

HELMITAC 64-041

LOW VOC, HAPS-FREE PRESSURE SENSITIVE ADHESIVE

Product Description

A low VOC, HAPS-free, solventborne pressure sensitive adhesive designed for bonding difficult substrates in 1-sided applications. Its high viscosity and aggressive tack make HELMITAC 64-041 ideal for converting and laminating applications, including the bonding of films and membranes to rigid core materials.

Benefits

- ✓ HAPs-free
- ✓ Excellent stability on mechanical glue spreaders
- ✓ Fast drying
- ✓ Extremely aggressive tack
- ✓ Excellent adhesion to many substrates
- ✓ NOT TO BE USED WITH PLASTICIZED PVC.

Suggested Uses

- Film converting
  - Pressure sensitive laminating films
  - Road and safety marking tapes
- TPO to extruded polystyrene (XPS) and other core materials
- Decorative paper and similar lightweight overlays to particle core, MDF, melamine, etc.
- **DO NOT USE WITH PLASTICIZED PVC**
- **DO NOT USE WITH HIGH PRESSURE LAMINATE (HPL)**

Physical Properties

Base:	Synthetic Rubber
Solids Content:	57.5% - 62.5%
Viscosity:	3,800 - 4,600 cP
Specific Gravity:	0.95
Weight/Gal:	7.92 lb
Coverage/Gal:	305 - 715 ft^2 at suggested application rates
Open Time:	Unlimited - Pressure Sensitive
Color:	Natural
VHAP:	0 lb/lb solids
VOC:	213 g/L (1.78 lb/gal); 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 - if chilled, warm to 22°C/72°F.
- 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.
- This adhesive is flammable. Ensure all application, drying, and handling equipment is designed for processing flammable materials.
- **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 US gallon drums, 5 US gallon pails

Clean-Up

- Use HELMITIN SOLVENT 665 or CITRUS CLEANER
- **Never** use lacquer thinner to thin adhesive or clean equipment

HELMITIN ADHESIVES
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*SEE SDS FOR REGULATORY INFORMATION

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APPLICATION GUIDELINES

1. Substrates to be bonded must be clean, dry and free from dust, dirt, grease, oils, solvents and other contaminants.
2. HELMITAC 64-041 should be applied at a coat weight of 3 - 7 dry grams/ft^2.
   - Coat weight will depend on the nature of the substrates being bonded and the demands of the application.
   - Heavier coat weights will produce a more aggressive adhesive surface.
3. Do not apply HELMITAC 64-041 directly onto EPS or XPS core as the solvent it contains will attack them. If using EPS or XPS, apply adhesive to the other substrate and allow for most of solvent to flash off before laminating to the foam core.
4. If one substrate is porous, parts can be mated immediately after adhesive application.
   - Compression must be maintained by pressing or deadstacking until the solvent has evaporated.
5. When bonding EPDM, TPO, or other difficult to bond to substrates, apply HELMITAC 64-041 to the most difficult substrate.
6. Drying tunnels will accelerate the drying process and reduce drying times.
7. Apply uniform pressure to ensure proper fusion of the adhesive surfaces. A pinch roller is the best method of applying pressure. Apply the maximum amount of pressure possible without damaging the substrates. Minimum recommended pressure is 25 psi.

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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