



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIFAST 788

FAST BONDING ONE- & TWO-COMPONENT WATERBORNE ADHESIVE

Product Description

HELMIFAST 788 is a one/two component waterborne adhesive designed to be roller coated or spray applied for the immediate assembly of foam, upholstery components, and similar fast assembly applications. Used as a 1K, HELMIFAST 788 exhibits fast tack, excellent green strength, and good repositionability. One-sided application is possible in many cases. As a 2K spray adhesive, HELMIFAST 788 produces immediate, permanent bonds. Ideal for bonding foam, carpet, upholstery, insulation and similar materials to themselves, each other and a wide variety of rigid core materials such as MDF, particleboard, plywood and luan.

Benefits

- ✓ Roll coater stable
- ✓ Sprayable
- ✓ Versatile - may be used 1K or 2K
- ✓ Fast tack with high green strength
- ✓ Repositionable
- ✓ Flexible, high heat resistance bonds
- ✓ Waterborne - Solvent-free - Zero VOCs
- ✓ Bonds one-way in many applications

Suggested Uses

- Foam laminating
- Mattress assembly
- Bonding insulation, luan, and upholstery for RV interior components, transportation vehicle interiors.
- Office partitions, furniture and components.
- **Do Not** laminate copper or its alloys with this adhesive.
- **Do Not** use with unbacked, plasticized vinyls.

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

Physical Properties

Base:	Synthetic Latex
Solids Content:	48 - 52%
Viscosity:	2,500 - 3,000 cP @ 20°C
Specific Gravity:	1.09
Weight/Gal:	9.09 lb
Color:	White
VHAP:	0lb/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 containers tightly closed and store off the floor when not in use.
- Avoid exposure of containers to direct sunlight.
- **Do Not** apply or make bonds at temperatures below 16°C/61°F.
- For best results use above 21°C/72°F.

Packaging

- 275 gallon totes, 53 gallon drums, 5 gallon cubitainers, 5 gallon pails

Clean-Up

- Wet adhesive – warm water
- Dried adhesive – HELMITIN SOLVENT 665 or HELMITIN CITRUS CLEANER

APPLICATION GUIDELINES

Preparation of Materials

Substrates to be bonded with HELMIFAST 788 must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants. Allow moisture and temperature sensitive 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.

Adhesive Application

1K Roll Coater Application:

1. HELMIFAST 788 is normally applied to the surfaces of one substrate with a roll coater/glue spreader to leave a even light coating of adhesive on the substrate.
2. Bonds may be made immediately after application or at any time within the open time of the adhesive. Open time and green strength will vary depending on the substrates used and the amount of adhesive applied.
 - i. For one-sided applications the open time is approximately 2 minutes
 - ii. For two-sided applications the open time is approximately 5 minutes
 - iii. Non-porous substrates can benefit if allowed to dry for 1-2 minutes before assembly
3. Repositioning of bonded parts is possible with many substrates while the adhesive is still tacky.
4. Apply uniform pressure to ensure proper fusion of the adhesive surfaces. Mechanical compression is the best method of applying pressure to large parts. Apply the maximum amount of pressure possible without damaging the substrates.

1K Spray Application:

1. HELMIFAST 788 should be applied to both substrates by spray application using a gravity feed system or a pressure pot system. Application amount will vary depending on the nature of the substrates and their porosity. Single-sided applications may be possible with some substrate combinations.
2. Bonds can be made as soon as the adhesive is applied or at any time within the open time. The initial bond strength can be greatly enhanced by allowing parts to dry for up to 10 minutes before they are combined. **Do Not** combine parts which have exceeded the 15 minute open time as the final bonds may be compromised.
3. Position the substrates to be bonded; apply sufficient, uniform pressure to ensure 100% mating and fusion of the two glued surfaces.
4. Repositioning is possible if performed immediately; foam tear will typically occur in 5 - 10 minutes.

2K Spray Application:

1. HELMIFAST 788 should be applied to both substrates by spray application using a 2K pressure pot system supplying an "On Demand" equipped spray gun. Application amount will vary depending on the nature of the substrates and their porosity.
2. HELMIFAST 788 may be applied as a 1K product to areas of parts not requiring instant, permanent bonding per the 1K guidelines above. For large, heavy parts or in high stress areas, where more strength is required, HELMIFAST 788 may be used in conjunction with ACTIVATOR 7 in two-component spray systems to produce an instant, permanent, high-strength bond when the parts are combined.
3. Position the substrates to be bonded; apply sufficient, uniform pressure to ensure 100% mating and fusion of the two glued surfaces.
4. Limited repositioning is possible only if performed immediately; foam tear will typically occur in 1 - 2 minutes.

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.

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