



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIBOND 1775

HIGH PERFORMANCE POSTFORMABLE WATERBORNE CONTACT ADHESIVE CANISTER

Product Description

A postformable, VOC & HAPS-free, waterborne contact adhesive canister. HELMIBOND 1775 exhibits aggressive initial tack; cured bonds have superior strength and heat resistance in comparison to other canister products. Designed to bond HPL and other decorative overlays to common core materials (particle board, MDF, OSB, etc.). Suitable for both flatwork and postforming applications.

Benefits

- ✓ VOC & HAPS-free
- ✓ Outstanding mileage ≈ 3X more than solventborne canisters
- ✓ Postformable
- ✓ Immediate, aggressive room temperature contact bonds
- ✓ Unrivalled strength & heat resistance after 24 hours
- ✓ Portable and convenient

Suggested Uses

- Lamination of High Performance Laminate (HPL) and other decorative overlays to particleboard and/or MDF core materials in the fabrication of store fixtures, millwork, cabinets, work surfaces, decorative panels and similar products.
- Suitable for postforming applications.
- EPS-cored insulated panels.
- Leather combining.
- **Do Not** laminate copper or its alloys with this adhesive.
- **Do Not** use with unbacked, plasticized vinyls.
- **Note:** The use of plywood as a core material with HPL may void some HPL manufacturers' warranties. Consult your HPL manufacturer's specifications.

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
- **OTC Rules for Adhesives & Sealants – Contact Bond Adhesive**

Physical Properties

Base:	Polychloroprene
Coverage:	37 lb Canister - 2,750 - 3,350 ft ²
Open Time:	60 minutes
Color:	White while wet. Clear when dry.
VHAP:	0 lb/lb of solids
VOC:	0 lb/gal (0 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.
- **Not Freeze/Thaw Stable. Protect from Freezing.** Product cannot be used after being frozen.
- 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.
- Use at room temperature, 18°C/65°F, or warmer. For best results use above 21°C/72°F.
- **Do not** apply or make bonds at temperatures below 18°C/65°F.

Packaging

37 lb canister

Suggested Spray Tip

- 730077

Clean-Up

- Wet adhesive – warm soapy water.
- Dried adhesive – HELMITIN SOLVENT 665 or HELMITIN CITRUS CLEANER.
- Adhesive supply hoses and spray guns: Flush with warm soapy water.

HELMITIN ADHESIVES

Toll Free: 877.823.2624
inquiries@helmitin.com
helmitin.com

*SEE SDS FOR REGULATORY INFORMATION

APPLICATION GUIDELINES

Conditioning of Materials

Allow the core and overlay materials 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.

Canister Equipment Set-up

1. Use of a 730077 spray tip is recommended
2. The adhesive supply hose should be conditioned prior to first use. Place 1 gallon of warm water in a sink or bucket, add 1 ounce (30 mL) liquid dish soap and mix thoroughly. Immerse the adhesive supply hose in the soapy water ensuring that the hose is filled. Remove the adhesive supply hose from the soapy water and allow to drain completely. Wipe the exterior of the hose with a rag to dry it. **DO NOT FLUSH THE CONDITIONED HOSE PRIOR TO USE;** allow the small amount of residual soapy water to remain in the adhesive supply hose.
3. Attach and securely tighten each end of the adhesive supply hose to the matching fitting on the spray gun and canister. Turn the trigger pull adjusting nut to the fully closed position to prevent accidental adhesive discharge from the spray gun.
4. Check the fittings for tightness. Position and tighten the spray tip on the spray gun. Plumbers tape is recommended to ensure a tight seal. Slowly open the valve on the canister to start the flow of adhesive and check for leaks. Partial opening is recommended initially. If there are no leaks, fully open the canister valve.
5. Turn the trigger pull adjusting nut on the spray gun 2 - 5 times counterclockwise to allow the adhesive to flow when the trigger is pulled. Discharge the spray gun and adjust the spray pattern to achieve a consistent spray of the desired width.

Adhesive Application

1. Substrates to be bonded with HELMIBOND 1775 must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants.
2. Hold spray gun at a consistent distance of 6 inches to 10 inches from the substrates producing an even pattern across the bonding surfaces with minimal overlap. The adhesive should be applied at a coating weight of 2.5 to 3.0 dry grams per ft² to ensure 100% coverage of both bonding surfaces.
3. When applying contact adhesives to porous materials such as plywood or particle board/MDF edges, it is advisable to apply two coats.
 - Apply the first coat and allow to dry. This will act as a sealer, prevent the second coat from soaking in, and ensure that there is the sufficient adhesive on the surface to achieve a strong, permanent bond. Once dry, apply the second coat and allow it to dry completely before bonding.
4. Waterborne contact adhesives will change appearance from milky to clear when dry.
5. To check for dryness, use the back of your fingers and press into the adhesive and lift up.
 - Any adhesive transfer or legginess indicates that the adhesive requires more time to dry.
 - If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding.
 - If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time.
 - **Do Not** use the palm of your hand to check for dryness.
6. Dry time will vary depending on temperature, humidity and coat weight. Drying time can be reduced using air movement, drying ovens, etc.
7. Bonds can be made as soon as the adhesive is dry. Bonds made any time during the 60 minute open time will be as strong as those made immediately after drying.
8. Position the pieces carefully, as a strong bond is made instantly upon contact.
9. Apply good uniform pressure to ensure good film fusion. A pinch roller is the best method for applying pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is 25 psi. This is easily achieved with a 3" J-roller. RUBBER MALLETS, BLOCKS OF WOOD, FLOORING ROLLERS, ETC. may not apply adequate pressure and should be avoided.
10. Completed panels can be processed immediately.

Note:

- 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.
- **Do Not Exceed the Recommended Open Time! Apply Sufficient Laminating Pressure!**
- **Do Not** use copper or its alloys to transfer or contain any contact adhesive.
- Thinning the adhesive is not recommended.

Frequent Use of Canister

1. Leave the hose and gun assembly attached to the canister and leave the canister valve open. This will keep the hose and gun charged with adhesive. Completely close the trigger pull adjusting nut when not in use. Adjust the trigger pull adjusting nut as desired to continue spraying again.
2. Regular gun and hose maintenance and cleaning is recommended for best performance. Clean the spray tip with warm, soapy water on a daily basis to avoid excessive adhesive build-up. Dried adhesive may be removed with SOLVENT 665 or Helmitin CITRUS CLEANER. The use of metallic objects to clean the tip is not recommended as they may cause damage to the tip and create an irregular spray pattern.

Canister Storage/Change Over

1. If the canister is not to be used for two weeks or longer, turn the canister valve completely off and dispense all material in the hose and gun assembly. Once empty and no pressure is present when the spray gun trigger is pulled, slowly disconnect the hose from the canister. Protect adjacent surfaces from any material that may drip from the hose.
2. The hose and gun may be then be flushed with warm, soapy water. Do not flush wash water down the drain. Pour wash water onto rags or suitable absorbent material and allow to dry completely. Dispose of dried waste in accordance with local regulations.
3. Flush wet adhesive from the closed canister valve with warm, soapy water to prevent any residual adhesive that is remaining in the valve from plugging it prior to the next 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.

HELMITIN ADHESIVES

Toll Free: 877.823.2624
inquiries@helmitin.com
helmitin.com

V1.2



HELMITIN
QUALITY ADHESIVE SOLUTIONS

*SEE SDS FOR REGULATORY INFORMATION