



HELMITIN
QUALITY ADHESIVE SOLUTIONS

1K ADHESION PROMOTER

VOC-FREE RUBBER SURFACE ADHESION PROMOTER

Product Description

1K ADHESION PROMOTER is a unique system that facilitates the bonding of many rubber compounds to a wide range of synthetic and natural materials (vinyl, polyurethane, poromeric, leather, canvas, primed nylon, primed EVA, foam rubbers, etc.) when used with Helmitin HELMIPLAST polyurethane adhesives..

Benefits

- ✓ VOC & HAPS free
- ✓ Easy to use
- ✓ Improves bond strength to most rubbers
- ✓ Excellent mileage

Suggested Uses

Designed primarily as a chlorinated primer to promote adhesion to most rubber compounds (e.g. Kraton, composition foam, etc.) when used in conjunction with the Helmitin line of HELMIPLAST polyurethane adhesives.

Surface Preparation

All materials to be primed with 1K ADHESION PROMOTER must be clean, dry, and free of dirt, dust, oil or other extraneous materials. Wiping or washing of substrates to be primed with SOLVENT 670 is recommended in order to remove mold release agents or other foreign materials. Some "difficult-to-bond" rubber compounds may require roughing prior to the application of 1K ADHESION PROMOTER. Adhesion tests performed are strongly recommended with all materials prior to commencing production.

Bonding

Heat Reactivation: Heat reactivate the dried adhesive surfaces to 75-80°C (167-176°F), then combine the materials with as much pressure as is practical.

Solvent Reactivation: Solvent wipe the dried adhesive surfaces with SOLVENT 671, then immediately bond as above.

Certifications & Compliance

- Complies with SCAQMD Rule 1168 VOC limits
- California compliant
- OTC compliant

Application

Parts to be treated must be clean, dry and free of contaminants. Remove any excessive oily or greasy contaminants from rubber surfaces with a solvent wipe. Apply 1K ADHESION PROMOTER directly to the substrates with a hard bristle brush (no metal parts) or a cotton rag (non-synthetic to avoid static sparks). Change rags often to prevent contaminant buildup. Hard or difficult to bond rubbers will require 1K ADHESION PROMOTER to be scrubbed into the freshly roughed rubber with a firm bristle brush. Avoid scrubbing of compounds such as soft TPR. Treatment is complete once 1K ADHESION PROMOTER has flashed off. Chlorination primers are chemical treatments which require time to react with rubbers unless heat is employed in the drying process. Heat dried parts may be top coated with HELMIPLAST polyurethane adhesives once dry. If air drying, allow a minimum of one hour after 1K ADHESION PROMOTER application before applying a topcoat of HELMIPLAST polyurethane adhesive. For best results, apply HELMIPLAST polyurethane adhesive within 24 hours of priming. Sole attaching, especially with soft TPR, should be done the following day. Store uncemented, primed parts in clean, dry conditions; re-prime aged parts prior to cementing if necessary. Exhausting of solvent fumes is essential and can be achieved by the use of a down-draft table (see the schematic on back page).

Handling & Storage

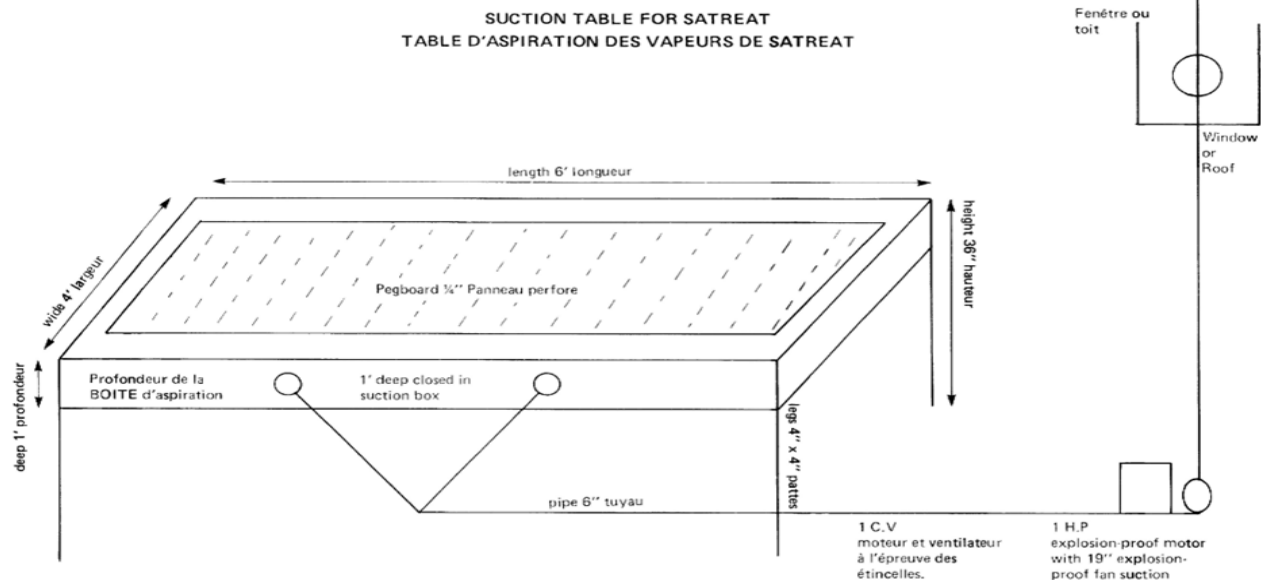
- 6 month shelf life from date of manufacture in unopened container. Rotate stock to use the oldest material first. **DO NOT USE EXPIRED MATERIAL.**
- 1K ADHESION PROMOTER is degraded by light. Store in a dark area.
- Store in original container or UV filtering plastic or glass containers only.
- Store away from oil, grease, dust, floor sweepings, organic compounds, ammonia, amines, ammonia salts.
- **DO NOT ALLOW CONTACT WITH METALS**
- **DISCARD EXCESS USED PRIMER - DO NOT POUR BACK INTO ORIGINAL CONTAINER**
- Freeze/Thaw Stable; if chilled below 10°C/50°F warm to 22°C/72°F.
- Store between 10°C/50°F and 32°C/90°F.
- Keep container tightly closed and stored off of the floor when not in use.
- Use at room temperature, 18°C/65°F, or warmer. For best results use above 22°C/72°F.

Packaging

- 5 US gallon plastic container

HELMITIN ADHESIVES
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*SEE SDS FOR REGULATORY INFORMATION



1K ADHESION PROMOTER Residues

The white powder resulting from the evaporation of 1K ADHESION PROMOTER (e.g. the drips from drainage racks) must be treated with caution as the powder forms a fire risk when mixed with fine organic materials (e.g. rubber dust from scouring operations). The following precautions must be followed:

- Check every week for white deposits in areas where 1K ADHESION PROMOTER is applied.
- Do not allow buildup to occur or remain in contact with metal surfaces.
- Do not allow residues to mix with dust from other operations.
- Where drips occur, it is suggested that they be caught in a disposable polyethylene bag which is sealed and properly disposed of at least weekly.

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.