HELMIBOND 885

WHITE 1-PART LOW ACTIVATION TEMPERATURE RTF/3D LAMINATING ADHESIVE

Product Description

HELMIBOND 885 is a low activation temperature, one-part waterborne polyurethane adhesive used for membrane pressing or vacuum forming thermoplastic foils in the manufacture of kitchen cabinet doors, furniture components and other 3D applications. It's low activation temperature makes it particularly suitable for use with thin foils and overlays.

Benefits

- ✓ One-part – no mixing of hardener and long pot life
- ✓ Low activation temperature
- ✓ Activation can take place long after parts have been sprayed
- ✓ High initial Green Strength
- ✓ White color offers easy visibility during application and after drying

Suggested Uses

- 3D Laminating of thin vinyl and similar thermoplastic foils which require a low activation temperature
- Pre-applied heat activatable adhesive coating for flexible materials

Meets or Exceeds

- **SCAQMD Rule 1168**
- **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

Activation Temperature:	54 - 74°C (130 - 165°F)
Solids Content:	40 - 42%
Viscosity:	2,200 - 2,500 cP
Specific Gravity:	1.05
Weight/Gal:	8.75 lb
Coverage/Gal:	535 ft² @ 3 wet mils
pH:	6 -8
Color:	White
VHAP:	0 lb/lb of solids
VOC:	0.0 lb/gal (0 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.
- Do Not store or ship at temperatures below 7°C/45°F.
- Use at room temperature, 18°C/65°F, or warmer. For best results use above 22°C/72°F
- **Do Not** apply or make bonds at temperatures below 18°C/65°F.
- Keep container tightly closed and store off the floor when not in use.
- Avoid exposure of containers to direct sunlight.
- If the container has been sitting for an extended period of time and has settled, stir thoroughly before using.

Packaging

- 275 gallon totes, 55 gallon drums, 5 gallon pails

Clean-Up

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

HELMITIN ADHESIVES
Toll Free: 877.823.2624
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*SEE SDS FOR REGULATORY INFORMATION

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APPLICATION GUIDELINES

Conditioning of Materials

Substrates should be acclimatized at 18°C/65°F, or above, for at least 48 hours prior to bonding. Make provisions to allow the free flow of air around substrates.

Adhesive Application

1. Substrates to be bonded must be clean and free from burn or score marks, moisture, dirt, oil, and other contaminants.
2. Adhesive and substrates should be 18°C/65°F or warmer. For best results use above 22°C/72°F.
3. At least one substrate must be porous.

General Assembly

1. Filter the adhesive through a fine mesh filter.
2. The adhesive should be applied utilizing an HVLP spray gun with a minimum fluid tip and needle of .055" (1.4 mm). Coating weight applied should be approximately 3 wet mils or 3.5 dry grams per ft². When applying to porous substrates, it may be necessary to increase coating amounts or apply two coats of adhesive. The atomization pressure at the gun should be 45 - 65 psi triggered and the fluid pressure/pot pressure should be 10 - 20 psi. **DO NOT** apply the adhesive if the temperature of the adhesive, environment or substrates drops below 10°C/50°F.
3. Allow the adhesive to dry thoroughly. When force drying the adhesive, do not exceed 50°C/122°F.
4. Press times should be 30 seconds to 4 minutes with a glue line temperature of 54 - 74°C (130 - 165°F). The minimum adhesive reactivation temperature is 54°C/130°F at the glue line.
5. Forming pressures depend on the press system and are approximately 3 bar (44 psi).
6. Final bond strength is achieved after 7 days.

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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QUALITY ADHESIVE SOLUTIONS

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