



# Hybond®

## PRODUCT DATA SHEET

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

**Product Number: HY-GGE Golden Glue EXTERIOR**

**Description: Type II Adhesive**

*HY-GGE is a pre-catalyzed crosslinking adhesive for exterior grade applications. It can also be used for Radio Frequency bonding and Hot Press Applications. Final bonds are water resistant, and will conform to D3/Type 2 specifications.*

**Benefits:**

Exterior Grade Wood Glue  
Passes ANSI TYPE 11 Water Resistance  
Hot or Cold Press  
Fast Set

RF Gluing  
Easily Sandable  
OTC Compliant  
Cal SCAQMD Compliant

**Typical Physical Properties:**

**Solids:** 49% +/- 3%  
**Open Time:** Approx. 5 minutes  
**Viscosity:** 4400 cps  
**Closed Time:** Approx 20 minutes  
**Press Time:** Approx. 30 - 45 minutes @ 40psi  
**Color:** Yellow

**VOC:** 18.09 g/l (EPA Method 24)  
**Shelf Life:** One year in unopened container  
**Coverage:** 240 sq ft/gal  
**Chalk Temperature:** 55°F  
**Coverage Rate:** 6 – 9 wet mls  
**Packaging:** 1, 5, 55, and 275 gal container

**Qualifies for Leed Points 3.2, 4.1 and 4.4**

**Application Instructions:**

**Hot or Cold Press**

1. Apply adhesive via Black Brothers A2158 roll coater (glue spreader). For best results use dual durometer rollers to insure thorough coverage.
2. Apply 6 – 9 wet mls onto the board surface.
3. Working time of the adhesive is 5 – 7 minutes and closed time to move the stack is 15 – 20 minutes. For cold press operations, 1- 2 hours of press time at 40 – 50 psi is recommended. Delay machining for 8 – 12 hours once out of press.
4. For hot press applications, set temperature at 180 – 200° F with dwell of 69 – 90 seconds. Wait 15 minutes after substrate has cooled for machining.

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2014-05



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### Assembly

1. Apply 6 mls (or at rate of 240 sq ft/gal) via glue spreader, brush/roller or squeeze bottle.
2. The joint have been prepped to fit together snugly.
3. Open time to bring the glue joint together is 5 - 8 minutes.
4. Apply pressure to the bondline with pressure recommendations being 100 – 150 psi for soft woods, 125 – 200 for medium density woods and 150 – 250 psi for hardwoods.

### Substrates to Avoid:

Moisture Resistant Boards  
Tempered Hardwood Products  
Metallized, polyester or painted surfaces  
Low Pressure melamine  
Fire retardant treated board

### Limitations:

Not for structural or load bearing applications. Do not use when temperature, glue or materials are below 55°F. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form. F716Y is not intended for use under conditions submersion or applications below the water line.

### Clean Up:

Warm soapy water while adhesive is still wet  
Used diluted ammonia to clean dried adhesive  
Washer water is NRCA non-hazardous

### Storage Conditions:

Do not subject to freezing conditions  
Insure adhesive and substrates are conditioned above 65°F.  
Best results are achieved between 70 and 85°F.  
Do not store in direct sunlight.

### Precautions:

For consumer or professional use. Keep out of reach of children.

**Please refer to the Material Safety Data Sheet for further safety information**