



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIFAST 778

INSTANT BONDING ONE-COMPONENT WATERBORNE ASSEMBLY ADHESIVE

Product Description

HELMIFAST 778 is a one-component waterborne adhesive for the immediate assembly of foam and foam backed vinyls/textiles to a wide variety of rigid/semi-rigid core materials, upholstery where instant tack, excellent green strength, and repositionability are needed. A one-sided application is possible in some applications.

Benefits

- ✓ Waterborne - Solvent-free, zero VOCs
- ✓ No Drip formulation
- ✓ Immediate tack
- ✓ Excellent green strength
- ✓ High heat resistance
- ✓ Repositionable for an extended period
- ✓ Versatile - bonds: fiberglass, polyurethane foam, EPS/XPS foams, polyester fiber, fabric, wood, particleboard, plywood, some plastics

Suggested Uses

- Acoustic panel laminating
- Laminating polyurethane foam backed vinyls to pressed fiberglass cores for large vehicle sound dampening
- Bonding insulation, lauan, upholstery foams/textiles for RV and transportation vehicle interior components.
- Office partition assembly
- Mattress laminating
- **Do Not** laminate copper or its alloys with this adhesive.
- **Do Not** use with unbacked, plasticized vinyls.

Meets or Exceeds

- **LEED Indoor Environmental Quality Credit 4.1; Low Emitting Materials: Adhesives and Sealants**
 - VOC content less than limits imposed by the State of California's South Coast Air Quality Management District (SCAQMD) Rule 1168 (80g/L, less water and exempt solvents)
- **LEED Indoor Environmental Quality Credit 4.4; Low Emitting Materials: Composite Wood and Laminate Adhesives**
 - No added urea-formaldehyde

Physical Properties

Base:	Polychloroprene
Solids Content:	50 - 54%
Viscosity:	5,000 - 7,000 cP @ 20°C
Specific Gravity:	1.07
Weight/Gal:	8.92 lb
Open Time:	5 minutes with 2-way bond 4 minutes (2-way, PU foam) 8 minutes (1-way, PU foam)
Time to Tear:	
Color:	White (778), Green (778GR), Beige-Yellow (778UV)
VHAP:	0lb/lb of solids
VOC:	0 lb/gal (0 g/L); less water and exempt solvents

Handling & Storage

- 6 month shelf life from date of manufacture.
- Rotate stock to use the oldest material first.
- **Not Freeze/Thaw Stable. Protect from Freezing.** Product cannot be used after being frozen.
- Store between 10°C/50°F and 32°C/90°F.
- Keep containers tightly closed and store off the floor when not in use.
- If the container has been sitting for a period of time and has settled, stir thoroughly before using.
- Avoid exposure of containers to direct sunlight.
- HELMIFAST 778 may be supplied by pressure pot or double diaphragm pump.
- Supply equipment, fittings and plumbing coming into contact with this adhesive must be plastic or stainless steel.
- **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

- 275 gallon totes, 53 gallon drums, 5 gallon pails

Clean-Up

- Use warm, soapy water when the adhesive is in the wet state
- Dry adhesive: Use HELMITIN SOLVENT 665 or CITRUS CLEANER

HELMITIN ADHESIVES
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*SEE SDS FOR REGULATORY INFORMATION

APPLICATION GUIDELINES**Conditioning of Materials**

Substrates made of materials prone to changing dimensions with variations in moisture content and/or temperature should be stabilized before assembly. Allow such substrates to acclimate together at the same temperature and humidity for at least 48 hours before bonding. Optimum conditions are approximately 22°C/72°F and relative humidity of 45% - 55%. Provisions should be made for the circulation of air around the components.

Adhesive Application

1. Ensure that the spray system oil and water traps are functioning, drained regularly and are at least 25' from the air compressor.
2. Substrates to be bonded with HELMIFAST 778 must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants.
3. For best performance, HELMIFAST 778 should be spray applied to the surfaces of both substrates with a HVLP or siphon feed spray gun to leave a light to medium, even coating of adhesive on both of substrates.
 - i. Adhesive coat weight and coverage will vary depending on the substrate type and its porosity. 2.0 - 3.5 dry grams/square foot is suggested.
 - ii. One-sided application is possible with lightweight substrates in low stress applications (i.e. foam to foam or foam to fabric.)
4. Bonds can be made while wet, immediately after application, or at any time within the open time of the adhesive. Open time will vary depending on the substrates used and the amount of adhesive applied.
 - i. For one-sided applications the open time is approximately 2 minutes
 - ii. For two-sided applications the open time is approximately 5 minutes
5. Repositioning of bonded parts is possible with some substrates and can only be performed while the adhesive is still tacky. Repositioning should be performed as soon as possible. Repositionability should be tested and validated.
6. Apply uniform pressure to ensure proper fusion of the adhesive surfaces. Apply the maximum amount of pressure possible without damaging the substrates.

Note

- This adhesive can be supplied using a pressure pot or double diaphragm pump, without adverse effect on its stability. Recommended pressure settings with 3/8" I.D. hoses and fittings are: fluid pressure: 8 – 20 psi and atomization air pressure: 40 -60 psi.

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.

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