



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIBOND 898

POSTFORMING PROFILE EDGE ADHESIVE

Product Description

Helmibond 898 is a postformable vinyl acetate adhesive designed for immediate bonding of HPL to particleboard, plywood, MDF, and wood. Product can be roll coated or sprayed and processed by hot laminating, hot pressing, dead stacking, and pinch rolling and stacking.

Benefits

- Waterborne.
- Solvent-free.
- Fast setting.
- Excellent mileage.
- Provides good uniform coverage in hand and automatic spray applications.
- Aggressive tack and bond that is excellent for high speed postforming applications.

Applications to Avoid

- Keep adhesive container closed tightly when not in use.
- Containers should be stored on pallets and away from outside walls and off concrete floors.
- Store containers where temperatures will not be less than 10°C/50°F and will not exceed 32°C/90°F.
- Product should not be stored in direct sunlight.
- Product should not be used after freezing.
- Thinning the adhesive is not recommended.
- Consult the Safety Data Sheet prior to use.

Health Hazard Data/Target Organ Effects

- See Safety Data Sheet for complete data.

First Aid

- See Safety Data Sheet for complete data.

Physical Properties

Solids Content:	53.0 ± 2.0%
Viscosity:	1,800 cP
Specific Gravity:	1.09
Weight/Gal.:	9.10lbs
pH:	4.0–6.0
Coverage/Gal.:	267 ft ² @ 6 wet mils
Shelf Life:	12 months from date of manufacture
Color:	White, dries clear (898) Green (898GR)
Packaging:	Totes, Drums, Pails
Freeze/Thaw:	Not freeze/thaw stable. Protect from freezing.

Clean-up

Use warm water when the adhesive is in the wet state
Dispose of waste in accordance with Provincial/State regulations

Volatile Organic Compounds (VOC):

The use, supply, sale or offer for sale of this product in certain province/states and localities may be prohibited if it exceeds certain VOC limits. Please check provincial/state and local regulations for any prohibitions on the sale and use of this product.

Proposition 65 Warning

This product contains substances known to the State of California to cause cancer or reproductive harm.

Safety

See Safety Data Sheet for complete data

Suggested Uses, Tips and Trouble Shooting

Substrates to be bonded should be clean and free from moisture, dirt, oil, and other contaminants.

Application Guidelines

Postforming

1. Adhesive film thickness should be set to a depth of 6–7 wet mils. With this application, the adhesive may be applied to one substrate.
2. Index the HPL to the particleboard or plywood core as the substrates exit the roll coater.
3. Process the panel through a commercially available hot lamination system.
4. Adhesive is to be applied to the edges of the core by spray application prior to entry into the postformer to achieve 100% coverage. The approximate atomization pressure at the gun should be 40–60 psi and the approximate fluid pressure should be 25–30 psi.
5. The top can now be postformed through any commercially available flow through postformer set up for postforming PVA type adhesives.

Panel Assembly by Roll Coating

1. Adhesive film thickness should be set to a depth of 6 to 8 wet mils. With this application, the adhesive may be applied to one substrate.
2. Index the HPL to the particleboard or plywood core as the substrates exit the roll coater.
3. At this point, the panel can be:
 - a. Dead stacked.
 - b. Pinch rolled and stacked for 30 minutes before processing.
 - c. Processed through pinch roll/hot laminating system, allowing immediate processing after the panel has cooled.
 - d. Hot pressed for a period of 1–2 minutes at approximately 82°C/93°C–180°F/ 200°F, allowing immediate processing after the panel has cooled.

Recommended Automatic Spray Equipment

	Automatic	
	Binks	DeVilbiss
Spray Gun	M95 Auto, M61, M610	AGX 550
Fluid Tip	63BSS	FF
Air Cap	66SDJG	797