

Product Data Sheet



TPO Bonding Adhesive

Item Description	Item Number
Bonding Adhesive – 5 gallon (18.9 liter)	W590030400

Description

GenFlex EZ TPO Bonding Adhesive is a solvent based contact adhesive designed specifically for bonding GenFlex EZ TPO membranes to approved insulations in addition to wood, metal, masonry, and other acceptable substrates.

NOTE: Not for use in adhering EZ TPO Fleece Backed membranes.

Coverage

A coverage rate of 45 – 60 ft² per gallon (1.10 – 1.47 m² per liter) may be obtained depending on the substrate. 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 adhesion. This can be determined by testing a small area. Check by adhering a small piece of membrane to the porous substrate to verify the bonding strength.

Method of Application

1. Surfaces to receive the EZ TPO Bonding Adhesive must be clean, smooth, dry, and free of sharp edges, loose and foreign materials, oil, grease, and other contaminants.
2. Stir the adhesive thoroughly to achieve a uniform mix with no sediment on the bottom and no marbling evident before and during use.
3. Apply the EZ TPO Bonding Adhesive at about the same time to both the exposed underside of the sheet and the substrate to which it will be adhered so as to allow approximately the same drying time. Apply EZ TPO Bonding Adhesive evenly avoiding areas of accumulation.
4. Apply the EZ TPO Bonding Adhesive with a solvent resistant paint roller and roll the adhesive onto the mating surfaces. When applying EZ TPO Bonding Adhesive, ensure complete uniform coverage of both surfaces that will be adhered. Care must be taken not to apply bonding adhesive over seam areas

5. EZ TPO Bonding Adhesive can be dispensed by means of power rollers or industrial spray equipment. Other equipment may be used as recommended by the manufacturer for application of this adhesive. Note: Spray applied bonding adhesive requires back-rolling with 9" (228.6 mm) wide solvent resistant roller (medium nap) to insure 100% coverage of the adhesive on the substrate and membrane.
6. Allow bonding adhesive to flash off until tacky. Touch down on the bonding adhesive surface with a clean, dry finger to be certain that the adhesive does not string. As you are touching the adhesive, pushing straight down to check for stringing, also push forward on the adhesive at an angle to ensure that the adhesive solvents have flashed off and ready throughout its thickness. If either motion exposes wet areas or sticking when the finder is lifted, then it is not ready for mating. Flash off time will vary depending on ambient conditions.
7. Starting at the fold, roll the previously coated portion of the sheet into the coated substrate slowly and evenly so as to minimize wrinkles.
8. To ensure proper contact, compress the bonded half of the sheet to the substrate with a stiff push broom using heavy pressure immediately after mating.
9. Contact your GenFlex Technical Coordinator at 1-800-428-4511 for specific application information.

Storage

- Store in original unopened containers at temperatures between 60 °F to 80 °F (16 °C to 27 °C) until ready for use.
- For optimum results, rotate stock to ensure stored material has not exceeded the shelf life.

Shelf Life

Shelf life of one year.

Precautions

- Flammable. Keep away from fire and open flame and other possible ignition sources during storage and use. Do not smoke when using.
- Harmful or fatal if swallowed.
- Avoid prolonged and repeated contact with skin. Gloves should be worn (OSHA approved).
- Avoid eye contact by wearing safety goggles with side shield.
- Thinning is not allowed.
- Do not use for splicing.
- Do not use with EPDM or XR membranes.
- Use only in well ventilated areas.
- Cover tightly when not in use.
- Recommended cleaner is Toluene (while fluid).
- Refer to Safety Data Sheets (SDS) for additional safety information.

LEED® Information

Post-Consumer Recycled Content: 0%

Post Industrial Recycled Content: 0%

Manufacturing Location: South Bend, IN


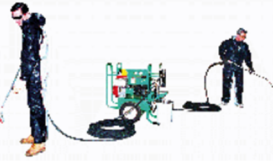
NOTE: LEED® is a registered trademark of the U.S. Green Building Council



Typical Properties

Properties	Typical Performance
Color	Yellow
Base	A blend of Polychloroprene and SBR rubbers
Solvents	A blend of Acetone, Hexane, Toluene and Xylene
Viscosity	3,300-3,800 cps, with R.V.F. spindle @ 10 rpm
Weight/Gallon	6.6-7.4 lb/gal
Specific Gravity	0.7909-0.8868
V.O.C. Content	5.282 lb/gal (633 g/L)
Pail Weight	Approximately 41 lb (18.6 kg)

Approved Power Equipment

Equipment	Requirements
	<p>Garlock 25ST Roller Boss Power Roller: 4 hp Honda Engine, 4 CFM Compressor, 25-gal pressurized supply tank (20 gal for material; 60-80 psi), up to 100 psi rating, 2 - ¾" x 30' supply hoses with swivels, 2 - 18" roller head assemblies.</p>
	<p>Garlock 2120 Commander Sprayer: 18 hp Kohler Engine, 4500 psi rating, 5 gallon per minute flow, 1200 psi pressure (minimum), Pump Displacement 45:1, GPM rating: up to 5 gpm, ½" x 100' hose, 2" intake pipe with screen, 5- or 55-gal drum containers, Graco Spray Tips: .023 to .031 diameter hose.</p>
	<p>Garlock Twin Gun Airless Sprayer: 6.5 hp Honda Engine, 3000 psi rating, Pump Displacement 30:1, GPM rating: up to 1 gpm, up to 400' of single ½" diameter hose, up to 200' of dual ½" diameter hose, ¾" intake pipe with screen, 5- or 55-gallon drum containers, bulk tank containers, Graco Spray Tips; .019 to .025 diameter hose (1850 psi operating pressure).</p>
	<p>Graco Spray Equipment: P70EC4-70 – 70:1 Xtreme Sprayer Package w/Heavy Duty car, Hopper package, w/NXT motor and Data Track, Xtreme-Duty high pressure hose, ¾" x 50', 7250 psi, with ¼" x 6' whip hose, XTR-7 applicator with XHD821-825 tips.</p>

Please contact Amrize Technical Services at 800-428-4511 for further information.

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