

EPDM Solvent Free Bonding Adhesive

Item Description

5 Gallon Pail (18.9 L)

Item Number

W593587029



Product Information

Description

GenFlex EPDM – Solvent Free Bonding Adhesive is a polymer based bonding adhesive for adhering non-reinforced GenFlex EPDM membranes to approved substrates on vertical and horizontal applications. This adhesive is formulated for a single-sided, “wet lay” application that does not need mixing, contains NEAR ZERO volatile organic compounds (VOC) and meets most current US environmental regulations, including Ozone Transport Commission (OTC) and South Coast Air Quality Management District (SCAQMD) rule 1168 regulations. As an odor free and non-hazardous product, the GenFlex EPDM – Solvent Free Bonding Adhesive is an ideal bonding adhesive that is used to quickly install GenFlex EPDM membrane in an environmentally and contractor friendly manner.

Method of Application:

Roofing Application

1. Position non-reinforced EPDM in place over substrate (not to exceed 1":12" slope) to receive the EPDM membrane.
2. Allow EPDM membrane to relax for 30 minutes (minimum).
3. Fold EPDM membrane back to expose the substrate to receive EPDM – Solvent Free Bonding Adhesive.
4. Surfaces to receive GenFlex EPDM – Solvent Free Bonding Adhesive shall be clean, smooth, dry, and free of sharp edges, loose and foreign materials, oil, grease, and other contaminants. Sweep the under-surface of the membrane with a stiff bristled broom to remove excess dusting agent, if present, and remove other contaminants from the under-surfaces.
5. Apply GenFlex EPDM – Solvent Free Bonding Adhesive to the substrate (**not the EPDM membrane**) uniformly at 120 to 150 square feet per gallon coverage rate. EPDM – Solvent Free Bonding Adhesive may be dispensed on substrate as follows:
 - a. “Dip & Roll” using paint rollers
 - b. Drop Spreader with rollers: Ambient conditions will dictate the dispensing rate
 - c. Spray application:
 - 1) Graco 60:1 Xtreme pump with NXT air motor, Heavy Duty Cart & Hopper Kit for gravity feed, 50' X 3/8" 4500 PSI high pressure hose, G-40 air assisted airless applicator with G40 519 tip. 1000 PSI pressure yields 9" wide adhesive fan when spray tip is 18" from the substrate. *Changing the spray tip to substrate distance will change the fan width.* Follow spraying with back-rolling *immediately* to uniformly apply adhesive on substrate.
 - 2) 1000 PSI pressure yields 9" wide adhesive fan when spray tip is 18" from the substrate. *Changing the spray tip to substrate distance*

NOTE: Take care to keep EPDM Solvent-free Bonding Adhesive from lap splice areas.
NOTE: Do not mix
6. Carefully, and slowly mate the EPDM membrane into the wet adhesive 2-5 minutes after dispensing the freshly applied bonding adhesive, taking care not to create any air bubbles or voids under the membrane.
7. Broom the membrane in place with a stiff bristled broom, *followed by rolling with a heavy roller*, (weight of 5 pounds per linear inch, e.g carpet roller; lawn roller; etc.) immediately after laying the EPDM into the adhesive to insure proper bonding and adhesion.

Vertical Surfaces

1. Apply EPDM – Solvent Free Bonding Adhesive to EPDM membrane and the vertical substrate to receive EPDM membrane uniformly at coverage rate of 120 – 150 square feet per gallon on the substrate.
2. Allow a brief open time period to allow EPDM – Solvent Free Bonding Adhesive to develop tack. This open time period will vary, depending on ambient conditions. Warm, humid days will require brief open time period. Cool, dry, days will require longer open time. Touch the adhesive surface with a clean, dry finger to determine whether tack has developed. *Some trial and error will be required.*
3. After a brief open time for tack development, carefully and slowly apply the EPDM membrane to the adhesive on the vertical substrate.
4. Roll the freshly vertically applied EPDM membrane using a 2" wide seam roller to insure proper bonding pressure.

Dispensing:

- EPDM – Solvent Free Bonding Adhesive can be dispensed via “dip and roll” method, using a medium nap solvent resistant paint roller to uniformly apply adhesive to substrate.
- EPDM – Solvent Free Bonding Adhesive can be dispensed via commonly used “drop spreaders” followed by back-rolling to uniformly apply adhesive to substrate. Ambient conditions will dictate rate of dispensing to result in specified coverage rate.
- EPDM – Solvent Free Bonding Adhesive can be spray applied using Graco 60:1 Xtreme pump followed by back-rolling to uniformly apply adhesive to substrate- see specifics listed under Approved Power Dispensing Equipment.

Storage:

- Store in original unopened containers at temperatures between 60 °F and 80 °F (16 °C and 27 °C) until ready for use.
- If top layer of adhesive “skins over” the “skin” can be removed to expose fresh adhesive.
- Shelf life of 12 months can be expected if stored in original unopened containers when stored at temperatures between 60 °F and 80 °F (16 °C and 27 °C). If exposed to lower temperatures, restore to room temperature before use.
- Temperature exposure exceeding 80 °F during storage will reduce the shelf life.
- Rotate stock to insure stored material will not exceed the 12 month shelf life.

Coverage:

120 - 150 ft² per gallon (2.95 to 3.68 m² per Liter) (nominal). Some surfaces that are more uneven and porous may result in a lower coverage rate; while smooth, less porous substrates could result in higher coverage rates. All insulation joints, gaps in substrates greater than ¼" (6.3 mm) shall be filled with acceptable filler.

*LEED® Information:

Post Consumer Recycled Content: 0%
 Post Industrial Recycled Content: 0%
 Manufacturing Location: Spring Lake MI
 *NOTE: LEED® is a registered trademark of the U.S. Green Building Council.



Precautions:

- Review the Safety Data Sheet (SDS) before use.
- Use only with non-reinforced EPDM membrane.
- Maximum roof slope is 1" in 12".
- DO NOT MIX
- Use only when ambient and substrate temperatures exceed 40 °F (4 °C). Do not use when temperatures will drop below freezing within 12 hours after installation.
- Harmful or fatal if swallowed.

Precautions Continued:

- Avoid prolonged inhalation.
- Avoid skin contact. Wear OSHA approved gloves when handling.
- Wear appropriate eye protection- safety goggles with side shields.
- Do not thin adhesive.
- Do not use for splicing.
- Keep this adhesive off membrane splice areas.
- Use only in well ventilated areas.
- Cover pail when not in use.
- Recommended cleaning procedures:
 - *Before* the adhesive cures: Splice Wash SW-100 or Single Ply LVOC Splice Wash using clean cotton rags.
 - *After* the adhesive cures: Single Ply LVOC Splice Wash using QuickScrubber™ Scrub Pads; or remove by mechanical means (wire brush if substrate will not be damaged).
- This adhesive is moisture sensitive. Exposure to moisture initiates curing. Use contents of pail within 72 hours after initial pail opening, *if the pail has been sealed tightly*.
- This adhesive is heat sensitive. Temperature exposure exceeding 80 °F (32 °C) during storage will reduce the shelf life. Temperature exposure exceeding 90 °F (32 °C) during application will hasten curing.
- Remove any skim coat of adhesive that may be present in pail; do not attempt to use skimmed or thickened adhesive.

| Typical Properties | |
|------------------------------|---|
| Property | Minimum Performance |
| Base Polymer: | Synthetic |
| Color: | Yellow |
| Brookfield Viscosity: | 6,000 ± 10,000 CPS |
| Weight/Gallon | 8.3 to 8.5 Pounds/Gallon (0.9946 Kg/L to 1.0185 Kg/L) |
| Percent Solids: | 100% |
| Field Dispensing: | Spray Applied, Drop Spreadable, Dip & Roll with rollers |
| VOC Content: | 13 ± 3 Grams/Liter |

| Acceptable Substrates | |
|---|--|
| Substrate | Note: |
| Structural Concrete (New and Existing) | Substrate must be clean, dry, fully cured and may require primer |
| Plywood and OSB | Check local code for acceptance of direct application |
| Masonry and CMU (New and Existing) | Substrate must be clean, dry, fully cured and may require primer |
| GenFlex ISO Insulation | |
| GenFlex Coated Glass Facer | |
| GenFlex HD ISO | |
| GenFlex HD Composite ISO | |
| DensDeck Products | DensDeck is a registered trademark of the G-P Gypsum Corporation |
| Securock | Securock is a registered trademark of the USG Corporation |
| DexCell | DexCell is a registered trademark of the National Gypsum Company |

Non-Acceptable Substrates

Substrate

Expanded/Extruded Polystyrene

Fiberglass

Perlite

Existing single ply roof membranes

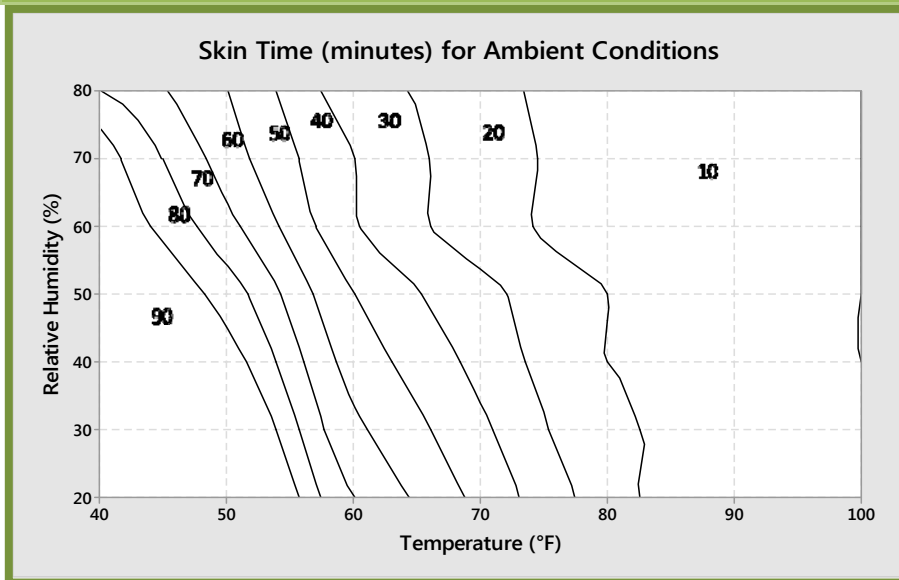
Existing asphalt and granule surfaced modified bitumen roofs

Coal tar pitch built up roofs

Cementitious wood fiber/tectum

Direct application to steel deck, lightweight concrete, gypsum

Skin Time



Approved Power Dispensing Equipment:

Graco 60:1 Xtreme pump with NXT air motor, Heavy Duty Cart & Hopper Kit for gravity feed, 50' X 3/8" 4500 PSI high pressure hose, G-40 air assisted airless applicator with G40 519 tip. 1000 PSI pressure yields 9" wide adhesive fan when spray tip is 18" from the substrate. *Changing the spray tip to substrate distance will change the fan width.* Follow spraying with back-rolling *immediately* to uniformly apply adhesive on substrate.

Please contact Quality Building Services Technical Department at 1-800-443-4272 option 1, for further information.

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