



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIFAST 777

INSTANT BONDING (2K) TWO-COMPONENT WATERBORNE FOAM ADHESIVE

Product Description

Two-Component (2K) Waterborne Spray Adhesive for immediate assembly in foam bonding, upholstery, fabric and other assembly applications. Helmifast 777 exhibits instant tack upon introduction of Activator 7 to the spray process. **MUST BE USED WITH ACTIVATOR 7 TO ACHIEVE PROPER ADHESIVE BOND.**

Benefits

- Immediate tack
- Excellent Green Strength
- Solvent-free, Zero VOCs
- Waterborne
- Aggressive tack; Helmifast 777 + Activator 7 permits one-way bonds in certain foam-to-foam applications
- Excellent adhesion to variety of substrates including, but not limited to, polyurethane foam, polyester fiber, and fabric

Suggested Uses

• Instant bonding of: Polyurethane foam to itself and most common upholstery materials (fabrics, backed/supported vinyls, etc.) in the fabrication of:

- Upholstered furniture
- Cushions and Seating
- Mattresses
- Pillows

- Scrim and other overlay materials to fiberglass in the manufacture of acoustical and insulation tiles and wraps.
- HPL laminating (flatwork only).
- Countertop end caps.

• **Note:** Do Not use copper and its alloys to transfer or contain any contact adhesive.

• **Do Not** laminate copper/copper alloys with this adhesive.

Physical Properties

Helmifast 777

Base: Polychloroprene

Solids

Content: 55 ± 2.0%

Viscosity: 100 cP

Specific

Gravity: 1.11

Weight/Gal: 9.29 lb

pH: 11

Activator 7

Base: Salt Solution

Solids

Content: 21.5 ± 2.0%

Viscosity: Like Water

Specific

Gravity: 1.20

Weight/Gal: 10.01 lb

pH: 1.5

Helmifast 777 + Activator 7

Mix Ratio: 10 : 1 (by weight) Helmifast 777 + Activator 7

Open Time: 5 - 15 minutes (two-way bond)

Time to Tear: 1 minute (two-way bond, Low Density PU foam) 1 - 2 minutes (one-way bond, Low Density PU foam)

Color: White

VHAP: 0.0 lb/lb solids

VOC: 0 lb/gal (0 g/L); less water and exempt solvents

HELMITIN ADHESIVES

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*SEE SDS FOR REGULATORY INFORMATION

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.

• SCAQMD RULE 1168.

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 stored off of the floor when not in use.
- Avoid exposure of containers 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 22°C/72°F.

Clean-up

- Use warm water when the adhesive is in the wet state
- Cured adhesive will require scraping/sanding

Packaging

- Available in 275 U.S. gallon totes and 50 U.S. gallon drums

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.

Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive should be applied to both substrates by mixing the adhesive with the accelerator during spray application (mix ratio in 10:1 by weight) with a 2K Low Pressure spray gun (HVLP or LVLP system). Adhesive can be supplied using a pressure pot or double diaphragm pump. Suggested starting settings for the listed spray gun are:

Fluid Pressure - Adhesive	12 lb
Fluid Pressure - Activator	9 lb
Atomization Pressure	15 lb*

*** Excessive atomization pressure can cause backflow of the activator in some spray systems**

3. In two-sided applications, bonds are made immediately. Open time will vary depending on substrate and amount of adhesive applied. Adhesive is ideal for applications requiring pinching and high stress points.

Recommended Equipment

BINKS:	
Spray Gun	95GPCXT
Fluid Tip	0.070"
Fluid Needle	17-670
Air Cap	17-102 (SWIRL RING)

***Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be reinforced PVC or nylon lined with a minimum ID of 1/4".**

