

HELMISTIK NF 1529

NON-FLAMMABLE FOAM BONDING & UPHOLSTERY ADHESIVE

Product Description

HELMISTIK NF 1529 is used in the foam fabricating and conversion industries for bonding flexible foam to itself and to many other materials including polyester fiber-fill, wood, plywood, particleboard and many plastic and metal surfaces. The adhesive exhibits aggressive tack, high green strength and rapid development of foam-tearing bonds. HELMISTIK NF 1529 dries to a soft, flexible, non-staining and non-dimpling film

Benefits

- ✓ Exceptional sprayability
- ✓ Can be used with Critter™ and other siphon spray guns
- ✓ Aggressive tack
- ✓ Long open time
- ✓ High Green Strength
- ✓ Fast drying
- ✓ Non-flammable

Suggested Uses

- Foam bonding and fabricating
- Mattresses
- Upholstered furniture and components
- Marine & RV carpeting, trim and components
- Lamination of a wide range of light to medium weight, 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..

Certifications & Compliance

- Complies with SCAQMD Rule 1168 VOC limits

Physical Properties

Base:	Synthetic rubber
Solids Content:	21 +/- 2%
Viscosity:	100-200 cP
Specific Gravity:	1.24
Weight/Gal:	10.0 lb
Coverage/Gal:	555 ft² @ 1.8 dry grams/ft²
Open Time:	60 minutes
Color:	Natural (1529) Pink (1529PK)
VHAP:	3.76 lb/lb of solids
VOC:	0.0 lb/gal (0.0 g/L); less water and exempt solvents

Handling & Storage

- This adhesive contains halogenated hydrocarbon solvent, which can cause corrosion of aluminum. It ***MUST NOT*** be used in any pressurized system containing aluminum where corrosion could lead to a rapid pressure increase and possible explosion.
- 12 month shelf life from date of manufacture in unopened containers.
- Rotate stock to use the oldest material first.
- Freeze/Thaw Stable - if chilled, warm 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** transport or store in the passenger compartment of vehicles.
- **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, 1 US Gallon Cans

Clean-Up

- HELMITIN SOLVENT 699 or CITRUS CLEANER
- **Never** use lacquer thinner to thin adhesive or clean equipment.

HELMITIN ADHESIVES
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*SEE SDS FOR REGULATORY INFORMATION

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. Application amount will vary depending on the substrates and their porosity. Adhesive is normally applied to both substrates, but can be one-side bonded if the porosity of one of the substrates will allow trapped solvents to evaporate.
4. Allow the adhesive to dry properly before bonding. Drying time will vary depending on temperature, humidity and coat weight.
5. Drying time can be reduced using air movement, drying ovens, etc.
6. Bonds can be made as soon as the adhesive is dry. Bonds made any time in the 60 minute open time will be 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 ***all*** areas to ensure 100% fusion of the bonded surfaces.

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.
- 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.

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HELMITIN
QUALITY ADHESIVE SOLUTIONS

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