

### **Description**

Helmibond 856 is a fast setting yellow PVA that is used for high speed assembly processes, offering short clamping times. It is designed for general assembly of all types of wood products and applications include edging, face gluing, tongue and groove, corner blocks, panel to frame, dowelling etc.

### **Benefits**

- Environmentally friendly.
- High shear strength.
- High initial tack.
- Fast setting.
- Non-toxic.
- Excellent bond adhesion to a variety of substrates including but not limited to soft woods, hardwoods, DHPL, veneer, particleboard, plywood, MDF, etc.

### **Specifications**

- **Solids Content:** 46.0% +/- 2.0%
- **Viscosity:** 4500 cps +/- 1000 cps
- **Weight /Gal:** 9.15 lbs +/- 0.2 lbs
- **Shelf Life:** 6 months from date of manufacture
- **pH:** 4.0 - 5.0
- **Color:** Yellow
- **Coverage:** 229 ft<sup>2</sup> @ 7 wet mils
- **Packaging:** Totes, drums, pails and gallons
- **VOC:** 0.00 lbs/gal (0 grams/L) < water and exempt solvents

### **Handling & Storage**

- Consult the Material Safety Data Sheet prior to use.
- Avoid contact with skin and eyes. Rinse affected areas immediately with water.
- Keep container tightly closed and store off the floor when not in use.
- **Protect from freezing.**
- Store containers where temperatures will not be less than 10°C (50°F) and will not exceed 32°C (90°F).
- Use at room temperature 20°C (68°F).

### **Clean Up**

Use warm water when the adhesive is in the wet state.

### **Disposal**

Do not flush or pour wet adhesive into the sewer system without authorization from local authorities.

### **Application Guidelines**

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive and substrates should be at 18°C (65°F) or above.
3. Adhesive can be applied squeeze bottle, manual roller or roll coater.
4. Moisture content of wood should be 6% - 10%.
5. At least one substrate must be porous.

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## **Applications**

### **General Assembly**

1. Apply 856 in a continuous coat to the entire area of one or both of the surfaces to be bonded.  
Adequate adhesive should be applied to achieve a slight squeeze out when clamping.
2. Clamp for 30 minutes minimum or until adhesive film dries.
3. Allow a minimum of 1 hour prior to machining.

### **Cold Press Laminating**

1. Apply using a roll coater utilizing 16 grooves/inch and apply 6 – 8 wet mils of adhesive. Plywood applications may require a higher coating of adhesive.
2. Open time is 2 - 3 minutes with a closed assembly time of 5 minutes.
3. Cold press time is a minimum of 30 minutes at 50 psi at 21°C (70°F) and an RH of 45% - 50%. Press time can be up to 2 hours depending on plant temperature, humidity, stock density, moisture content of substrates, application amount, etc.
4. For cold pressing, typical pressures are 30 psi – 100 psi for DHPL, 100 psi – 150 psi for solid core stock and 100 psi to 250 psi for veneered panels.

**Be careful to avoid contamination by iron (rust) from any source, such as containers or application equipment, as such contamination leads to dark glue lines and staining on woods high in tannic acid.**

**NOTE: THIS PRODUCT MAY NOT BE COMPATIBLE WITH FIRE RETARDENT BOARD. CONSULT WITH HELMITIN TECHNICAL SUPPORT PRIOR TO USE WITH THIS TYPE OF SUBSTRATE.**