

PRODUCT DATA SHEET

GenFlex All Purpose Bonding Adhesive

DESCRIPTION

GenFlex All Purpose Bonding Adhesive is a solvent based contact adhesive designed specifically for bonding GenFlex EPDM and TPO membranes and flashings to approved substrates such as insulations, wood, metal, concrete and other acceptable substrates.

PHYSICAL PROPERTIES

PROPERTY	TYPICAL VALUES
Base	Blend of Polychloroprene and SBR
Color	Yellow
Solvents	Blend of Acetone, Toluene, Hexane, Xylene
Viscosity	3,300-3,800 cps, R.V.F. spindle @ 10 RPM
Specific Gravity	0.7909-0.8868
Weight/Gallon	6.6 – 7.4 lb/gal

INSTALLATION

- Surfaces that will receive GenFlex All Purpose Bonding Adhesive must be clean, smooth, dry, free of sharp edges and loose materials and other contaminants.
- Stir the adhesive thoroughly before and during use to achieve a uniform mix with no sediment on the bottom with no marbling evident. **DO NOT THIN MATERIAL.**
- Fold roofing membrane back so one-half (½) of the underside of the panel is exposed.
- Apply Bonding Adhesive to the substrate and the membrane at about the same time using a 9" (228 mm) medium nap roller. A coverage rate of 45 – 60 ft²/gal (1.1 – 1.4 m²/L) may be achieved depending on the substrate. Coverage rates will vary depending on substrate texture and porosity. When applying the Bonding Adhesive, ensure a uniform coverage of both surfaces that will be adhered. Care should be taken not to apply Bonding Adhesive within the seam areas.
- Allow adhesive to flash off or dry completely. Touch down on the adhesive surface with a clean dry finger to determine that the adhesive does not string. As you touch the adhesive surface, push down to check that the adhesive has completely dried below the surface. If either test exposes wet adhesive when the finger is lifted, then the adhesive is not ready for mating. Flash off time will vary depending on ambient conditions.
- Apply the adhesive coated membrane into the adhesive coated substrate in a continuous motion avoiding wrinkles and folds.
- Using a push broom, apply firm downward pressure to the membrane to promote 100% adhesion to the substrate.
- Install adjoining panels in a similar manner, lapping edges a minimum of 3" (76 mm) in preparation for seaming.
- All Purpose Bonding Adhesive can be dispensed by means of Power Roller or Spray equipment. Contact GenFlex for recommendations.

APPLICATION PRECAUTIONS

100% adhesive coverage on both the membrane and substrate is required. Do not apply bonding adhesive to seam areas. Avoid globs or puddles of adhesive.

PRODUCT DATA

SIZE	CONTENTS	PRODUCT #
1 gallon (3.8 Liter)	4 Cans per Carton	W590010158
3 gallon (11.4 Liter)	NA	W590010157

Flash Point: Less than 0°F (16°C)

Coverage Rate: Correctly applied, 1 gallon (3.8 L) of bonding adhesive will cover approximately 45 – 60 ft²/gal (1.1 – 1.4 m²/L) of finished surface.

Some insulation surfaces are more uneven and porous and will result in a lower coverage rate while smooth non-porous substrates will result in higher coverage rates. Rates are based on roller application to both mating surfaces.

Very porous substrates (Rough wood, concrete block) may require two coats of Bonding Adhesive, to ensure proper coverage and adhesion. This can be determined by adhering a small piece of membrane to the porous substrate and testing the bonding strength.

LEED INFORMATION

Recycled Content	
Post Consumer	0%
Post Industrial	0%
V.O.C. Content	633 g/L

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

12 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 and use chemically resistant gloves when handling.

Review Material Safety Data Sheet prior to use