



**HELMITIN**  
QUALITY ADHESIVE SOLUTIONS

# SATREAT

## RUBBER SURFACE ADHESION PROMOTER

### Product Description

SATREAT is a unique system that facilitates the bonding of many rubber compounds to a wide range of synthetic and natural materials (vinyl, polyurethane, polymeric, leather, canvas, primed nylon, primed EVA, foam rubbers, etc.) when used with Helmitin HELMIPLAST polyurethane adhesives..

### Benefits

- ✓ Easy to use
- ✓ Dissolves quickly
- ✓ Improves bond strength to most rubbers
- ✓ Excellent mileage

### Suggested Uses

Designed primarily as a chlorinated primer to promote adhesion to most rubber compounds (e.g. Kraton, composition foam, etc.) when used in conjunction with our line of Helmitin HELMIPLAST polyurethane-type adhesives.

### Surface Preparation

All materials to be primed with SATREAT must be clean, dry, and free of dirt, dust, oil or other extraneous materials. Wiping or washing of substrates to be primed with SOLVENT 672 is recommended in order to remove mold release agents or other foreign materials. Some "difficult-to-bond" rubber compounds may require roughing prior to SATREAT application. Adhesion tests performed by Helmitin laboratories are strongly recommended on all materials prior to commencing production.

### Mixing

The SATREAT system consists of SATREAT A solvent and SATREAT B powder. To mix one gallon of SATREAT add one 68 gram bag of SATREAT B powder to one gallon of SATREAT A solvent. To mix smaller volumes the ratio is 2% by weight SATREAT B (e.g. 2 g SATREAT B + 98 g SATREAT A). Add the powder to the solvent and agitate thoroughly in a tightly sealed PLASTIC container until all of the powder has dissolved. Once mixed, SATREAT must be used within 3 days. NEVER MIX OR APPLY SATREAT SOLUTION IN CONTACT WITH METAL

### Bonding

**Heat Reactivation:** Heat reactivate the dried adhesive surfaces to 75-80 C (167-176F), then combine the materials with as much pressure as is practical.

**Solvent Reactivation:** Solvent wipe the dried adhesive surfaces with SOLVENT 675, then immediately bond as above.

### Application

The mixed SATREAT solution may be applied to the substrates with a hard bristle brush (no metal parts) or a cotton cloth (non-synthetic to avoid static sparks). Avoid skin contact. Hard or difficult to bond rubbers will require the SATREAT to be scrubbed into the freshly roughed compound with a firm bristle brush. Avoid scrubbing of compounds such as soft TPR. Allow a minimum of one hour after SATREAT application before applying a topcoat of HELMIPLAST polyurethane adhesive. Freshly cemented materials must be allowed 1-2 hours to dry. Overnight drying where possible is recommended. Sole attaching, especially with soft TPR, should be done the following day. Exhausting of solvent fumes is essential. This can be achieved by the use of a downward draft table (see schematic).

### Handling & Storage

- 12 month shelf life from date of manufacture.
- Rotate stock to use the oldest material first.
- Freeze/Thaw Stable; if chilled below 10°C/50°F warm to 22°C/72°F.
- Store between 10°C/50°F and 32°C/90°F.
- Keep container tightly closed and stored off of the floor when not in use.
- Avoid exposure to direct sunlight.
- **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 22°C/72°F.

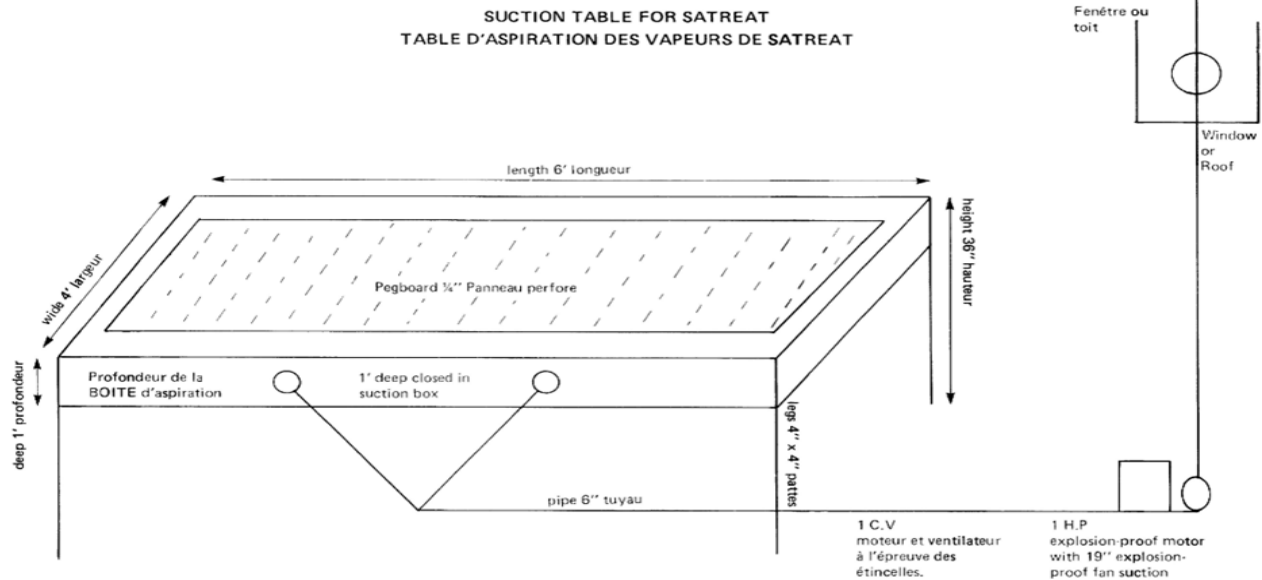
### Packaging

- SATREAT A - 5 gallon pail
- SATREAT B - 1 overpack bag containing 5 X 68 gram bags

### HELMITIN ADHESIVES

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\*SEE SDS FOR REGULATORY INFORMATION



### SATREAT Residues

The white powder resulting from the evaporation of SATREAT (e.g. the drips from drainage racks) must be treated with the same precautions as the active powder before solution. The powder forms a fire risk when mixed with fine organic materials (e.g. rubber dust from scouring operations). The following precautions must be followed:

- Check every week for white deposits in the SATREAT applying areas.
- Do not allow buildup to occur or remain in contact with metal surfaces.
- Do not allow residues to mix with dust from other operations.
- Where drips occur, it is suggested that they be caught in a disposable polyethylene bag which is sealed and properly disposed of at least weekly.

### 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.*