



**HELMITIN**  
QUALITY ADHESIVE SOLUTIONS

# HELMISTIK 8137-9

HIGH TACK, BRUSH GRADE GENERAL ASSEMBLY CONTACT ADHESIVE

## Product Description

Helmistik 8137-9 is a solvent-borne synthetic rubber contact cement that dries very fast and displays excellent green tack. This adhesive provides good strength at elevated and low temperature ranges.

## Benefits

- Fast drying.
- High green tack.
- Good heat and cold resistance.
- Excellent aging properties.
- Long heat activation open time.
- Can be heat reactivated for 2–3 days after application.
- Excellent adhesion to a variety of substrates including, but not limited to polyurethane foam, polycarbonate, fiberglass, metal, rigid plastics, and rigid urethanes.

## Applications to Avoid

- Do Not** use with decorative plastic laminate, wood veneers or metal overlays.
- Do Not** exceed the recommended open time.
- Do Not** use to bond vinyl due to plasticizer migration.
- Thinning the adhesive is not recommended.
- Never** use lacquer thinner for thinning.
- Consult the Safety Data Sheet prior to use.
- Store and use at room temperature 18°C/65°F.
- Keep adhesive container closed tightly when not in use.
- Do Not** use with HPL.

## Physical Properties

|                          |                                                   |
|--------------------------|---------------------------------------------------|
| <b>Base:</b>             | Synthetic rubber                                  |
| <b>Solids Content:</b>   | 40.0 ± 2.5%                                       |
| <b>Viscosity:</b>        | 1,100 cP                                          |
| <b>Specific Gravity:</b> | 0.80                                              |
| <b>Weight/Gal:</b>       | 6.70lbs                                           |
| <b>Open Time:</b>        | 60 minutes                                        |
| <b>Shelf Life:</b>       | 6 months from date of manufacture                 |
| <b>Color:</b>            | Clear                                             |
| <b>Packaging:</b>        | Drums, Pails                                      |
| <b>VOC:</b>              | 2.72lbs/gal (324 g/L) < water and exempt solvents |

## Volatile Organic Compounds (VOC):

The use, supply, sale or offer for sale of this product in certain province/states and localities may be prohibited if it exceeds certain VOC limits. Please check provincial/state and local regulations for any prohibitions on the sale and use of this product.

## Proposition 65 Warning

This product contains substances known to the State of California to cause cancer or reproductive harm.

## Health Hazard Data/Target Organ Effects

See Safety Data Sheet for complete data.

## First Aid

See Safety Data Sheet for complete data.

## Safety

•See Safety Data Sheet for complete data.

- FLAMMABLE LIQUID AND VAPOR. VAPOR MAY CAUSE FLASH FIRE. VAPOR MAY TRAVEL TO AREAS AWAY FROM WORK SITE BEFORE IGNITING/FLASHING BACK TO VAPOR SOURCE. USE ONLY IN WELL VENTILATED AREA. Keep away from heat, sparks and open flame. Prevent buildup of vapors. Open all windows and doors. Do not smoke when vapors are present.
- Extinguish all flames and pilot lights. Turn off stoves, heaters, electric motors. Turn off all potential ignition sources during use and until vapors are gone.
- Purchaser must obtain complete information on health and fire precautions from local officials in order to adequately protect personnel and property.
- Avoid repeated breathing of vapors. Avoid contact with skin. Do not take internally.
- NFPA 33 states non-ASME pressure-pot pressure shall not exceed 15 psi when filled with amammable liquids.

## Suggested Uses, Tips and Trouble Shooting

1. Helmistik 8137-9 can also be used to laminate most porous and non-porous materials such as sheet metal, plywood, drywall and particleboard to polystyrene foam or honeycomb cores, etc., in the fabrication of doors and other interior sandwich- panel type products.
2. Other applications include bonding materials such as cork, leather, canvas, felt, etc. to metal, wood, some plastics and many other surfaces.
3. Store and use at room temperature – 18°C/65°F.
4. In times of high humidity, “blushing” may occur. A “blush ” is caused from the rapid evaporation of the solvents, which causes the temperature in the immediate area to drop. When the temperature reaches the dew point, moisture will form on the surface of the adhesive. Once the “blush” has formed, the solvent cannot penetrate the moisture, and the moisture will act as a barrier between the two glue lines. The moisture must be allowed to dry before bonding. The best method to help speed drying is with air movement. Once the moisture is removed and you give the solvents time to flash off, the bond can be made.
5. A dull appearance is a symptom of under-applying adhesive.
6. A very shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time. Keep adhesive container closed tightly when not in use.

## Application Guidelines

### Method 1

#### Cold Spray:

Helmistik 8137-9 is readily sprayed with most types of conventional equipment. Apply an even spray to both of the surfaces to be bonded, then combine and press immediately. The very fast drying solvent system enables single side application to flat surfaces under no stress, provided combining is done while the adhesive still possesses a wet tack.

### Method 2

#### Hand brush or paint roller:

Apply an even, continuous coat of Helmistik 8137-9 to both surfaces to be bonded at a coat weight of 5 wet mils. On more porous surfaces best results will be obtained by applying two lighter coats and allowing 10 minutes for drying between coats. Do not apply at temperatures below 18°C/65°F.

### Method 3

#### Heat reactivated Contact Bonding:

After the adhesive coated surfaces have thoroughly dried, heat to 70°C–82°C/160°F–180°F, then while hot and tacky, combine and press. Heat reactivation may be done 2 – 3 days after adhesive application. Keep the adhesive surfaces free of dust and dirt. In certain applications only one surface need be heat-reactivated.

## Wet Bonding

Where at least one surface is porous, apply Helmistik 8137-9 to the least porous substrate and combine surfaces while the adhesive is still wet enough to wet out the second surface. Final bond strength is achieved after conditioning for 48 hours at room temperature. Cooling of the bonded material before final curing will interfere with the curing and ultimate bond strength.

