



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIFAST 778

INSTANT BONDING ONE-COMPONENT WATERBORNE ASSEMBLY ADHESIVE

Product Description

One-component waterborne spray adhesive for immediate assembly in foam bonding, upholstery, and other assembly applications. Helmifast 778 exhibits instant tack, excellent green strength, and repositionability. One-sided application is possible in many uses

Benefits

- Immediate tack
- Waterborne
- Solvent-free, zero VOCs
- Excellent green strength
- High heat resistance
- Aggressive tack; Helmifast 778 permits one-way bonds in various foam-to-foam applications.
- Excellent adhesion to variety of substrates including, but not limited to, fiberglass, polyurethane foam, polyester fiber, fabric, wood, particleboard, plywood, and many plastics.

Handling & Storage

- Do Not use copper and its alloys to transfer or contain any contact adhesive.
- Do Not laminate copper/copper alloys with this adhesive.
- 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.
- Consult the Safety Data Sheet prior to use

Physical Properties

Solids Content:	52 ± 2%
Viscosity:	5,000 - 7,000 cP
Specific Gravity:	1.07
Weight/Gal:	8.92 lb
Open Time:	5 minutes with 2-way bond
Time to Tear:	4 minutes (2-way bond, PU foam) 8 minutes (1-way bond, PU foam)
Shelf Life:	6 months from date of manufacture
Color:	White (778) Green (778GR) Ultra Violet (778UV)
Packaging:	Totes, Drums, Pails, Gallon jugs
VOC:	0 lb/gal (0 g/L); less water and exempt solvents
Freeze/Thaw:	Not freeze/thaw stable. Protect from freezing.
Clean-up:	Use warm soapy water when the adhesive is in the wet state

Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive should be applied to both substrates with HVLP or siphon feed spray guns. Adhesive can be supplied using a pressure pot or double diaphragm pump, without adverse effect on adhesive performance or stability. Recommended pressure pot settings are: fluid pressure between 12 – 20 psi, with 40 -60 psi atomization pressure.
3. Adhesive coat weight and coverage will vary depending on the substrate type and porosity. It is possible for some single sided applications, such as foam to foam or foam to fabric. The open time in one-sided applications is approximately 2 minutes, and will vary depending on the amount of adhesive applied.
4. In two-sided applications, bonds can be made immediately or within the 5 minute open time. Open time will vary depending on substrate and amount of adhesive applied.
5. In some two-sided applications, repositionability is achievable with adhesive. Repositioning should be performed as soon as possible while the adhesive is still tacky. Repositionability should be tested and validated by the customer through their verification processes

Recommended Equipment

	BINKS	DeVILBISS	WALTHER
Spray Gun	Mach 1 HVLP	JGHV-531	Pilot XIII-ND
Fluid Tip	97 (.070)	E (.070)	1.8 mm, 2.0mm, 2.2mm
Air Cap	94P, 95P	83MP	

*Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be reinforced PVC or nylon lined with a minimum ID of 1/2".

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.