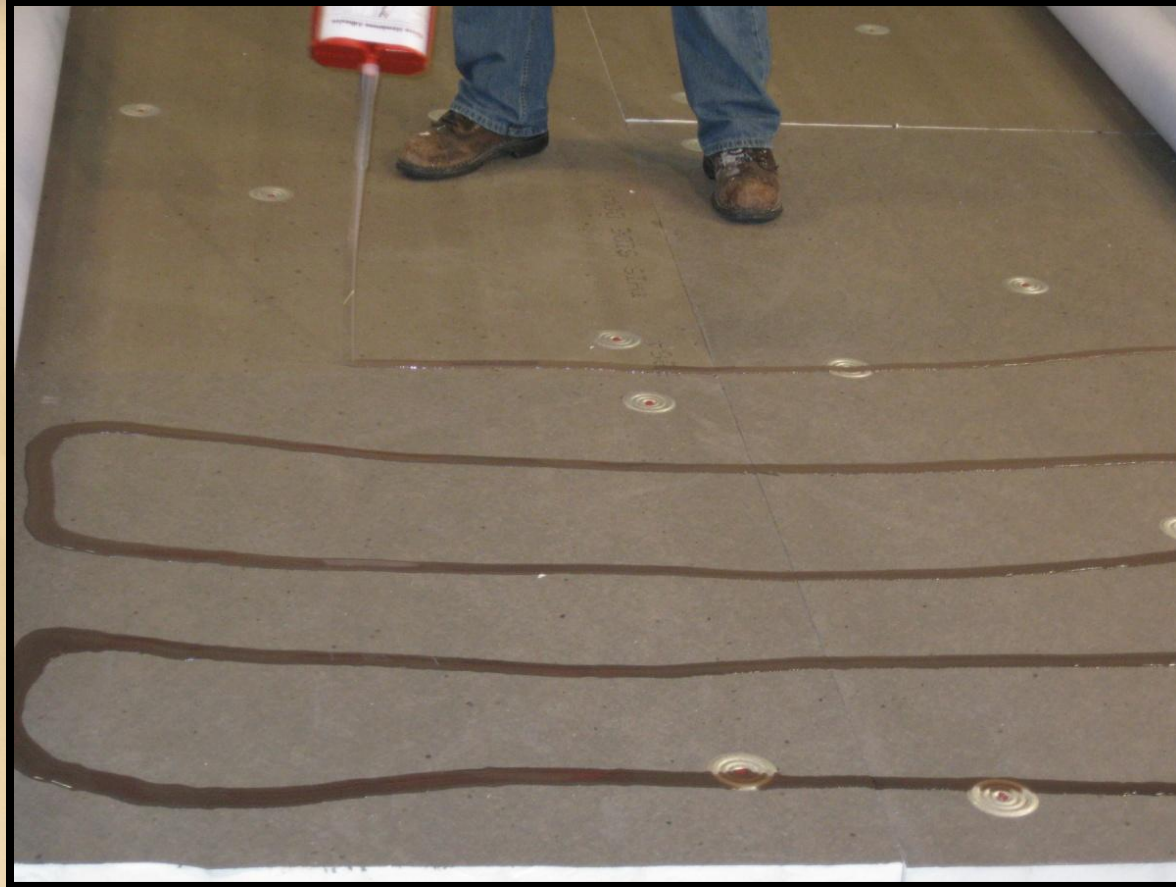


XR StickTM



Firestone Building Products

XR Stick™

About

- Firestone's **XR Stick™** is a two-component, low-rise polyurethane adhesive designed to attach ***Firestone UltraPly™ TPO XR, fleece backed roofing membrane*** to a variety of acceptable substrates as allowed by Firestone specifications.
- **XR Stick™** (cartridges) can be dispensed using various Firestone approved hand or multi bead electric dispensing units. The dispensing units extrude Part A and Part B simultaneously through a static mixer which results in a properly mixed **bead of adhesive** to be applied to the receiving substrate.
- **XR Stick™** (box) is specifically designed to be dispensed using the PaceCart 2™ dispenser.

***XR* Stick™**

Stages

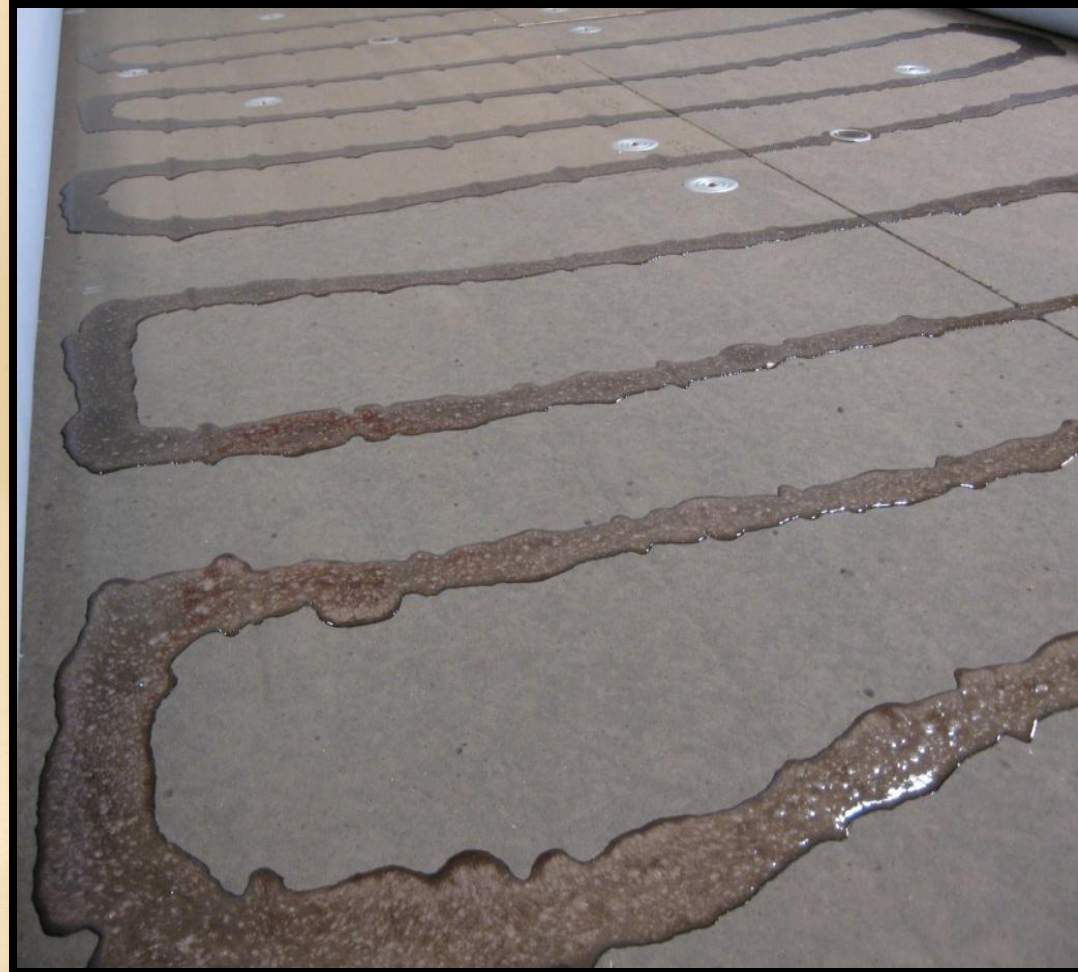
- There are ***three*** different stages that ***XR* Stick™** goes through.
 - Cream
 - Rise
 - Tack-Free
- These stages occur at ***different times*** throughout the application process.

XR Stick™

Stages

Cream

- ***XR Stick™*** begins its reaction to transition from a liquid to a foam state.
- The product starts to take on a “bubbly” look from the center of the bead and gradually works its way to the outside edges of the bead.



***XR* Stick™**

Stages

Rise

- The entire bead of ***XR* Stick™** begins to rise and is sticky to the touch.
- The dark brown color gives way to a light tan color.
- This is when to place the membrane into the ***XR* Stick™** Adhesive.
- ***XR* Stick™** stays in rise for 2-5 minutes (depending on ambient conditions).



***XR* Stick™**

Stages

Tack-Free

- The bead starts to harden and develop a shell-like coat.
- ***XR* Stick™** should be hard to the touch during this stage.
- If the ***Tack-Free*** stage occurs before the membrane has been laid in the ***XR* Stick™**, discard and re-apply.



XR Stick™

Features and Benefits

- Fast installation of UltraPly TPO XR membrane when compared to XR Bonding Adhesive.
- Environmentally safe and friendly.
 - No Solvents or VOC's.
- Easy application using a battery powered hand dispenser or the PaceCart 2.
- Once dispensed and applied to proper substrate, reaction occurs quickly and is ready for membrane attachment within 2-5 minutes (depending on ambient conditions).
- Substantial FM & UL Approvals.

XR Stick™

Application

- Install **XR Stick™** only when ambient conditions, and bonding substrates and membranes, exceed 40 °F (4 °C) and are rising.
- Apply the **XR Stick™** adhesive onto the substrate in beads specified in the Technical Information Sheet (T.I.S.) or job specifications.
 - Contact your Technical Coordinator if a job is outside of the T.I.S. scope.
- It is important to allow **XR Stick™** to develop past the cream phase before membrane placement. **DO NOT TRY TO INSTALL DURING THE TACK-FREE PHASE!**

XR Stick™

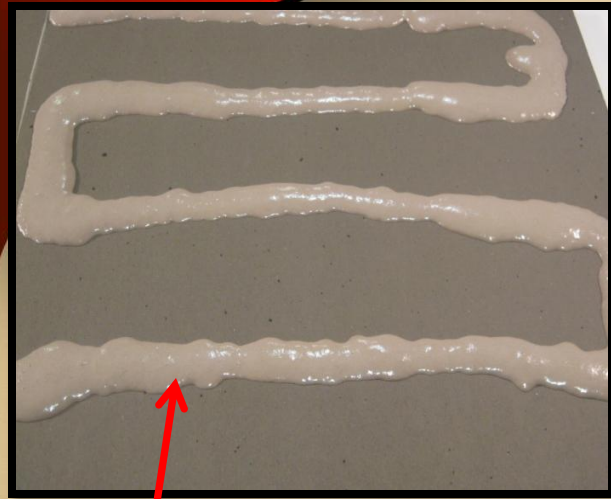
Application

- Once the membrane is laid into the ***XR Stick™***, thoroughly apply continuous pressure to the membrane using a roller. The roller should not exceed 150 lbs.
- Rolling is **required** to ensure that the ***XR Stick™*** is fully adhered to the fleece on the back of the XR membrane.

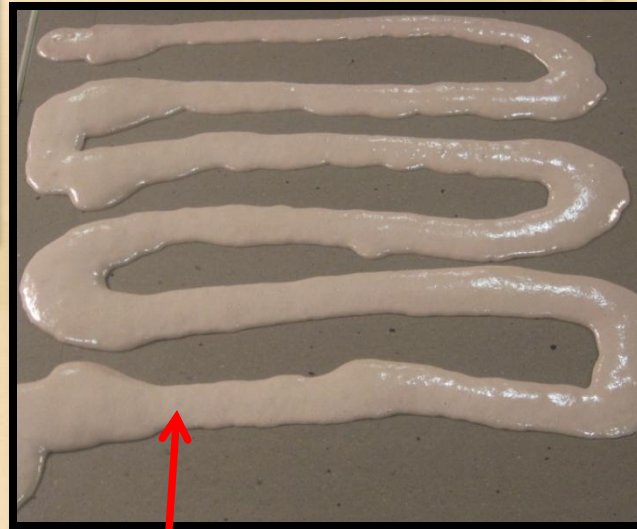


XR Stick™

Bead Spacing

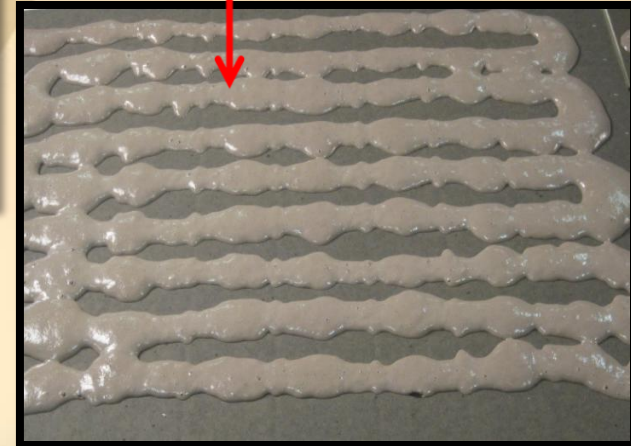


Field Bead Spacing: 12" o.c.



Perimeter Bead Spacing: 6" o.c.

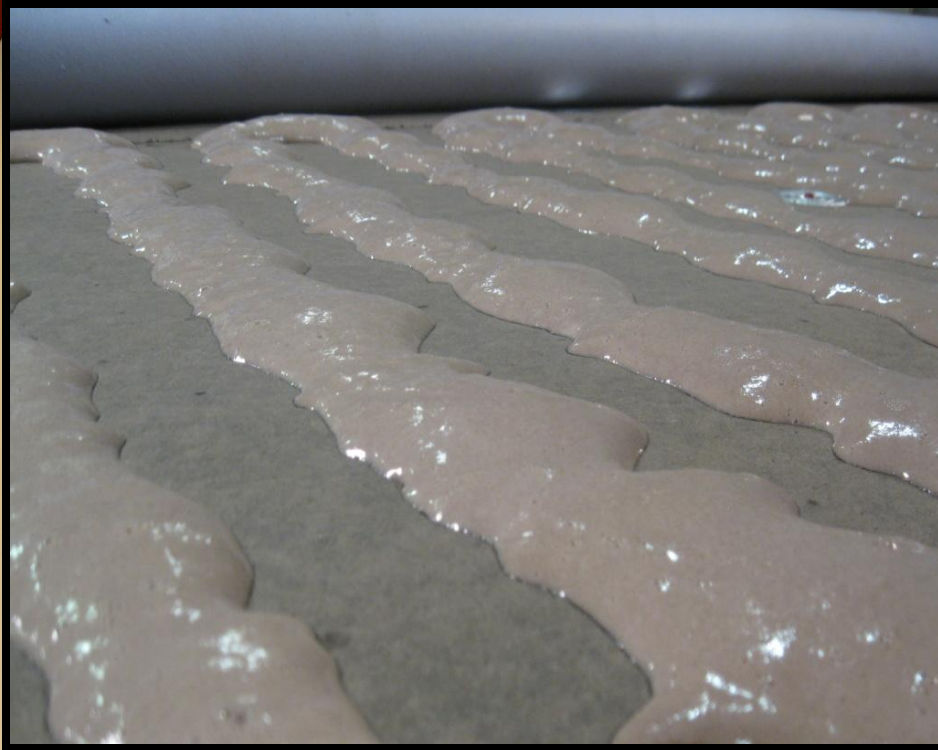
Corner Bead Spacing: 4" o.c.



Refer to the T.I.S. for building specific bead spacing guidelines.

XR Stick™

Warranty Information



- Standard warranties are available for XR Stick applied membrane systems up to a 20-year warranty period. Please refer to the Firestone Technical Database at technicaldatabase.fsbp.com for specific warranty requirements.