



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMISTIK 1516

HAPS FREE EPS BONDING CONTACT ADHESIVE

Product Description

A HAPs-free flammable high solids synthetic rubber spray grade EPS and general purpose adhesive. HELMISTIK 1516 is designed for versatility with a long open time and high tack level with excellent strength for general purpose applications.

Not for use with decorative high pressure laminate (HPL).

Physical Properties

Base:	Synthetic rubber
Solids Content:	30 ± 2%
Viscosity:	250 - 350 cP
Specific Gravity:	0.78
Weight/Gal:	6.51 lb
Open Time:	60 minutes
Shelf Life:	12 months from date of manufacture
Color:	Natural
Packaging:	Drums, Pails
VHAP:	0.1 lb/lb of solids
VOC:	4.56 lb/gal (456 g/L); less water and exempt solvents
Freeze/Thaw:	Not freeze/thaw stable. Protect from freezing.

Benefits

- HAPs-FRee
- High Tack
- Excellent room temperature
- Excellent green strength
- Fast drying with a long open time
- Bonds EPS (styrofoam), carpet, polyurethane foam, fabric, leather, plywood, particleboard, rigid plastics, etc.

Handling & Storage

- Do Not exceed the recommended open time.
- Consult the Safety Data Sheet prior to use.
- Avoid contact with skin and eyes. Rinse affected areas immediately with water.
- Keep container tightly closed and store off the floor when not in use.
- Protect from freezing.
- Store containers where temperatures will not be less than 10°C/50°F and will not exceed 32°C/90°F.
- Use at room temperature 20°C/68°F.

Usage Tips

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.

HELMITIN

Toll Free: 877.823.2624
inquiries@helmitin.com
helmitin.com

*SEE SDS FOR REGULATORY INFORMATION

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.

Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. The adhesive should be applied at a coating weight of 2.8 to 3 dry grams per ft² to achieve 80% coverage by hand spray application, with near 100% coverage around the edges. For automatic spray applications, a minimum of 2.5 dry grams per ft² should be applied. The atomization pressure at the gun should be 80 to 100 psi, fluid pressure should be 10 to 15 psi.
3. When applying Helmistik 1516 to porous materials, it may be necessary 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.
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. 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.
6. Position the pieces carefully, as a strong bond is made instantly upon contact.
7. 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. 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.
8. Completed panels can be processed immediately.

HELMITIN

Toll Free: 877.823.2624
inquiries@helmitin.com
helmitin.com



*SEE SDS FOR REGULATORY INFORMATION