

“CALIFORNIA COMPLIANT” SPRAY GRADE CONTACT ADHESIVE

PRODUCT DESCRIPTION

A “California compliant”, zero VOC, flammable high solids synthetic rubber spray grade contact adhesive.

BENEFITS

- Zero VOCs – California compliant
- Zero HAPs (Hazardous Air Pollutants)
- High tack
- Aggressive room temperature contact bonds
- Excellent green strength and high heat resistance
- Fast drying with a long open time
- Very good sprayability
- Bonds HPL, particleboard, plywood, steel, and many plastics
- LEED compliant (IEQ Credits 4.1 & 4.4)

SPECIFICATIONS

- **Base** Synthetic rubber
- **Solids Content** 40.0 ± 2.0%
- **Viscosity** 225 cP
- **Specific Gravity** 0.95
- **Weight/Gal.** 7.92 lb
- **Coverage/Gal.** 449 ft² @ 3.0 dry grams
224 ft² completed bond
- **Open Time** 60 minutes
- **Shelf Life** 12 months from date of manufacture
- **Color** Natural (1575), Red (1575RD)
- **Packaging** Drums, Pails
- **VHAP** 0.00 lb/lb of solids
- **VOC Content** 0.00 lb/gal. (0.00 g/L)
less water and exempt solvents

HANDLING & STORAGE

- **Do Not** exceed the recommended open time.
- **Do Not** use to bond vinyl due to plasticizer migration.
- Thinning the adhesive is not recommended.
- **Never** use lacquer thinner for thinning.
- Consult the Safety Data Sheet prior to use.
- Keep adhesive container closed tightly when not in use.

CAUTION

- Consult the Safety Data Sheet prior to use.
- HELMISTIK 1575 contains flammable solvents. Use the same precautions as when handling gasoline.
- Adequate ventilation must be provided in work areas.
- Purchasers must obtain complete information on health and fire precautions from local officials in order to adequately protect personnel and property.
- Do not smoke when using.
- Do not apply or bond at temperatures below 18°C (65°F).
- Not to be taken internally.

USAGE TIP

In times of high humidity, “blushing” may occur. A “blush” is caused from the rapid evaporation of the solvents, which causes the temperature in the immediate area to drop. When the temperature reaches the dew point, moisture will form on the surface of the adhesive. Once the “blush” has formed, the solvent cannot penetrate the moisture, and the moisture will act as a barrier between the two glue lines. The moisture must be allowed to dry before bonding. The best method to help speed drying is with air movement. Once the moisture is removed and you give the solvents time to flash off, the bond can be made.

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APPLICATION GUIDELINES

- Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
- The adhesive should be applied at a coating weight of 2.8 – 3.0 dry grams per ft² to achieve 80% coverage by hand spray application, with near 100% coverage around the edges. For automatic spray applications, a minimum of 2.5 dry grams per ft² should be applied. The atomization pressure at the gun should be 80 – 100 psi, fluid pressure should be 10 – 15 psi.
- When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry apply the second coat and allow to dry properly before bonding. This helps to ensure that the adhesive does not soak-in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond.
- Allow the adhesive to dry properly before bonding. Waterborne contact adhesives will change color when dry. To check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer or legginess indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding. If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time. **DO NOT** use the palm of your hand to check for dryness. Dry time can vary depending on temperature, humidity and coat weight. Drying time can be reduced using air movement, drying ovens, etc.
- Bonds can be made as soon as the adhesive is dry. Bonds made any time in the 1 hour open time will be as strong as those made immediately after drying.
- Position the pieces carefully, as a strong bond is made instantly upon contact.
- Apply good uniform pressure to ensure good film fusion. A pinch roller is the best method for applying pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is 25 psi. This is easily achieved with a 3” J-roller. Rubber mallets, blocks of wood, and flooring rollers do not apply adequate pressure.
- Completed panels can be processed immediately.

Recommended Equipment

	Automatic		Manual	
	Binks	DeVilbiss	Binks	DeVilbiss
Spray gun	21, 61, 610, 95A	AGX 550	18, 62, 2001, 95	JGA 510
Fluid tip	63B, 63C	FX, FF	63B, 63C	FX, FF
Fluid needle	63B, 63C	FX, FF	63B, 63C	FX, FF
Air cap	66SD-3	797	66SD-3	797

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Statements and recommendations made herein are based on tests believed to be reliable. However, no guarantee of their accuracy or completeness is made. Unless otherwise provided in written contract, products are sold without warranties or conditions expressed or implied. Purchasers must make their own tests to determine the suitability of our products for their particular purpose.