



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMIBOND 894

POSTFORMING & PINCH ROLLING COPOLYMER ADHESIVE

Product Description

Helmibond 894 is a versatile waterborne adhesive designed for postforming and flat laminating without the need for cold pressing. It can be applied by spray or glue spreader. Product can be roll coated or sprayed and processed by hot bonding, hot laminating, hot pressing, and pinch rolling and dead stacking

Benefits

- Waterborne
- Fast setting
- Excellent mileage
- Sprays evenly when applied by hand or with automated systems
- Higher viscosity reduces overspray

Applications to Avoid

- Keep adhesive container closed tightly when not in use.
- Containers should be stored on pallets and away from outside walls and off concrete floors.
- Store containers where temperatures will not be less than 10°C/50°F and will not exceed 32°C/90°F.
- Product should not be stored in direct sunlight.
- Product should not be used after freezing.
- Thinning the adhesive is not recommended.
- Consult the Safety Data Sheet prior to use.

Health Hazard Data/Target Organ Effects

- See Safety Data Sheet for complete data.

First Aid

- See Safety Data Sheet for complete data.

Physical Properties

Solids Content:	56.5 ± 1.5%
Viscosity:	3,100 cP
Specific Gravity:	1.08
Weight/Gal.:	9.01lbs
pH:	3.0–5.0
Coverage/Gal.:	263 ft ² @ 6 wet mils
Shelf Life:	12 months from date of manufacture
Color:	White, dries clear (894) Green (894GR)
Packaging:	Totes, Drums, Pails
Freeze/Thaw:	Not freeze/thaw stable. Protect from freezing.

Clean-up

Use warm water when the adhesive is in the wet state
Dispose of waste in accordance with Provincial/State regulations

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.

Safety

See Safety Data Sheet for complete data

HELMITIN ADHESIVES

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*SEE SDS FOR REGULATORY INFORMATION

Suggested Uses, Tips and Trouble Shooting

Substrates to be bonded should be clean and free from moisture, dirt, oil, and other contaminants.

Application Guidelines

Postforming

1. The adhesive should be applied at a coating weight of 4.5 dry grams per ft² or 3 mils on both the core and the HPL by spray application or roll coating to achieve 100% coverage on the postform radius and edges. The approximate atomization pressure at the gun should be 40–60 psi and the approximate fluid pressure should be 25–30 psi.
2. The HPL and core are to be dried by processing through a drying oven. The adhesive should appear to be approximately 50% clear and 50% opaque when exiting the drying oven. The postform radius and edges should be completely dry or clear.
3. The HPL and core should be indexed and pinch rolled with a temperature of each between 52°C/55°C–125°F/130°F. Failure to pinch roll at the recommended temperatures may result in spotty or no bond.
4. The edges of the core to be postformed should not have any wet spots.
5. The top can now be postformed through any commercially available flow through postformer.

Panel Assembly by Roll Coating

1. Adhesive film thickness should be set to a depth of 6 to 8 wet mils. With this application, the adhesive may be applied to one substrate.
2. Index the HPL to the particleboard or plywood core as the substrates exit the roll coater.
3. At this point, the panel can be:
 - a. Dead stacked.
 - b. Pinch rolled and stacked for 30 minutes before processing.
 - c. Processed through pinch roll/hot laminating system, allowing immediate processing after the panel has cooled.
 - d. Hot pressed for a period of 1–2 minutes at approximately 82°C/93°C–180°F/ 200°F, allowing immediate processing after the panel has cooled.

Recommended Automatic Spray Equipment

	Automatic	
	Binks	DeVilbiss
Spray Gun	M95 Auto, M61, M610	AGX 550
Fluid Tip	63BSS	FF
Air Cap	66SDJG	797

