



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIBOND 6504

CONTACT ADHESIVE

Product Description

HELMIBOND 6504 is a solvent-free, waterborne, polychloroprene contact adhesive formulated for installation of vinyl and rubber flooring products, moldings and stair treads. Maybe used over properly prepared porous and non-porous surfaces. HELMIBOND 6504 is designed versatility with excellent tack, high heat resistance and excellent bond strength.

Benefits

- ✓ Non-Flammable
- ✓ Low VOC's
- ✓ Solvent-free
- ✓ Low odor
- ✓ Long open time
- ✓ High heat resistance
- ✓ Excellent green strength
- ✓ Easy application
- ✓ FloorScore® Certified by SCS Global Services

Testing Methods

- Shelf Life (ASTM D1337)
- Adhesive Shear Strength (ASTM D6004)
- 90° Peel Resistance (ASTM D6862)

Packaging

- HELMIBOND 6504 is available in 1-quart units (12-quarts per carton) and 1-gallon units (4-gallons per carton).

Shelf Life

Adhesive shall be stored in a dry, climate-controlled area. Shelf life is 18 months in unopened, properly stored containers. Avoid storage of product in direct sunlight.

Physical Properties

Weight/Gal:	10.2 lb
Color:	Beige
Coverage:	Varies
Open Time:	90 Minutes
VOC:	<1 gram/liter per SCAQMD Rule 1168
Freeze-thaw:	Protect from freezing

Application

Substrates to be bonded shall be clean and free from moisture, dirt, oil and other contaminants. Very smooth surfaces should be lightly abraded.

Position material on floor or wall and mark area. This will be used as guidelines to which adhesive will be applied. Adhesive is applied by brushing. Apply adhesive evenly to both surfaces. Avoid heavy or excessive applications. When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry apply the second coat and allow to dry properly before bonding. This helps to ensure that the adhesive will not soak into the board and that there is the proper amount on the surface to achieve a strong, permanent bond.

Allow the adhesive to properly dry before bonding. When dry, adhesive will not transfer to finger. Normal dry time is 20 - 40 minutes, but will vary depending on temperature, humidity and coat weight. Dry time can be reduced using air movement. Bonds can be made as soon as the adhesive is dry. Carefully position material along guidelines. A strong bond is achieved instantly upon contact. Once adhesive is dry, materials shall be positioned into adhesive within 90-minutes. After material is positioned, roll area with a hand roller to ensure contact over the entire bonded area.

Clean up

Remove wet adhesive from flooring and tools with soapy water and a clean cloth. Use mineral spirits to remove dried adhesive. Do not apply solvents directly to flooring. **Use caution when handling flammable solvents.**

General Warranty & Precautions

Helmitin warrants its private label adhesive formulations to be free of all manufacturing defects. The warranty period shall be in place for one (1) year from the date of installation and will also be guided by the date of manufacture to insure the integrity of the formulation and that proper storage and shipment of same has taken place. Please contact Helmitin for detailed warranty information and information for Helmitin's Match It ASTM F2170 Moisture Warranty. Do not wash or begin maintenance procedures on the floor for a minimum of 5 days after installation to allow the adhesive to properly cure. Carefully read and follow all precautions and warnings. Keep out of reach of children. For complete safety information, refer to Safety Data Sheet (SDS) available from Helmitin Inc.

Statements and recommendations made herein are based on tests believed to be reliable. However, no guarantee of their accuracy or completeness is made. Unless otherwise provided in written contract, products are sold without warranties or conditions expressed or implied. Purchasers must make their own tests to determine the suitability of our products for their particular purpose.

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*SEE SDS FOR REGULATORY INFORMATION