

HELMIBOND 885WH *WHITE ONE-PART 3D LAMINATING WATERBORNE ADHESIVE*

PRODUCT DESCRIPTION

HELMIBOND 885WH 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

- **Base:** Polyurethane
- **Solids Content:** 46 ± 2.0%
- **Viscosity:** 1,800 cP
- **Specific Gravity:** 1.07
- **Weight/Gal:** 8.9 lbs.
- **Coverage/Gal:** 485 ft² @ 3.5 dry grams (approx. 3 wet mils)
- **Open Time:** 6 - 8 Hours
- **Color:** White
- **VHAP:** 0.00
- **VOC:** 0.00 lb/gal (0.00 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.
- **January 2017 CARB VOC Limits For Web Spray Adhesives OTC Rules for:**
 - Adhesives & Sealants – Contact Bond Adhesive
- **SCAQMD Rule 1168**

SUGGESTED USES

- Membrane press applications.

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.
- Keep container tightly closed and store off of the floor when not in use.
- Use at room temperature 18°C/65°F or above.
- **Do Not** store or ship at temperatures below 7°C/45°F.

CLEAN-UP

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

PACKAGING

- Available in Totes, Drums, Pails.

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

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 ft². 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 54°C/130°F - 74°C/165°F. The minimum adhesive reactivation temperature is 54°C (130°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

- A drying issue called "**Blushing**" often occurs under extremely humid conditions. "**Blushing**" occurs when rapidly evaporating solvents cause the temperature of the adhesive surface to drop below dew point. Condensation then forms on the surface of the adhesive and acts as a barrier to further drying; it also interferes with the fusion of the two glued surfaces and prevents them from bonding. All moisture **MUST** be completely evaporated before bonding. Moderate air movement (shop fan) is the preferred method to speed drying while reducing or eliminating "**Blushing**" issues. Bonds can be made once all moisture and solvents have completely evaporated.
- A failed contact adhesive bond with a shiny appearance to the surface of the adhesive is an indication that the recommended open time was exceeded and/or that inadequate laminating pressure was applied during assembly.

Do Not Exceed the Recommended Open Time! Apply Sufficient Laminating Pressure!

RECOMMENDED SPRAY EQUIPMENT

	Automatic		Manual	
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	Mach 1A	AGXV-541	Mach 1	JGHV-531
Fluid Tip	94	FF	94	FF
Fluid Needle	47-478	FF	54-3941	FF
Air Cap	94P	46	94P	33, 46

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