



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMISTIK NF 1535

HIGH SOLIDS, NON-FLAMMABLE FOAM & UPHOLSTERY ADHESIVE

Product Description

HELMISTIK NF 1535 is a high solids, nonflammable foam and upholstery adhesive with aggressive tack, high green strength and a long open time. It is also suitable for the general assembly of a wide variety of lightweight porous and nonporous substrates. **Not for use with decorative high pressure laminate (HPL) or in EPS bonding applications.**

Benefits

- ✓ Non-flammable
- ✓ Excellent spray characteristics
- ✓ Fast drying
- ✓ Long open time
- ✓ Aggressive tack
- ✓ Immediate, irreversible high strength bonds
- ✓ Good heat resistance

Suggested Uses

- Foam bonding and fabricating
- Upholstered furniture and components
- Mattress fabrication
- 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.

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:	28 - 32%
Viscosity:	300 - 500 cP
Specific Gravity:	1.2
Weight/Gal:	10 lb
Coverage/Gal:	360 ft ² @ 3.0 dry grams/ft ² ; 180 ft ² completed bond
Open Time:	60 minutes
Color:	Natural (1535) Pink (1535PK)
VHAP:	2.33 lb/lb of solids
VOC:	0 lb/gal (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.
- Rotate stock to use the oldest material first.
- Freeze/Thaw Stable; if chilled below 0°C/32°F – agitate well after first warming to 22°C/72°F.
- Store between 10°C/50°F and 30°C/85°F.
- Keep container tightly closed and store off of the floor when not in use.
- Avoid exposure of canisters to direct sunlight.
- 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

- Non-flammable HELMITIN SOLVENT NF 699 is suggested.
- **Do Not** use lacquer thinner or flammable solvents to thin this adhesive.
- Equipment may be cleaned with flammable SOLVENT 665.
- Ensure that all flammable solvent residues have evaporated before reintroducing HELMISTIK NF 1535 to spray 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. 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.

