



NYLON PRIMER 8340-2

NYLON PRIMER FOR USE WITH 2 COMPONENT URETHANE ADHESIVES

Product Description

NYLON PRIMER 8340-2 is a solvent-based solution used for priming nylon soles, uppers and other parts which are to be bonded with a 2 component polyurethane adhesive to which an isocyanate hardener has been added. NYLON PRIMER 8340-2 etches the nylon surface to make it more compatible with the adhesive and improve adhesion.

Benefits

- ✓ Ready to use
- ✓ Easy to apply
- ✓ Fast drying
- ✓ Improves initial and final bond strength on extruded and woven nylon materials

Suggested Uses

- Priming nylon soles before applying a two-part polyurethane adhesive.
- Priming nylon textile uppers before applying a two-part polyurethane adhesive.
- Priming extruded nylon tapes and weaves to improve adhesion with polyurethane and nitrile rubber adhesives.

Meets or Exceeds

- **LEED Indoor Environmental Quality Credit 4.4; Low Emitting Materials: Composite Wood and Laminate Adhesives.**
 - No added urea-formaldehyde.

Physical Properties

Base:	Proprietary
Solids Content:	8%
Viscosity:	Water thin
Specific Gravity:	1.29
Weight/Gal:	10.8 lb
Drying Time:	< 1 minute
Color:	Transparent liquid
VHAP:	9.56 lb/lb of solids
VOC:	11 lb/gal (1,323 g/L); less water and exempt solvents

Handling & Storage

- This adhesive contains halogenated hydrocarbon solvent, which can cause corrosion of aluminum. It **MUST NOT** be used in any pressurized system containing aluminum where corrosion could lead to a rapid pressure increase and possible explosion.
- 3 month shelf life from date of manufacture; 1 month after opening.
- Rotate stock to use the oldest material first.
- Product does not freeze; protect from cold nevertheless.
- Store between 10°C/50°F and 32°C/90°F.
- Keep containers tightly closed and store off the floor when not in use.
- Avoid exposure of containers to direct sunlight.
- **Do Not** apply or make bonds at temperatures below 18°C/65°F.
- Use at room temperature, 18°C/65°F, or warmer. For best results use above 21°C/72°F.

Packaging

- 5 gallon pails

Clean-Up

- Use warm water when the adhesive is in the wet state
- Cured adhesive will require scraping/sanding

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APPLICATION GUIDELINES

Surface Preparation

In order to achieve maximum bond strength, surfaces to be primed must be clean and dry. All dirt, dust, oil, moisture or other extraneous materials must be removed prior to applying the primer.

Methods of Application

By hand:

- Apply Helmitin NYLON PRIMER 8340-2 by brush to provide an even wetting of the entire surface to be bonded.
- On textile materials a scrubbing application with a stiff bristled brush is recommended; this is especially important for fine weave materials.
- Apply adhesive to the treated surface 15-60 minutes after priming.
- The adhesive **MUST** be a two-part polyurethane containing added isocyanate.
- All primed, cemented nylon surfaces must, when dry, be strongly heat reactivated to ensure good adhesion.
 - The surface temperature should reach at least 100°C, and 110-120°C is recommended with difficult materials.
 - Heating may either be at bonding, or as a separate, preliminary step.
 - If the latter, the heat-treated surfaces are allowed to cool and subsequently heat-activated/bonded by standard procedures.

Automated tape coating line

- Add 5% HARDENER 506 by weight and mix thoroughly
- Apply NYLON PRIMER 8340-2 with a roll coater or a drip/wipe applicator to the tape.
- Allow the primer to dry completely; supplemental inline drying will assist with this.
- Apply the adhesive. (polyurethane or nitrile rubber based), dry and respool.

Warranty

Because Seller has no control over methods of product application or conditions of use, its product is warranted only to be made of standard commercial grade materials and in conformance with Seller's published specifications, if any. Any recommendations for the use of the product are based on tests or experience believed to be reliable and are furnished without compensation, and Seller does not guarantee the applicability or the accuracy of this information or the suitability of its product in any given situation. Buyer must make its own tests to determine the suitability of Seller's product for Buyer's particular use and Buyer assumes all risk and liability of use of Seller's product.