

HELMIBOND 8320-6

WATERBORNE POLYCHLOROPRENE CONTACT ADHESIVE

Product Description

A versatile polychloroprene-based, waterborne contact adhesive used in the manufacture of steel fire doors, HELMIBOND 8320-6 is specially formulated to bond aggressively to all common steel door skins as well as honeycomb paper and EPS (Styrofoam) cores. Bonds made with HELMIBOND 8320-6 become stronger with time; maximum strength, heat resistance and chemical resistance are achieved after approximately 7 days.

Benefits

- ✓ Long open time
- ✓ Spray, brush, or roller application
- ✓ Low odor
- ✓ Good coverage

Suggested Uses

- Laminating honeycomb paper and EPS (Styrofoam) core materials to steel door skins in the manufacture of hollow core steel fire doors.
- Leather combining for belts, straps and bags.
- Post-formed countertops and similar worksurfaces
- EPS-cored insulated panels.
- **Do Not** laminate copper or its alloys with this adhesive.
- **Do Not** use with unbacked, plasticized vinyls.

Clean-Up

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

Physical Properties

Base:	Polychloroprene
Solids Content:	50 - 54%
Viscosity:	700 - 2,000 cP
Specific Gravity:	1.10
Weight/Gal:	9.17 lb
Coverage/Gal:	approx. 725 ft² @ 3.0 dry grams/ft²
Open Time:	60 minutes
Color:	White (8320-6) Green (8320-6GR)
VHAP:	0.09 lb/lb of solids
VOC:	0.82 lb/gal (98 g/L); less water and exempt solvents

Handling & Storage

- 6 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.

Packaging

- 53 gallon drums, 5 gallon pails

HELMITIN ADHESIVES
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*SEE SDS FOR REGULATORY INFORMATION

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APPLICATION GUIDELINES

Conditioning of Materials

Allow the core and overlay 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

1. Substrates to be bonded with HELMIBOND 8320-6 must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants.
2. HELMIBOND 8320-6 can be brushed, rolled and sprayed:
   - If brushing and rolling, apply 100% coverage @ 3.0 dry grams/ft² or higher to the surfaces to be bonded on both sides.
   - If spraying, a coating weight of 2.5 - 3.5 dry grams/ft² should be applied to the surfaces to be bonded on both sides. The atomization pressure at the gun should be 5 - 20 psi and the fluid pressure should be 10 - 15 psi. Ensure that the spray system oil and water traps are functioning, drained regularly and are at least 25 ft from the air compressor.
3. 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, prevent the second coat from soaking in, and ensure that there is the sufficient adhesive on the surface to achieve a strong, permanent bond.
   - When dry, apply the second coat and allow it to dry completely before bonding.
4. Waterborne contact adhesives will change appearance from milky to clear when dry.
5. To check for dryness, use the back of your fingers and press into the adhesive and lift up.
   - Any adhesive transfer or legginess indicates that the adhesive requires more time to dry.
   - If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding.
   - If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time.
   - **Do Not** use the palm of your hand to check for dryness.
6. Dry time will vary depending on temperature, humidity and coat weight. Drying time can be reduced using air movement, drying ovens, etc.
7. Bonds can be made as soon as the adhesive is dry. Bonds made any time during the 60 minute open time will be as strong as those made immediately after drying.
8. Position the pieces carefully, as a strong bond is made instantly upon contact.
9. Apply good uniform pressure to ensure good film fusion. A pinch roller is the best method for applying pressure. Use the maximum possible pressure without damaging the substrates. **Minimum recommended pressure is 25 psi.** This is easily achieved with a 3" J-roller. **RUBBER MALLETS, BLOCKS OF WOOD, FLOORING ROLLERS, ETC.** may not apply adequate pressure and should be avoided.
10. Completed panels can be processed immediately.

Note

- A failed contact adhesive bond with a shiny appearance to the surface of the adhesive is an indication that the recommended open time was exceeded and/or that inadequate laminating pressure was applied during assembly.
- **Do Not Exceed the Recommended Open Time! Apply Sufficient Laminating Pressure!**
- **Do Not** use copper or its alloys to transfer or contain any contact adhesive.
- Thinning the adhesive is not recommended.

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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