



HELMITIN
QUALITY ADHESIVE SOLUTIONS

HELMICOL 3012 A&B

2-COMPONENT METAL DOOR CORE BONDING EPOXY

Product Description

HELMICOL 3012 A & B is a 100% solids content, versatile epoxy adhesive that displays good adhesion to a wide variety of substrates and exhibits strong final bonds that are heat and moisture resistant.

Benefits

- ✓ Low viscosity for easy mixing
- ✓ Easy to apply
- ✓ Excellent spreading characteristics, trowels smoothly
- ✓ 100% solids, no shrinkage
- ✓ 3 - 4 hour pot life
- ✓ Wide range of adhesion - bonds carpeting, ceramic tile, stone, wood, some plastics

Suggested Uses

- Bonding honeycomb and expanded polystyrene foam cores to metal in the construction of metal doors.
- Bonding decorative metal overlays to particle board, MDF or plywood in the construction of decorative architectural panels.
- Stone facades and curtainwall.

Certifications & Compliance

- Complies with SCAQMD Rule 1168 VOC limits
- California compliant
- OTC compliant

Physical Properties

Base:	Epoxy Resin
Solids Content:	100%
Viscosity Part A:	Pasty
Viscosity Part B:	20,000 - 60,000 cP @ 20°C
Specific Gravity Part A:	1.6
Specific Gravity Part B:	1.25
Weight/Gal Part A:	13.33 lb
Weight/Gal Part B:	10.41 lb
Pot Life:	3 to 4 hours
Color Part A:	Light beige)
Color Part B:	Green
Coverage:	Approx. 80 ft ² /gallon; 1/8" notched trowel on 3/16" centres
VHAP:	0.001 lb/lb of solids
VOC:	<0.1 lb/gal (<12 g/L); less water and exempt solvents

Handling & Storage

- 12 month shelf life from date of manufacture in unopened containers.
- Rotate stock to use the oldest material first.
- Freeze/Thaw Stable - 5 cycles.
- 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 18°C/65°F.
- Use at room temperature, 18°C/65°F, or warmer. For best results use above 21°C/72°F.

Packaging

- 5 US gallon pails

Clean-Up

- Use HELMITIN SOLVENT 665

APPLICATION GUIDELINES

Surface Preparation

In order to achieve maximum bond strength, surfaces to be bonded must be clean and dry. All dirt, dust, oil, moisture or other extraneous materials must be removed prior to applying the adhesive.

Mixing Ratio

HELMICOL 3012 A&B is supplied 2 pails of HELMICOL 3012 Part A to 1 pail of HELMICOL 3012 Part B. This ratio must be maintained.

- If mixing by weight the ratio of Part A to Part B is 2 to 1.
- If mixing by volume the ratio of Part A to Part B is 1.5 to 1

This adhesive must be mixed only in the recommended ratio. Adjustment or deviation from the recommended mixing ratio of Part A to Part B may result in bond failure

Adhesive Application

1. HELMICOL 3012 A & B may easily be applied by trowel, paint roller, brush or automatic metering and dispensing equipment.
2. Thoroughly mix Part A and Part B by hand or mechanical mixer to ensure a smooth homogeneous mixture.
3. Mix only enough adhesive as will be used within the recommended pot life.
4. Never mix used adhesive with fresh material.
5. Apply a smooth continuous coat of adhesive to the least porous substrate, then immediately combine to the second substrate.
6. Press or stack the assemblies and allow a setting time of 4 - 8 hours.
7. Final bonds are achieved in approximately 24 - 48 hours @ 20°C/68°F. Cooler temperature will slow the rate of curing, higher temperatures will accelerate the rate of curing.

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.

HELMITIN ADHESIVES

Toll Free: 877.823.2624
inquiries@helmitin.com
helmitin.com

V1.1



HELMITIN
QUALITY ADHESIVE SOLUTIONS

*SEE SDS FOR REGULATORY INFORMATION