

### Description

A high performance solvent-free water-borne neoprene contact adhesive. Helmibond 776 is designed for versatility with excellent tack, high heat resistance and excellent bond strength. Can be brushed, rolled or sprayed and used in flat laminations and post-forming applications.

### Benefits

- Solvent-free with no VOC content.
- High solids yields excellent coverage and faster dry times.
- Long open time.
- Excellent “solvent like” contact bonds.
- Excellent green strength and high heat resistance for post-forming applications.
- Excellent bond adhesion to a variety of substrates including but not limited to DHPL, particleboard, plywood, leather, etc.

### Specifications

- **Solids Content:** 55.0% +/- 2.0%
- **Viscosity:** 2000 cps +/- 200 cps
- **Weight/Gal:** 9.17 lbs +/- 0.5 lbs
- **Coverage/Gal:** 763 ft<sup>2</sup> @ 3.0 dry grams  
382 ft<sup>2</sup> completed bond
- **Open Time:** 2 hours
- **Shelf Life:** 6 months
- **Color:** Natural or Green
- **Packaging:** Drums and pails
- **VHAP:** 0.00 lbs/lb of solids
- **VOC:** 0.00 lbs/gal (0 grams/L) < water and exempt solvents

### Handling & Storage

- **Do Not** use copper and its alloys to transfer or contain any contact adhesive.
- **Do Not** laminate copper with this adhesive.
- **Do Not** exceed the recommended “open time.”
- **Do Not** use to bond vinyl due to plasticizer migration.
- Thinning the adhesive is not recommended.
- For optimum performance, store containers at 65°F (18°C) or above.
- Avoid storage of product in direct sunlight.
- Consult the Material Safety Data Sheet prior to use.
- Product is not freeze/thaw stable. **Protect from freezing.** Product should not be used after being frozen.

### Usage Tip

Dry times can be accelerated by the use of air movement once the adhesive has been applied to the substrates.

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## Application Guidelines

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. 776 can be brushed, rolled and sprayed. If brushing and rolling, apply 100% coverage (3.0 dry grams/sq. ft. or higher). If spraying, coating weight of 2.5 – 3.5 dry grams should be applied. The atomization pressure at the gun should be 5 – 20 psi and the fluid pressure should be 10 to 15 psi.
3. 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 insure 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.
4. Allow the adhesive to dry properly before bonding. Water-borne 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 coating weight. Drying time can be reduced using air movement, drying ovens, etc.
5. Bonds can be made as soon as the adhesive is dry. However bonds made anytime in the 2 hour open time will be strong as those made immediately after dry.
6. Position the pieces carefully, since a strong bond is made instantly upon contact.
7. Use good uniform pressure to insure good film fusion. A pinch roller is the optimum method for applying pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is applied with a J-roller.
8. The completed panel can be routed or trimmed, cut filed and machined immediately.

## Recommended Equipment

	<u>Automatic</u>		<u>Manual</u>	
	<b>Binks</b>	<b>DeVilbiss</b>	<b>Binks</b>	<b>DeVilbiss</b>
<b>Spray gun</b>	Mach 1A	AGXV-541	Mach 1	JGHV-531
<b>Fluid tip</b>	94	FF	94	FF
<b>Fluid needle</b>	47-478	FF	54-3941	FF
<b>Air cap</b>	94P	46	94P	33, 46