



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIBOND 6520

RESILIENT FLOORING ADHESIVE

Product Description

HELMIBOND 6520 is a solvent-free, acrylic, pressure sensitive adhesive formulated to permanently install resilient floor tile including luxury vinyl tile and plank and resilient sheet flooring. To insure product stability and reduce joint openings, HELMIBOND 6520 has been formulated to produce a firm bond line less susceptible to indentation and telegraphing. May be used over properly prepared porous and non-porous surfaces such as concrete, underlayment grade plywood, cementitious based patching compounds and levelers.

Benefits

- ✓ Non-Flammable
- ✓ Solvent-free
- ✓ Excellent moisture and alkali resistance
- ✓ Excellent plasticizer resistance
- ✓ In bucket anti-microbial protection
- ✓ When dry, does not promote growth of mold or mildew
- ✓ Low odor
- ✓ Easy to trowel
- ✓ Sets to a tough, permanent bond
- ✓ Easy clean up
- ✓ FloorScore® Certified by SCS Global Services
- ✓ Health Product Declaration

LEED Points Contribution

MR Credit Regional Materials
IEQ Credit 4.1 Low-Emitting
Materials Adhesives and Sealants

LEED Points

Up to 2 points
1 point

This adhesive formulation has received a C2C Certified Material Health Certificate™ at the Gold level.

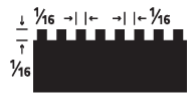
Packaging

- HELMIBOND 6520 is available in 1-gallon and 4-gallon pails.

Physical Properties

Viscosity:	Smooth Paste
Weight/Gal:	8.2 lb
Color:	Off-White
VOC:	<1 gram/liter per SCAQMD Rule 1168
Shelf Life	18 months in unopened properly stored containers.

Coverage

TROWEL	SPACING	COVERAGE
	1/16" X 1/16" X 1/16" Square Notch	125 - 150 square feet per gallon
	1/16" X 1/16" X 1/16" V-Notch	165 - 200 square feet per gallon
	3/64" X 3/64" X 3/64" U-Notch	165 - 200 square feet per gallon
	1/32" X 1/16" X 1/32" U-notch	225 - 250 square feet per gallon

Note: 3/64" X 3/64" X 3/64" U-notch trowel is available from Helmitin.

Testing Methods

- Freeze-thaw stability (ASTM D7149)
- Shelf Life (ASTM D1337)
- Adhesive Shear Strength (ASTM D6004)
- 90° Peel Resistance (ASTM D6862)
- Plasticizer Resistance (ASTM D7888)
- Caster Chair (ISO 4918)
- Heat Aged Expansion/Contraction

HELMITIN ADHESIVES

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

*SEE SDS FOR REGULATORY INFORMATION

Acclimation

The area to receive flooring shall be fully enclosed, weather tight, with an installed operating HVAC system. The installation area, flooring materials and adhesive must be acclimated at a temperature between 65° – 85°F for 48 hours prior to, during and after installation. The relative humidity of the installation area shall be maintained between 35 – 55% per ASTM F710 (Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring).

Surface Preparation

HELMIBOND 6520 can be used on porous and non-porous surfaces free of moisture. Surface to be covered must be dry, clean and smooth. Any foreign materials present such as paint, grease, oil, pen markings, adhesive residues, etc. that may prevent a proper bond or migrate to the surface causing a stain must be removed. Adhesive can be used on all grades of concrete on, above or below grade in the absence of moisture. Installation of a 10 mil (0.010") or greater effective moisture retarder is recommended directly under all on and below grade concrete floors with its integrity insured. Concrete shall be prepared according to the recommendations outlined in ASTM F710 (Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring). Concrete floors shall be free from crazing, dusting, spalling and any curing or sealing compounds. Concrete floors shall be tested for moisture according to the latest revision of ASTM F2170 (Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using in situ Probes) and ASTM F1869 (Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride). Wood floors must be double construction with a 1" minimum thickness, structurally sound, securely fastened and free from deflection/spring. Top layer of wood shall be underlayment grade plywood. Cracks and uneven surfaces must be filled with an approved cement-based patching compound.

Application

Porous Substrates

Apply adhesive with a $\frac{1}{8}$ " x $\frac{1}{8}$ " x $\frac{1}{8}$ " square notch trowel for materials with a gauge (thickness) of 0.080" or greater. Use a $\frac{1}{8}$ " x $\frac{1}{8}$ " x $\frac{1}{8}$ " V-notch trowel for materials with a gauge (thickness) of 0.080" or less.

Non-Porous Substrates

Apply adhesive with a $\frac{1}{8}$ " x $\frac{1}{8}$ " x $\frac{1}{8}$ " V-notch trowel for materials with a gauge (thickness) of 0.080" or greater. Use $\frac{1}{32}$ " x $\frac{1}{8}$ " x $\frac{1}{32}$ " U-notch trowel for materials with a gauge (thickness) of 0.080" or less.

Note: The $\frac{3}{16}$ " x $\frac{3}{16}$ " x $\frac{3}{16}$ " U-notch trowel can be used as an alternative to the $\frac{1}{8}$ " x $\frac{1}{8}$ " x $\frac{1}{8}$ " V-notch trowel. Contact Helmitin for more information.

Spread adhesive evenly using the recommended trowel. Hold trowel at a 60° angle. Replace trowels with worn notches. Do not re-notch worn notches. Once applied, the adhesive must be allowed to dry to the touch. Adhesive will become translucent and no longer have a milky appearance. Dry time will be dependent upon substrate porosity, room temperature and humidity. Position flooring within 4 hours after the adhesive has dried to dry to the touch. Immediately roll flooring in both directions with a 100 lb. three-section roller. If the adhesive remains uncovered longer than the recommended 4 hours, a loss of bond strength may result. The installer should not to spread more adhesive than can be covered with flooring within the 4-hour time frame.

Post Installation

Prevent all traffic for a minimum of 24 hours. Restrict heavy traffic and rolling loads for a minimum of 72 hours after installation. 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.

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.

HELMITIN ADHESIVES

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



HELMITIN
QUALITY ADHESIVE SOLUTIONS

*SEE SDS FOR REGULATORY INFORMATION