



helmitin[®] 1526

Application

Contact adhesive for bonding rubber, cellular- and foam rubber, leather, leather fibre board, textiles, poromerics, card board together or to wood, lacquered materials and certain plastic materials, especially for sole bonding and for lasting in the shoe industry.

Technical Data

Base:	Polychloroprene
Colour:	Yellowish
Viscosity (Brookfield):	Ca. 2.000 mPas*
Density:	Ca. 0,85 g/cm ³
Thinner/Cleaner:	helmitin [®] 676/2
Application:	Brush, roll-coating machine
Drying time:	20 - 30 minutes
Contact life:	20 - 60 minutes
Setting time:	Ca. 24 hours
Storage life:	Ca. 12 months
Conditions for storage and transport:	Well closed at temperatures not below 10°C
Sensitive to cold:	Yes, jellies below 10°C, can be thawed
Inflammable:	Yes
Labelling acc. to regulations for dangerous goods:	F, Xn, N See Safety data sheet

* The viscosity indicated above is based on a temperature of 20°C prevailing at the time of production. Minor deviations may occur during storage.

Pre-Conditions

The parts to be bonded should be roughed thoroughly. Fibry and especially porous materials should be coated with adhesive twice (2. application after a short drying time).



Instruction for use

Before use, stirr adhesive well.

Apply the adhesive with a brush or an adhesive application machine evenly to both parts to be bonded. After the drying time, the parts are bonded within the contact life with a short pressure. Drying time and contact life are depending on materials to be bonded, room temperature and rel. air humidity. The drying time can be accelerated by infrared radiation or with hot-air.

By bondings with heat activation, the activation time is 1 - 3 min. at 60 - 90°C; by shock activation 3 - 5 sec. Activation time has to be determined by proper tests.

With rubber materials you have to test if these materials can withstand warm bondings (possible shrinking or modification of plasticity).

In order to avoid faulty bondings, the temperature of room and adhesive should not be below 18°C.

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