



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMITAC 1621

LOW VOC, HAPS-FREE, FAST GRABBING CANISTER CONTACT ADHESIVE

Product Description

Helmitac 1621 is a low VOC, HAPS-free, extremely tacky contact adhesive packaged in canisters. It is designed for light duty, low stress bonding applications such as installation of fiberglass batting and applying urethane foams and fabrics to a variety of substrates.

Benefits

- ✓ HAPs Free
- ✓ Extremely aggressive tack
- ✓ Excellent green strength
- ✓ High heat resistance
- ✓ Fast drying with a long open time
- ✓ Excellent adhesion to many substrates
- ✓ Good spray pattern
- ✓ Great coverage
- ✓ Portable and convenient

Suggested Uses

- Ideal for bonding Fiberglass Insulation, Urethane foams, Upholstery, Felt/Fabrics, Duct Liner Wrap, Wood, Most Plastics, Paper Products and Glasswork.
- Not for use on decorative high pressure laminate applications.
- Do Not use to bond unbacked PVC due to plasticizer migration.

Meet or Exceeds

- **LEED Indoor Environmental Quality Credit 4.4; Low Emitting Materials: Composite Wood and Laminate Adhesives.**
 - No urea-formaldehyde added during adhesive manufacturing

Physical Properties

Base:	Synthetic rubber
Solids Content:	35 +/- 2%
Open Time:	>4 hours
Color:	Amber
VHAP:	0lb/lb of solids
VOC (Canister)	<15% VOC 0.74lb/gal (89g/L); less water and exempt solvents
Flammability	Extremely Flammable Gas

Handling & Storage

- 2 year 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

- 30lb, 146lb and 289lb canisters

Clean-Up

- HELMITIN SOLVENT 665
- HELMITIN CITRUS CLEANER

APPLICATION GUIDELINES

1. Attach gun and hose to canister and open valve completely. Keep valve on canister open and hose pressurized at all times. Do Not disconnect hose from empty canister until ready to reconnect to a full canister. Once the hose is disconnected from empty canister, open valve to ensure all vapors have evacuated the canister. Leave overnight. On disposable canisters, use a non-sparking tool to punch out the knock out plug and discard the canister.
2. Apply and even coat of adhesive (80%-100% coverage) to the surface to which the insulation materials is to be adhered.
3. Allow sufficient time to dry so that the adhesive does not transfer when touched.
4. Firmly press insulation material to dried adhesive surface to make the bond.
5. Do Not use to bond unbacked PVC due to plasticizer migration.
6. For optimum performance, store canisters at 18°C/65°F and above, but less than 49°C/120°F.
7. Avoid exposure of canisters to direct sunlight.
8. 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.
9. A dull appearance is a symptom of under-applying adhesive.
10. A very shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time. 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.