

## HELMIBOND 883WH *WHITE ONE-PART 3D LAMINATING ADHESIVE*

### PRODUCT DESCRIPTION

HELMIBOND 883WH is a 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.

### BENEFITS

- ✓ One-part – no mixing of hardener and long pot life.
- ✓ Reactivation can take place long after parts have been sprayed.
- ✓ High initial green strength.
- ✓ White color offers easy visibility during application and after drying.

### PHYSICAL PROPERTIES

- **Solids Content:** 42 ± 2%
- **Viscosity:** 1,500 – 2,100 cP
- **Specific Gravity:** 1.05
- **Weight/Gal.:** 8.76 lb
- **Coverage/Gal.:** 485 ft<sup>2</sup> @ 3.5 dry grams (approx. 3 wet mils)
- **pH:** 6 – 8
- **Color:** White
- **VHAP:** 0.0 lb/lb solids
- **VOC:** 0 lb/gal (0 g/L); less water and exempt solvents

### MEETS OR EXCEEDS

- **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.
- **OTC Rules for Adhesives & Sealants – Contact Bond Adhesive**
- **SCAQMD Rule 1168**

### 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.**
- Store between 10°C/50°F and 32°C/90°F
- **Do Not** store or ship at temperatures below 7°C/45°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 before using
- **Do Not** apply or make bonds at temperatures below 18°C/65°F
- **Avoid** contact with iron or steel. Iron contamination will discolor glue lines
- Pressure will build in tightly closed containers when mixed with hardener.
- Use at room temperature, 18°C/65°F, or warmer. For best results use above 22°C/72°F

### CLEAN-UP

- Use warm water when the adhesive is in the wet state.

### PACKAGING

- Available in 275 US Gallon Tote, 53 US Gallon Drums, 5 US Gallon Pails, 4 x 1 US Gallon Cases

### 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.

*\*See SDS for Regulatory Information*

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### APPLICATION GUIDELINES

#### Conditioning of Materials

Substrates should be acclimatized together 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. 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 6.5 - 7.5 wet grams per ft<sup>2</sup>. 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 74°C/82°C - 165°F/180°F. The minimum adhesive reactivation temperature is 74°C/165°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.

#### Note:

- Be careful to avoid contamination by iron (rust) from any source, such as containers, tools or application equipment, as such contamination will lead to dark glue lines.
- This product may not be compatible with fire retardant board. Consult with **HELMITIN** technical support prior to use with these types of substrates.

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