses. It also has a class C fire rating laminating standard grade laminate and PB and MDF board stock.

Product will Hot Press.

Cold Press or Hot Press PVA (Part No CBA-538)

- Cold or Hot press glue for colder climates
- Operates well at temps as low as 40 Deg F
- Cross links for moisture resistant bond
- OTC and California Compliant

Solids: 50%
Viscosity: 35000 cps
Working Time: 10-15 minutes
Cold Press Time: 30 – 45 minutes
Hot Press Time: 2 minutes @ 180-200 deg F

Color: White, translucent when dry
Application Temp: 40 Deg F or above
Freeze Stable: Yes
Shelf Life: 8 months

CBA-538 is a crosslinking PVA that can be used in any Cold or Hot Press applications. The product crosslinks providing a moisture resistant bond. The product is unique in that its operating temperature can be as low as 35 – 38 deg F compared to other PVA press glues. Set time will vary dependent on plant conditions.

Hot Press or Cold Press Adhesive PVA (Part no CBA-502)

- Hot press or FR gluing
- Quick set / Strong bonds
- Water resistant bondline
- Can be used in Evans Panel Express
- OTC and California Compliant

Solids: 48%
Viscosity: 5000 cps
Working Time: 10-15 minutes
Cold Press Time: 30 – 40 minutes
Hot Press Time: 2 minutes @ 180-200 deg F

Color: White
Application Temp: 54 Deg F or above
Freeze Stable: Yes w/agitation
Shelf Life: 8 months

CBA-502 is an exceptional Hot or Cold Press adhesive that yields moisture resistant bonds once cross-linked. It provides a fast set in a hot press.



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LAMINATING ADHESIVE PRODUCT GUIDE (con't)

Post Forming PVA (Part No CBA-530)

- High solids, fast setting
- Postforming PVA
- Works well for all types of radius
- OTC and California Compliant

Solids: 60%
Viscosity: 2500 cps
Working Time: 2-5 minutes
Hot Press Time: 1-2 minutes @
40 psi

Color: White (CBA-530)
Lt Blue (CBA-530T)
Application Temp: 55 Deg F or above
Freeze Stable: Yes
Shelf Life: 8 months

CBA-530 is typically spray or glue spreader applied for pressing and post forming of HPL countertops. This product can postform the most difficult of edges including 180 Deg wraps and OG edges
CBA-530T is available in color (blue) and with an optical brightener for better visibility and clean up (specify CBA-530T).

Cold Press Adhesive for Difficult Surfaces EVA (CBA-531)

- High solids, fast setting EVA adhesive
- Layup of difficult surfaces
- Layup metallic, acrylic and FRP surfaces
- Ideal for FR and MR board stock
- OTC and California Compliant

Solids: 60%
Viscosity: 8000 cps
Working Time: 5-10 minutes or less
Cold Press Time: Substrate Dependent

Color: White
Application Temp: 50 Deg F or above
Freeze Stable: Yes
Shelf Life: 8 months

CBA-531 is an exceptional and versatile product for pressing many different materials. It bonds well to High Pressure laminate, veneer, decorative metals (to include Chemetal and Decometal), Fiber Reinforced Plastic (FRP) and other plastic surfaces. High solids allow for fast set times to difficult surfaces.

Cold Press Adhesive for Fire Rated Board Surfaces (Part No CBA-537)

- Formulated for lamination of fire rated (FR) board surfaces
- Compatible with borates and other FR materials
- Fast setting
- OTC and California Compliant

Solids: 63%
Viscosity: 3600 cps
Working Time: 5 minutes
Cold Press Time: Substrate Dependent

Color: White
Application Temp: 55 Deg F or above
Freeze Stable: No
Shelf Life: 8 months

CBA-537 is an exceptional press adhesive specifically formulated as a press adhesive with compatibility to borate modified board stocks. Thus CBA-537 is great for laminations using Fire Retardant or Moisture Resistant core materials.

Nip-n-Stack, Cold Press, Hot Press EVA Adhesive (Part No 7709TG)

- Dead Stack, Panel Express
- Ready to route in 45 minutes
- Postformable
- Can be used as a contact adhesives
- OTC and California Compliant
- GreenGuard Gold Certified

Solids: 55%
Viscosity: 2500 cps
Working Time: 2-5 minutes or less
Cold Press Time: 30-40 minutes
Hot Press Time: 1 - 2 minutes @
180 -200 deg F
Dead Stack Time: 30-60 minutes

Color: Green (7709TG)
White (7709TW)
Application Temp: 50 Deg F or above
Freeze Stable: No
Shelf Life: 8 months

7709TG is an incredibly versatile product that can be cold or hot pressed, used through panel express. It can be spray applied or run through most glue spreaders. It works well as a contact adhesive and can be post formed. It has wonderful versatility.



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Common Terms

Acclimate:	<i>Time (48 hours) for materials to adjust to a new environment.</i>
Closed Time:	<i>Interval between the point when a PVA composite is put together and when it is pressed.</i>
Cold Pressing:	<i>A hydraulic or screw press in which the glued members are forced together.</i>
Coverage:	<i>Amount of adhesive that is applied (measured in wet mils for PVA and g/ft² for contacts).</i>
Coverage Rate:	<i>The bonded amount of material that can be produced at a recommended adhesive coverage.</i>
Dead Stack:	<i>Pressure being applied to a laminated panel by only the weight of the core. No mechanical pressure is applied.</i>
Density:	<i>Mass per unit volume.</i>
Dry Time:	<i>The period of time during which an adhesive needs to dry prior to bonding.</i>
Flatwork:	<i>Also known as non-postforming.</i>
Freeze-Thaw Stable:	<i>A system able to freeze and thaw without losing chemical or physical properties.</i>
Glue Spreader:	<i>A piece of equipment with grooved rollers capable of applying adhesive in wet mils.</i>
Green Strength:	<i>Initial strength of adhesives that prevents laminate from springing back until it cures to full strength.</i>
Heat Strength:	<i>Strength measured at elevated temperature.</i>
Hot Press:	<i>A single or multi-platen hydraulic press, with plates or platens, heated by steam, for thermo-setting resin adhesives.</i>
Joint Assembly:	<i>The junction of two adjacent pieces of wood or veneer.</i>
Open Time:	<i>This is the window of time that begins when an adhesive is applied to the substrate and ends when the laminate is applied to make an assembly. Temperature and humidity affect open time.</i>
Pinch Roller:	<i>A mechanized roller which applies precise and continuous pressure over the entire panel.</i>
Postforming:	<i>Postforming describes the process of bending laminate around curves with the application of heat (approximately 325°F). A postforming adhesive has the ability to hold the laminate to the curved substrate while still at postforming temperatures.</i>
Press Time:	<i>The time which the assembly to be bonded remains under the pressure necessary for bonding.</i>
Solids Content:	<i>The percentage by weight of nonvolatile material in an adhesive or sealant.</i>
Substrate:	<i>The basic surface upon which the adhesive is applied and to which it is expected to adhere.</i>
Tack:	<i>The property of an adhesive that enables it to form a bond of measurable strength immediately after adhesive and adherent are brought into contact under low pressure.</i>
Viscosity	<i>The resistance of a fluid to flow.</i>
VOC: (Volatile Organic Compounds)	<i>Carbon-containing chemicals which contribute to the formation of ground level ozone (smog).</i>

All press and set times are states at 70 deg F, 50% RH. Temperature and Humidity changes will change set and press times.