



# Hybond®

## PRODUCT DATA SHEET

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

**Product Number:** XA-2600

**Description:** Vinyl Acetate Emulsion

### Typical Physical Properties:

|                     |                             |                           |                                |
|---------------------|-----------------------------|---------------------------|--------------------------------|
| <b>Solids:</b>      | 45% +/- 3%                  | <b>VOC:</b>               | 13.15 g/l (EPA Method 24)      |
| <b>Open Time:</b>   | Approx. 10 minutes          | <b>Shelf Life:</b>        | One year in unopened container |
| <b>Viscosity:</b>   | 5000 cps +/-1500            | <b>Coverage:</b>          | 240 sq ft/gal                  |
| <b>Closed Time:</b> | Approx 20 minutes           | <b>Chalk Temperature:</b> | 50°F                           |
| <b>Press Time:</b>  | Approx. 30-45 mins. @ 40psi | <b>Packaging:</b>         | 5, 55, 275 gal containers      |
| <b>Color:</b>       | White                       | <b>Coverage Rate:</b>     | 6 – 9 wet mls                  |

**OTC and SCAQMD compliant**

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



### Application:

XA-2600 adhesive is an excellent roll-coatable assembly adhesive for press lamination processes. XA-2600 has very aggressive wet tack (“grab”) properties resulting in a quick set speed to increase productivity in general wood assembly applications. XA-2600 has been formulated to provide balanced adhesive properties, which are suitable for a variety of applications where previously several glues were necessary. XA-2600 is typically applied by direct roll coating method to sheet stock. May be pumped using conventional means such as a diaphragm or gear pump.

Apply 6 – 9 wet mls onto the board stock using a glue spreader (Black Brothers A2158 dual durometer roller). Open time will be 5 – 10 minutes and working time to get a slack in the press will be between 20 – 30 minutes. Press for 30 – 60 minutes at a minimum of 40 psi. Allow at least 3 – 4 hours before machining any parts.

### Substrates to Avoid:

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



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### Limitations:

XA-2600 is not intended for exterior use or where moisture is likely. For exterior applications use F716Y, Not for structural or load bearing applications. Do not use when temperature, glue or materials are below 50°F. Freezing may not affect the function of the product but may cause it to thicken. Agitation should restore product to original form.

### 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.**