



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMITAC 1521

HIGH SOLIDS PRESSURE SENSITIVE FOAM & INSULATION TACKING ADHESIVE

Product Description

HELMITAC 1521 is a high solids, flammable, HAPs-free, synthetic rubber adhesive with prolonged pressure sensitive tack and high green strength for bonding lightweight substrates such as fiberglass/rockwool insulation and many types of foam.

Benefits

- ✓ Fast drying
- ✓ Pressure sensitive
- ✓ High solids and coverage per gallon
- ✓ Excellent spray characteristics
- ✓ Quick, high strength bond
- ✓ Versatile - bonds fiberglass/rockwool insulation, many types of foam, lightweight overlays, etc. to plywood, particleboard, lauan, rigid plastics, etc.

Suggested Uses

- Tacking insulation in wall panel construction
- Upholstered furniture and components
- Marine & RV carpeting, trim and components
- Lamination of a wide range of lightweight, porous and non-porous materials to themselves and each other, or to rigid core materials.
- **Do Not** use with unbacked, plasticized vinyls.
- **Do Not** use to laminate HPL, wood veneers or rigid metal overlays..

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:	Synthetic rubber
Solids Content:	33 - 37%
Viscosity:	400 - 600 cP
Specific Gravity:	0.96
Weight/Gal:	8.0 lb
Coverage/Gal:	508 ft ² @ 2.5 dry grams/ft ²
Open Time:	Pressure Sensitive
Color:	Amber (1521)
VHAP:	0 lb/lb of solids
VOC:	0.39lb/gal (47 g/L); less water and exempt solvents

Handling & Storage

- 12 month shelf life from date of manufacture.
- Rotate stock to use the oldest material first.
- Does Not Freeze; If chilled below 10°C/50°F – agitate well after first warming to 22°C/72°F.
- Store between 10°C/50°F and 32°C/90°F.
- Keep container tightly closed and store off of the floor when not in use.
- Avoid exposure of canisters 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 21°C/72°F.

Packaging

- 53 US Gallon Drums, 5 US Gallon Pails

Clean-Up

- Use HELMITIN SOLVENT 665 or CITRUS CLEANER
- **Never** use lacquer thinner to thin adhesive or clean equipment.

APPLICATION GUIDELINES

Conditioning of Materials

If the components to be bonded are subject to dimensional changes caused either by variations in temperature or moisture content, they should be allowed 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. Substrates to be bonded should be clean and free from moisture, dirt, oil, and other contaminants.
2. Suggested fluid pressure is 5 to 15 psi and atomization pressure 30 to 50 psi.
3. The application amount will vary depending on the substrates and their porosity. The adhesive can be applied to one or both substrates. If using one-sided, at least one of the substrates must have sufficient porosity to allow any trapped solvents to evaporate.
4. Allow the adhesive to dry properly before bonding. Dry time will vary depending on temperature, humidity and amount applied.
5. Drying time can be reduced using air movement, drying ovens, etc.
6. Bonds can be made as soon as the adhesive is dry. As HELMITAC 1521 is pressure sensitive, bonds made any time after drying will be strong as those made immediately after drying.
7. Position the pieces carefully, as a strong bond is made upon contact.
8. Apply good, uniform pressure to all areas to ensure 100% contact.

Note

- A drying issue called "**Blushing**" often occurs under extremely humid conditions. "**Blushing**" occurs when rapidly evaporating solvents cause the temperature of the adhesive surface to drop below dew point. Condensation then forms on the surface of the adhesive and acts as a barrier to further drying; it also interferes with the fusion of the two glued surfaces and prevents them from bonding. All moisture must be completely evaporated before bonding. Moderate air movement (shop fan) is the preferred method to speed drying while reducing or eliminating "Blushing" issues. Bonds can be made once all moisture and solvents have completely evaporated.
- A failed contact adhesive bond with a shiny appearance to the surface of the adhesive is an indication that the recommended open time was exceeded and/or that inadequate laminating pressure was applied during assembly.
- **Apply Sufficient Laminating Pressure!**
- Thinning the adhesive is not recommended.

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.