

HIGH PERFORMANCE SPRAY GRADE CONTACT ADHESIVE CANISTER

PRODUCT DESCRIPTION

HELMISTIK 1685 is a non-flammable high heat resistant and high solids contact adhesive with excellent dry time, initial tack and bond strength for use in bonding HPL and a variety of substrates.

BENEFITS

- High tack
- Excellent room temperature contact bonds
- Excellent green strength and high heat resistance
- Fast drying with a long open time
- Bonds HPL, particleboard, plywood, steel, and many plastics
- Portable and convenient

SPECIFICATIONS

- **Base** Synthetic rubber
- **Solids Content** 28.0 ± 2.0%
- **Viscosity** 275 cP
- **Specific Gravity** 1.20
- **Weight/Gal** 10.0 lb
- **Open Time** 60 minutes
- **Shelf Life** 12 months from date of manufacture
- **Color** Natural (1685), Green (1685GR)
- **Packaging** 17 oz aerosol can, 11 lb, 38 lb, 177 lb, 355 lb canisters
- **Freeze/Thaw** Does not freeze; agitate well after warming to 22°C/ 72°F if chilled
- **Flammability** Non-flammable adhesive with a flammable propellant.
- **Clean Up** SOLVENT 699, SOLVENT 665, or CITRUS CLEANER

HANDLING & STORAGE

- Attach gun and hose to canister and open valve completely.
- Keep valve on canister open and hose pressurized at all times.
- **Do Not** disconnect hose from empty canister until ready to reconnect to a full canister.
- Once the hose is disconnected from empty canister, open valve to ensure all vapors have evacuated the canister overnight. On disposable canisters, use a non-sparking tool to punch out the knock out plug and discard of the canister.
- **Do Not** exceed the recommended “open time.”
- **Do Not** use to bond vinyl due to plasticizer migration.
- For optimum performance, store canisters at 18°C (65°F) and above, but less than 49°C (120°F).
- Avoid exposure of canisters to direct sunlight.
- Consult the Safety Data Sheet prior to use.

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.

HELMITIN

HELMISTIK 1685

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APPLICATION GUIDELINES

- Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
- Hold spray gun at a consistent distance of 6” to 10” from the substrates producing a web pattern across the substrates with minimal overlap.
- The adhesive should be applied at a coating weight of 2.5 – 3.0 dry grams per ft², at the same time achieving 80 – 100% coverage.
- Allow the adhesive to dry properly before bonding. 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.
- When applying HELMISTIK 1685 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.
- 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.

DISTRIBUTED BY:
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