



HELMISTIK 1675

CALIFORNIA, LEED/OTC COMPLIANT LOW VOC, SPRAY GRADE ADHESIVE

Product Description

A "California, LEED & OTC Compliant", Low VOC, High Solids Synthetic Rubber Spray Grade Contact Adhesive with Excellent Green Strength in Canister and Aerosol Cans.

Benefits

- Low VOC – California/OTC, LEED Compliant
- HAPs Free (Hazardous Air Pollutants)
- High Tack
- Aggressive Room Temperature Contact Bonds
- Excellent Green Strength and High Heat Resistance
- Fast Drying with a Long Open Time
- Excellent Sprayability
- Bonds HPL, Particleboard, Plywood, Steel, and Numerous Types of Plastics, etc.
- Portable and Convenient

Clean-up

- Using Solvent 665
- Dispose of waste in accordance with provincial/state regulations.

Shipping Information

- Ship Domestic Ground
- CHEMICAL UNDER PRESSURE, FLAMMABLE, N.O.S. (Petroleum Gases, Liquefied; Methyl Acetate), Class 2.1, UN3501

Physical Properties

Base:	Synthetic Rubber
Adhesive Solid's Content:	
Canister Solid's Content:	
Viscosity:	260 cP
Specific Gravity:	0.95
Weight/Gal.:	7.9 lb
Open Time:	60 minutes
Color:	Amber (1675) Red (1675RD)
Packaging:	Aerosol Cans, Small, Medium, Large Canisters
VHAP:	0.0 lbs/lb Solids
VOC:	0.63 lb/gal (77 g/L)
Freeze/Thaw:	Does Not Freeze; Agitate Well After Warming to 22°C/72°F; If Chilled Below 10°C/50°F
Flammability:	Extremely Flammable
Shelf Life:	12 Months from Date of Manufacture

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*SEE SDS FOR REGULATORY INFORMATION

Suggested Uses

- Ideal for Horizontal & Vertical Applications (Flatwork)
- Excellent Green Strength for Bonding HPL, Particleboard, Plywood, Steel and Rigid Plastics and Urethanes, etc.
- Do Not use to bond vinyl due to plasticizer migration.

Specifications

Meets or Exceeds:

LEED Indoor Environmental Quality Credit 4.1; Low Emitting Materials: Adhesives and Sealants.

LEED Indoor Environmental Quality Credit 4.4; Low Emitting Materials: Composite Wood and Laminate Adhesives.

- VOC content less than limits imposed by the State of California's South Coast Air Quality Management District (SCAQMD) Rule #1168.
- Does Not contain chloroform, ethylene dichloride, methylene chloride, perchloroethylene or trichloroethylene and, as such, are California compliant.
- No Added urea-formaldehyde during adhesive manufacturing.

Health Hazard Data/Target Organ Effects

See Safety Data Sheet for complete data.

First Aid

See Safety Data Sheet for complete data.

Volatile Organic Compounds (VOC) Warning

N/A

Proposition 65 Warning

N/A

Usage Tips

1. An issue called "Blushing" may occur during high humidity – this happens when solvents rapidly evaporate causing the temperature of the adhesive surface to drop below dew point. Condensation that forms on the surface of the adhesive from "Blushing" acts as a barrier between the two glue lines preventing it to bond. The moisture Must be completely dried before bond, and the best method to help speed up drying is with air movement. The bonds can be made when the moisture and solvents have completely evaporated.
2. A bond that fails may have a shiny appearance on the surface of the adhesive. This is an indication that the recommended open time was exceeded and/or inadequate pressure was applied during assembly. Do Not Exceed the Recommended Open Time.
3. A dull appearance to the adhesive surface indicates that an

Safety

See Safety Data Sheet for complete data.

- FLAMMABLE LIQUID AND VAPOR. VAPOR MAY CAUSE FLASH FIRE. VAPOR MAY TRAVEL TO AREAS AWAY FROM WORK SITE BEFORE IGNITING/FLASHING BACK TO VAPOR SOURCE. USE ONLY IN WELL VENTILATED AREA. Keep away from heat, sparks and open flame. Prevent buildup of vapors. Open all windows and doors. Do not smoke when vapors are present.
- Extinguish all flames and pilot lights. Turn off stoves, heaters, electric motors. Turn off all potential ignition sources during use and until vapors are gone.
- Purchaser must obtain complete information on health and fire precautions from local officials in order to adequately protect personnel and property.
- Avoid repeated breathing of vapors. Avoid contact with skin. Do not take internally.
- NFPA 33 states non-ASME pressure-pot pressure shall not exceed 15 psi when filled with amammable liquids

Canister Equipment Set-Up

1. Attach and securely tighten each end of a recommended hose (length can vary by choice) to the matching fitting on the spray gun and canister. Turn the trigger pull adjusting nut to the fully closed position to prevent accidental adhesive discharge from the spray gun.
2. Check the fittings for tightness, and position and tighten the spray tip on the spray gun. Plumbers tape is recommended to ensure a tight seal. Slowly open the valve on the canister to start the flow of adhesive and check for leaks. Partial opening is recommended initially, and if there are no leaks, fully open the canister valve.
3. To open the trigger pull adjusting nut on the spray gun, turn 4 - 6 times. Discharge the spray gun and adjust the spray pattern to achieve a consistent spray of the desired width. You are ready to apply adhesive.

Application Guidelines

1. The surface of the substrates to be bonded with Helmistik 1675 must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants that will affect adhesive performance. Apply abrasion to extremely smooth to achieve best adhesion. Acclimatize all substrates in the same environment at a temperature of 65°F/18°C, or higher, for 72 hours prior to bonding.
2. Hold the spray gun at a consistent distance of 6" - 10" from the substrates. Apply the adhesive at a coating weight of 2.5 - 3.0 dry grams per ft² producing a web pattern across the substrates with minimal overlap. Contact adhesives do not form a one-way bond, it is necessary to apply 80% - 100% coverage on both surfaces.
3. Allow the adhesive to dry properly before bonding. Use the back of your fingers to check for dryness by pressing into the adhesive and lift up. (Do Not use the palm of your hand to check for dryness).
Any adhesive transfer or legginess indicates more dry time is required.
Heavy areas on the adhesive may indicate a skin has formed on the surface of the adhesive. Press the back of your fingers and twist into the adhesive, if it tears open, more dry time is required.
The adhesive will be ready for bonding when it feels tacky, but there is no transfer or legginess.
4. Temperature, humidity and coat weight will affect drying time. Reduce drying time by using air movement, drying ovens, etc. Full adhesive strength will be reached in 24 hours.
5. Apply two coats of Helmistik 1675 to porous materials such as plywood and edges. Allow the first coat to dry (this will act as a sealer) before applying the second coat. Allow the second coat to dry properly before bonding. Bonds can be made as soon as the adhesive is dry.
6. Bonds made any time within the one hour open time will be as strong as those made immediately after drying. Position the pieces carefully, as a strong, irreversible bond is made instantly upon contact.

7. Apply uniform pressure to ensure proper fusion of the adhesive. A pinch roller is recommended for applying pressure. Use the maximum amount of pressure without damaging the substrates. Minimum recommended pressure is 25 psi. This is easily achieved with a 3" J-roller.
8. Do Not Use RUBBER MALLETS, BLOCKS OF WOOD, FLOORING ROLLERS, ETC. to apply pressure.
9. Completed panels can be processed immediately.

Frequent Use of Canister

1. Leave the hose and gun assembly attached to the canister and leave the canister valve open. This will keep the hose and gun charged with adhesive. Completely close the trigger pull adjusting nut when not in use. Adjust the trigger pull adjusting nut as desired to continue spraying again.
2. Regular gun and hose maintenance and cleaning is recommended for best performance. Clean the spray tip with Helmitin Solvent 665 or Helmitin Citrus Cleaner on a daily basis to avoid excessive adhesive build-up. The use of metallic objects to clean the tip is not recommended as this will cause damage to the tip and create an irregular spray pattern.

Canister Storage/Change Over

1. When the canister is not in use for two weeks or longer, turn the canister valve completely off and dispense all material in the hose and gun assembly. Once empty and no pressure is present when the spray gun trigger is depressed, slowly disconnect the hose from the canister. Protect adjacent surfaces from any material that may drip from the hose.
2. The hose and gun may be cleaned by attaching the hose to Helmitin Citrus Cleaner canister and flushing with a small amount of the cleaner. The hose may also be cleaned by removing the spray gun and manually flushing it with Helmitin Solvent 665. Cleaning the closed canister valve with a small amount of either Helmitin Solvent 665 canister or a small amount of Helmitin Citrus Cleaner aerosol will help to prevent residual adhesive from sealing it shut.

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