

HELMIPLAST 64-042

CELLULAR PVC ADHESIVE

Product Description

High solids, Zero HAPs (Hazardous Air Pollutants) adhesive for bonding cellular and rigid PVC trim and components.

Benefits

- ✓ Zero Hazardous Air Pollutants (HAPs)
- ✓ Long open time
- ✓ Excellent adhesion
- ✓ Bonds are stronger than most PVC substrates

Suggested Uses

- Two-way bonding of rigid and cellular PVC trim and components.

Physical Properties

Base:	Polyvinyl Chloride
Solids Content:	20 +/- 2%
Viscosity:	2,750 cP
Specific Gravity:	1.032
Weight/Gal:	8.61
Coverage/Gal:	Approximately 312 ft² @ 2.5 dry grams/ft² 156 ft² completed bond
pH:	6.5-8.5
Color:	Clear
Open Time:	Approximately 60 minutes
VHAP:	0lb/lb of solids
VOC:	6.89 lb/gal (826 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 - if chilled, warm to 22°C/72°F and mix well.
- Store between 10°C/50°F and 32°C/90°F.
- Keep container tightly closed and store off of the floor when not in use.
- Thinning is not recommended.
- 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. Clean-up

Packaging

- 53 US gallon drums, 5 US gallon pails

Clean-Up

- Use Helmitin Solvent 665 or Helmitin Citrus Cleaner

HELMITIN ADHESIVES
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*SEE SDS FOR REGULATORY INFORMATION

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APPLICATION GUIDELINES

Conditioning of Materials
Substrates to be bonded with HELMIPLAST 64-042 must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants.

Adhesive Application
1. HELMIPLAST 64-042 can be applied manually by squeeze bottle, animal hair or solvent resistant brush, short nap phenolic roller, etc. HELMIPLAST 64-042 may also be dispensed with pressure pot fed hand application systems. A mechanical roll coater suitable for use with solventborne adhesives may be used to apply the HELMIPLAST 64-042 to larger parts or panels.
2. HELMIPLAST 64-042 should be applied at a coating weight of 3.0 dry grams per ft² and 100% coverage. Proper adhesive coating is indicated by a uniform glossy sheen on the surface with light reflecting on it. Any dull areas indicate an insufficient amount of adhesive and should be reapplied.
3. Parts coated with HELMIPLAST 64-042 can be assembled immediately or, due to its extended open time, may be allowed to sit for up to 5 minutes before assembly.
4. Join the coated surfaces with firm, even pressure. Be careful to ensure that there are no voids so that the strongest possible bond can be obtained.
5. HELMIPLAST 64-042 is thick enough that low stress assemblies may not need to be clamped while curing. Higher stress or heavier assemblies may require clamping.
6. The curing time of HELMIPLAST 64-042 is dependent on temperature, the amount of adhesive applied and the size of the bonded area. Overnight curing is suggested.

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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