



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMISTIK 1531

FLAMMABLE FOAM BONDING & UPHOLSTERY ADHESIVE

Product Description

A flammable synthetic rubber spray grade upholstery adhesive. Helmistik 1531 was designed as a premium quality and fast drying adhesive for fast assembly of upholstery components.

Benefits

- Excellent room temperature contact bonds
- Quick initial tack
- Fast drying with a long open time
- Excellent spray characteristics
- Can be used with Critter™ & other siphon spray guns
- Good heat resistance
- Bonds fabrics, polyurethane foam, foam rubber, wood, etc.

Caution

- Consult the Safety Data Sheet prior to use.
- Helmistik 1531 contains flammable solvents. Use the same precautions as when handling gasoline.
- Adequate ventilation must be provided in work areas.
- Purchasers must obtain complete information on health and fire precautions from local officials in order to adequately protect personnel and property.
- Do Not smoke when using.
- Do Not apply or bond at temperatures below 18°C/65°F.
- Not to be taken internally.

Physical Properties

Base:	Synthetic rubber
Solids Content:	35 ± 2%
Viscosity:	100 - 200 cP
Specific Gravity:	0.81
Weight/Gal:	6.8 lb
Open Time:	30 minutes
Shelf Life:	12 months from date of manufacture
Color:	Amber (1531), Pink (1531PK)
Packaging:	Drums, Pails, Gallon cans
VHAP:	0.56 lb/lb of solids
VOC:	3.97 lb/gal (476 g/L); less water and exempt solvents
Freeze/Thaw:	Does not freeze; agitate well after warming to 22°C/72°F if chilled
Clean-up:	Use Helmitin Solvent 665

Handling & Storage

- Do Not use with decorative plastic laminate, wood veneers or metal overlays.
- Do Not exceed the recommended open time.
- Do Not use to bond unbacked PVC due to plasticizer migration.
- Thinning the adhesive is not recommended.
- Never use lacquer thinner for thinning.
- Store and use at room temperature 20°C/68°F.
- Keep adhesive container closed tightly when not in use.

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.

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.

Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Application amount will vary depending on the substrates and the porosity. Adhesive is normally applied to both substrates, but can be one-side bonded if porosity of one of the substrates will allow trapped solvent to evaporate. The atomization pressure at the gun should be 40 to 60 psi, fluid pressure should be 10 to 15 psi.
3. Allow the adhesive to dry properly before bonding. Dry time can vary depending on temperature, humidity and coating weight. Drying time can be reduced using air movement, drying ovens, lamps, etc.
4. Bonds can be made as soon as the adhesive is dry. Bonds made any time in the 30 minute open time will be strong as those made immediately after drying. Open time will vary depending on the substrates.
5. Position the pieces carefully, since a strong bond is made instantly upon contact.
6. Apply good uniform pressure to ensure good film fusion.