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PRODUCT DATA SHEET

GenFlex FB Bonding Adhesive

DESCRIPTION

GenFlex FB Bonding Adhesive is used to adhere both GenFlex Fleece Backed TPO and standard TPO membranes directly to various substrates, including approved insulations and deck types.

PHYSICAL PROPERTIES

PROPERTY	TYPICAL VALUES
Base	Nitrile Rubber
Color	Brown
Solvents	Blend of Acetone and Diisobutyl Ketone
Weight	6.99 – 7.73 lb/gal (0.838 – 0.926 kg/L)
Specific Gravity	0.838 – 0.926
Viscosity	4,000 - 6,000 cps, with #4 spindle @ 10 rpm
V.O.C. Content	1.72 lb/gal (206 g/L)

INSTALLATION (Fleece Backed TPO Membrane)

- Surfaces must be clean, smooth, dry, and free of sharp edges, loose and foreign materials, oil, grease, and other contaminants.
- Stir thoroughly to achieve a uniform mix with no marbling or sediment on the bottom evident. **STIR BEFORE AND DURING USE.**
- Adhesive must be applied in a uniform thickness to the **base substrate only**. Apply with either a 9" (228.6 mm) wide solvent resistant roller designed for medium to semi-rough textured surfaces or an industrial grade adhesive sprayer. **DO NOT APPLY ADHESIVE TO THE POLYESTER BACKING PORTION OF THE MEMBRANE.** If the adhesive is spray applied, it must be back-rolled with a similar type roller to ensure proper contact and coverage. **DO NOT APPLY FB BONDING ADHESIVE TO SEAM PORTION OF THE MEMBRANE.**
- Apply the adhesive in a uniform manner, avoiding globs and puddles of adhesive that may lead to blistered membranes.
- FB Bonding Adhesive shall have a brief flash-off period of approximately 5 to 30 minutes, depending on ambient conditions, before mating the membrane. The adhesive shall be tacky to the touch when mating the membrane.
- Starting at the fold of the Fleece Backed TPO membrane, roll the mating portion into the coated substrate slowly and evenly to minimize wrinkles. To ensure proper contact, compress the bonded portion of the membrane to the substrate with a stiff push broom using heavy pressure immediately after mating, followed by the use of a heavy roller (approximately 150 lb (68.0 kg)) to ensure proper contact of membrane to substrate.

INSTALLATION (Standard TPO Membrane)

- Surfaces (both substrate and back side of the TPO membrane) to received the FB Bonding Adhesive must be clean, smooth, dry, and free of sharp edges, loose and foreign materials, oil, grease, and other contaminants.
- Stir thoroughly to achieve a uniform mix with no marbling or sediment on the bottom evident. **STIR BEFORE AND DURING USE.**
- Adhesive must be applied in a uniform thickness to both the approved substrate and the TPO membrane. Apply FB Bonding Adhesive with either a 9" (228.6 mm) wide solvent resistant roller designed for medium to semi-rough textured surfaces or an industrial grade adhesive sprayer. If the adhesive is spray applied, it must be back-rolled with a similar type roller to assure proper contact and coverage.
- Apply the adhesive in a uniform manner to both surfaces avoiding globs and puddles of adhesive that may lead to blistered membranes. **DO NOT APPLY FB BONDING ADHESIVE TO THE SEAM AREA OF THE MEMBRANE.**
- FB Bonding Adhesive shall have a flash-off period of approximately 30 minutes before mating the membrane. Touch the adhesive surface with a clean dry finger to be certain that the adhesive does not stick or string. As you are touching the adhesive, pushing straight

down to check for stringing. Also, push forward to verify the adhesive is ready throughout its thickness. If either motion exposes wet or stringy adhesive when the finger is lifted, then it is not ready to adhere the membrane. **FLASH OFF TIME WILL VARY DEPENDING ON THE AMBIENT AIR CONDITIONS.**

- Roll the mating portion of the membrane into the coated substrate slowly and evenly to minimize wrinkles. To ensure proper contact, compress the bonded portion of the membrane to the substrate with a stiff push broom using heavy pressure immediately after mating.

APPLICATION PRECAUTIONS

100% adhesive coverage on the substrate is required when used to adhere Fleece Backed TPO membrane.
100% adhesive coverage on both substrate and membrane is required when used to adhere standard TPO membrane.
Do not apply bonding adhesive to splice area.
Avoid globs or puddles of adhesive.

PRODUCT DATA

Container Size: 5 gallon (18.9 Liter) Pail
Product Number: W590030095
Flash Point: Less than -2 °F (18.9 °C)
Coverage Rate: Correctly applied to substrate only, a coverage rate of 70 to 90 ft²/gal (1.7 to 2.2 m²/L) of bonding adhesive may be obtained.

LEED INFORMATION

Recycled Content	
Post Consumer	0%
Post Industrial	0%

STORAGE

Store indoors in original unopened containers at a temperature between 60 °F and 80 °F (16 °C and 27 °C) for maximum shelf life. Do not store on roof in direct sunlight. When exposed to lower temperatures, restore to room temperature prior to use.

SHELF LIFE

9 months; shelf life will be shortened if exposed to elevated temperatures.

PRECAUTIONARY DATA

This product is extremely flammable. Vapors may cause flash fires. Vapors may ignite explosively under certain conditions. Keep away from fire, sparks, and sources of heat. Extinguish all flames and pilot lights. Turn off electronic motors, stoves, or heaters, or any source of ignition during use and until all vapors have been dispersed. Do not smoke. Open all doors and windows. Close containers after use. Use with adequate ventilation. Avoid prolonged breathing of vapors. Avoid prolonged and repeated contact with skin. Store at temperature of 80 °F (27 °C) or below for maximum shelf life. Keep out of reach of children. Keep away from eyes. Use chemically resistant gloves. Thinning is not allowed. Review Material Safety Data Sheet prior to use.

