

GenFlex EPDM Solvent-Free Bonding Adhesive

GenFlex Roofing Systems is committed to making your job easier. To help you during installation and to ensure optimum results when using GenFlex EPDM Solvent-Free Bonding Adhesive (SFBA), please read the following install tips prior to application. *Note: Application of SFBA is different and cures differently than other bonding adhesives. Please review the Technical Information Sheet (TIS) and Application Guide prior to your first application.*

DISPENSING EQUIPMENT

- A standard short nap roller (3/16" - 1/4"), along with any back-rolling, provides the uniform application necessary to achieve the coverage rate for this adhesive.
- Better Spreader hole spacing: "hole every 1.5" O.C. Back-roll immediately after dispensing.
- Drop Spreaders provide an efficient method to automate dispensing. Back-rolling is required after dispensing.
- It is critical that the weighted roller weighs at least 5 lbs. per lineal inch. A standard 15" roller must weigh a minimum of 75 lbs.



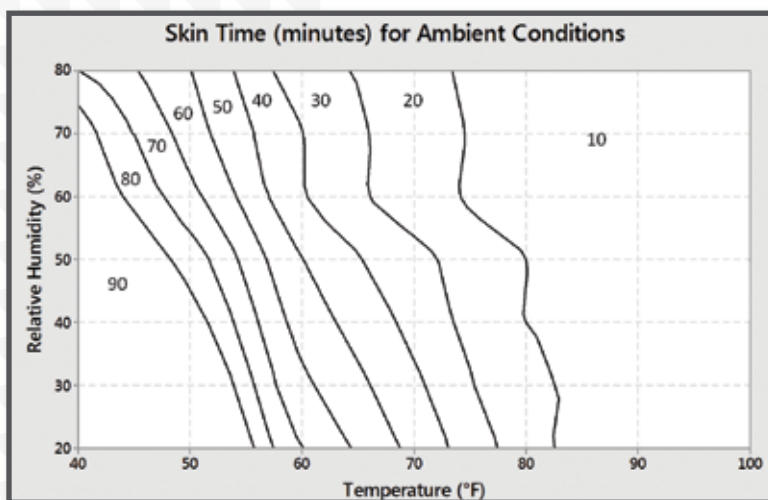
Amount of adhesive needed to cover 4' x 8' at a coverage rate of 150 ft² per gallon.

PRIOR TO APPLICATION

- SFBA is a moisture curing adhesive, so high humidity and high heat accelerate the curing process. Test the work/cure time of SFBA with scrap material to gauge cure time prior to use on the roof as there should be slight tackiness prior to mating the EPDM. Periodically check temperature and humidity throughout application and adjust install accordingly.
- Allow membrane to relax for minimum of 30 mins. before applying adhesive.



Proper weighted roller.



For example, at 70 °F and 50% relative humidity, the product will skin in less than 30 minutes. But at 70 °F with 70% relative humidity, it will skin in less than 20 minutes. Above 85 °F will cause the adhesive to skin in less than 10 minutes.

APPLICATION

- Application rate is 150 ft² (13.9 m²) per gallon. A five gallon pail will cover 750 ft² (69.7 m²) or about 23 standard 4' x 8' insulation boards. When using a Wet Film Thickness Gauge, the reading should be 11 mil (150ft²) to 13 mil (120ft²).
- Leave NO puddled or thick adhesive areas, as they may result in blistering. Puddle areas or areas of thick adhesive must be back rolled to avoid potential blistering. Uniform thin application will provide positive results.
- During higher temperature and/or higher humidity days, the installer may need to apply the adhesive and mate the membrane in five foot increments to prevent adhesive from skinning over and not bonding to the EPDM. If skinning occurs, a light re-coat (coverage rate greater than 150 ft²) of adhesive is required.
- Remove adhesive on ALL AREAS that will be seamed.
- SFBA is not to be used where insulation facer has been removed, such as roof drain sump pans or scupper flanges. For this application, use Firestone approved solvent based bonding adhesive.
- SFBA takes up to 24 hours for curing. At the end of the day, some areas may still feel wet underfoot. DO NOT assess adhesion until the next day.



X Light Coverage
Will cause lack of adhesion.



✓ Proper Coverage
Uniform distribution with no light or heavy spots.



X Heavy Coverage
Thick, pooled areas will cause blistering.

INSTALLATION VIDEO



Click here to watch the GenFlex Solvent-Free Bonding Adhesive installation video. Also available on our YouTube page or online at GenFlex.com

For more information, contact your local sales rep or visit GenFlex.com
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