

Description

Helmibond 805 is a pre-catalyzed Type II PVA. It is fast setting and used for hot pressing, cold pressing, RF and general assembly.

Benefits

- Fast setting.
- Type II water resistance.
- Non staining.
- High shear strength.
- Good heat resistance.
- Excellent machining characteristics.
- Excellent bond adhesion to a variety of substrates including but not limited to DHPL, veneer, particleboard, plywood, MDF, etc.

Specifications

- **Solids Content:** 48% +/- 1.0%
- **Viscosity:** 4200 cps +/- 600 cps
- **Weight/Gal:** 9.36 lbs +/- 0.2 lbs
- **pH:** 3.5 – 4.5
- **Shelf Life:** 6 months from date of manufacture
- **Color:** White
- **Packaging:** Totes, drums, pails and gallons
- **Coverage:** 229 ft² @ 7 wet mils
- **VOC:** 0.00 lbs/gal (0 grams/L) < water and exempt solvents

Handling & Storage

- Consult the Material Safety Data Sheet prior to use.
- Avoid contact with skin and eyes. Rinse affected areas immediately with water.
- Keep container tightly closed and store off the floor when not in use.
- Product is not freeze/thaw stable. **Protect from freezing.** Product should not be used after being frozen.
- Store containers where temperatures will not be less than 10°C (50°F) and will not exceed 32°C (90°F).
- Use at room temperature 20°C (68°F).

Clean Up

Use warm water when the adhesive is in the wet state.

Disposal

Do not flush or pour wet adhesive into the sewer system without authorization from local authorities.

Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive and substrates should be at 18°C (65°F) or above.
3. Adhesive can be applied squeeze bottle, manual roller or roll coater.
4. Moisture content of wood should be 6% - 10%.
5. At least one substrate must be porous.

Statements and recommendations made herein are based on tests believed to be reliable. However, no guarantee of their accuracy or completeness is made. Unless otherwise provided in written contract, products are sold without warranties or conditions express or implied. Purchasers must make their own tests to determine the suitability of our products for their particular purpose. Les affirmations et recommandations ci-dessus sont basées sur des tests éprouvés. Toutefois aucune garantie n'est donnée quant à leur précision ou plénitude. Sauf stipulations contraires dans un contrat écrit, les produits sont vendus sans aucune forme de garantie ou condition. L'acheteur doit faire ses propres essais pour déterminer si notre produit est approprié pour ses fins particulières.

Applications

General Assembly

1. Apply 805 in a continuous coat to the entire area of one or both of the surfaces to be bonded. Adequate adhesive should be applied to achieve a slight squeeze out when clamping.
2. Clamp for 30 minutes minimum.
3. Allow a minimum of 1 hour prior to machining.

Cold and Hot Press Laminating

1. Apply using a roll coater utilizing 16 grooves/inch and apply 6 – 8 wet mils of adhesive. Plywood applications may require a higher coating of adhesive.
2. Open time is 5 minutes with a closed assembly time of 10 - 15 minutes.
3. Cold press time is a minimum of 30 minutes at 50 psi at 21°C (70°F) and an RH of 45% - 50%. Press time can be up to 2 hours depending on plant temperature, humidity, stock density, moisture content of substrates, application amount, etc.
4. For cold pressing, typical pressures are 30 psi – 100 psi for DHPL, 100 psi – 150 psi for solid core stock and 100 psi to 250 psi for veneered panels.
5. Hot pressing is performed at 82°C - 93°C (180°F - 200°F) for 60 – 90 seconds. Machining operations can be performed as soon as the panel is cool. Temperatures and press times can vary depending on substrates being bonded. A guideline chart for veneer is shown below:

Veneer Thickness	70°C (160°F)	90°C (194°F)	100°C (220°F)	120°C (250°F)
1/16"	1' 45"	1' 30"	1' 15"	1' 00"
1/8"	3' 15"	2' 22"	1' 55"	1' 40"
1/4"	6' 15"	5' 50"	4' 50'	4' 00"

Helmibond 805 meets the following standards:

CSA 0112-8M Series 1977 Type II water resistance
ANSI / HPVA 1994 Type II water resistance
NWWDA Type I and Type II Water resistance

NOTE: THIS PRODUCT MAY NOT BE COMPATIBLE WITH FIRE RETARDENT BOARD. CONSULT WITH HELMITIN TECHNICAL SUPPORT PRIOR TO USE WITH THIS TYPE OF SUBSTRATE.

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