



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMITAC 1620

HAPS-FREE, FAST GRABBING CANISTER CONTACT ADHESIVE

Product Description

Helmitac 1620 HAPs Free is an extremely tacky contact adhesive available in canisters. It is designed for light duty, low stress bonding applications such as installation of fiberglass batting and applying urethane foams and fabrics to a variety of substrates.

Benefits

- HAPs Free.
- Extremely aggressive tack.
- Excellent green strength.
- High heat resistance.
- Fast drying with a long open time.
- Excellent adhesion to many substrates.
- Good spray pattern.
- Great coverage.
- Portable and convenient.

Clean-up

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

Shipping Information

- Ship Domestic Ground
- CHEMICAL UNDER PRESSURE, FLAMMABLE, N.O.S. (DIMETHYL ETHER, HEPTANE), Class 2.1, UN3501

Physical Properties

Base:	Synthetic Rubber
Adhesive Solids Content:	40.0 ± 1.0%
Canister Solids Content:	24.0 ± 1.2%
Viscosity:	300 cP
Specific Gravity:	0.83
Weight/Gal.:	6.92 lbs
Open Time:	60 minutes
Color:	Clear
Packaging:	280 lbs, 140 lbs, 30 lbs Canisters
VHAP:	0.0 lbs/lb Solids
VOC:	3.30 lbs/gal. (395 g/L)
Freeze/Thaw:	Does Not Freeze; agitate well after warming to 22°C/72°F if chilled
Flammability:	Extremely Flammable Gas
Shelf Life:	12 months from date of manufacture

Specifications

Meets or Exceeds:

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

Health Hazard Data/Target Organ Effects See Safety Data Sheet for complete data

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*SEE SDS FOR REGULATORY INFORMATION

Specifications Continued

Volatile Organic Compounds (VOC) Warning

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 local/state/provincial/federal regulations for any prohibitions on the sale and use of this product.

Proposition 65 Warning

N/A

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 flammable liquids.

Suggested Uses, Tips, and Trouble Shooting

1. Ideal for bonding Fiberglass Insulation, Urethane foams, Upholstery, Felt/Fabrics, Duct Liner Wrap, Wood, Most Plastics, Paper Products and Glasswork.
2. Not for use on decorative high pressure laminate applications.
3. Attach gun and hose to canister and open valve completely. Keep valve on canister open and hose pressurized at all times. Do Not disconnect hose from empty canister until ready to reconnect to a full canister. Once the hose is disconnected from empty canister, open valve to ensure all vapors have evacuated the canister overnight. On disposable canisters, use a non-sparking tool to punch out the knock out plug and discard the canister. Do Not exceed the recommended open time.
4. Do Not use to bond unbacked PVC due to plasticizer migration.
5. For optimum performance, store canisters at 18°C/65°F and above, but less than 49°C/120°F.
6. Avoid exposure of canisters to direct sunlight.
7. In times of high humidity, "blushing" may occur. A "blush" is caused from the rapid evaporation of the solvents, which causes the temperature in the immediate area to drop. When the temperature reaches the dew point, moisture will form on the surface of the adhesive. Once the "blush" has formed, the solvent cannot penetrate the moisture, and the moisture will act as a barrier between the two glue lines. The moisture must be allowed to dry before bonding. The best method to help speed drying is with air movement. Once the moisture is removed and you give the solvents time to flash off, the bond can be made.
8. A dull appearance is a symptom of under-applying adhesive.
9. A very shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time. Keep adhesive container closed tightly when not in use.

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Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Hold spray gun at a consistent distance of 6" – 10" from the substrates producing a web pattern across the substrates with minimal overlap.
3. The adhesive should be applied at a coating weight of 2.5 – 3.0 dry grams per ft², at the same time achieving 80 – 100% coverage.
4. Allow the adhesive to dry properly before bonding. To check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer or legginess indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding. If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time. Do Not use the palm of your hand to check for dryness. Dry time can vary depending on temperature, humidity and coat weight. Drying time can be reduced using air movement, drying ovens, etc.
5. When applying Helmitac 1620 HAPs Free to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry, apply the second coat and allow to dry properly before bonding. This helps to ensure that the adhesive does not soak in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond. Bonds can be made as soon as the adhesive is dry. Bonds made any time in the 1 hour open time will be as strong as those made immediately after drying.

7. Position the pieces carefully, as a strong bond is made instantly upon contact.
8. Apply good uniform pressure to ensure good film fusion. A pinch roller is the best method for applying pressure. Use the maximum possible pressure without damaging the substrates.
9. Minimum recommended pressure is 25 psi. This is easily achieved with a 3" J-roller. Rubber mallets, blocks of wood, and flooring rollers do not apply adequate pressure. Completed panels can be processed immediately.

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