HELMITIN

Adhesives

HELMIPRENE 1685

Description

A non-flammable high solids synthetic rubber spray grade contact adhesive in aerosol cans and canisters. Helmiprene 1685 is designed for versatility with a long open time and high heat resistance.

Benefits

- High tack.
- Excellent room temperature contact bonds.
- Excellent green strength and high heat resistance.
- Fast drying with a long open time.
- Excellent bond adhesion to a variety of substrates including but not limited to DHPL, particleboard, plywood, steel, rigid plastics and rigid urethanes, etc.
- Portable and convenient.

Specifications

- **Solids Content:** 28.0% +/- 2.0%
- **Viscosity:** 275 cps +/- 50 cps
- **Weight/Gal:** 10.25 lbs +/- 0.2 lbs
- **Open Time:** 1 hour
- **Shelf Life:** 1 year
- **Color:** Green or Natural
- **Packaging:** 17 oz., 11 lb., 38 lb., 177 lb., 355 lb.
- **Flammability:** Non-flammable adhesive with a flammable propellant

Handling & Storage

- Attach gun and hose to canister and open valve completely.
- Keep valve on canister open and hose pressurized at all times.
- **Do Not** disconnect hose from empty canister until ready to reconnect to a full canister.
- Once the hose is disconnected from empty canister, open valve to insure all vapors have evacuated the canister overnight. On disposable canisters, use a non-sparking tool to punch out the knock out plug and discard of the canister.
- **Do Not** exceed the recommended "open time."
- **Do Not** use to bond vinyl due to plasticizer migration.
- For optimum performance, store canisters at 65^{o}F and above, but less than 120^{o}F.
- Avoid exposure of canisters to direct sunlight.
- Consult the Material Safety Data Sheet prior to use.

Usage Tip

In times of high humidity, "blushing" may occur. A "blush" is caused from the rapid evaporation of the solvents, which causes the temperature in the immediate area to drop. When the temperature reaches the dew point, moisture will form on the surface of the adhesive. Once the "blush" has formed, the solvent cannot penetrate the moisture, and the moisture will act as a barrier between the two glue lines. The moisture must be allowed to dry before bonding. The best method to help speed drying is with air movement. Once the moisture is removed and you give the solvents time to flash off, the bond can be made.

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Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Hold spray gun at a consistent distance of 6” to 10” from the substrates producing a web pattern across the substrates with minimal overlap.
3. The adhesive should be applied at a coating weight of 2.5 to 3.0 dry grams per sq. ft., or 80% to 100% coverage.
4. When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry apply the second coat and allow to dry properly before bonding. This helps to insure that the adhesive does not soak-in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond.
5. Allow the adhesive to dry properly before bonding. To check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer or legginess indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding. If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time. **DO NOT** use the palm of your hand to check for dryness. Dry time can vary depending on temperature, humidity and coating weight.
6. Bonds can be made as soon as the adhesive is dry. However bonds made anytime in the 1 hour open time will be strong as those made immediately after dry.
7. Position the pieces carefully, since a strong bond is made instantly upon contact.
8. Use good uniform pressure to insure good film fusion. A pinch roller is the optimum method for applying pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is applied with a J-roller.
9. The completed panel can be routed or trimmed, cut filed and machined immediately.

02/06