

# Product Data Sheet



## GenSplice™ Seam Adhesive

Item Description	Item Number
1-gallon (3.8 liter)	W590010148
<i>*4 per carton</i>	

### Description

GenFlex GenSplice Seam Adhesive is a solvent based contact adhesive designed for splicing GenFlex EPDM membranes and flashings in fully adhered, mechanically attached, and ballasted systems.

### Method of Application

**NOTE:** Ensure both mating surfaces are cleaned, and no moisture is present on the EPDM splicing surfaces.

1. Position the top membrane to overlap the bottom membrane by a minimum of 3" (76 mm). With a grease pencil, mark the bottom membrane ½" (12.7 mm) from the edge of the top membrane. Fold the top membrane back 12" to 15" (305 mm to 375 mm).
2. Using a clean cotton rag saturated with GenFlex Cleaner, thoroughly clean an area on both sheets at least 4" (102 mm) wide where the adhesive will be applied. Remove all visible talc and maintain surfaces free from all moisture, oil, and other contaminants. Discard rags that become dirty and replace them with new rags to assure proper cleaning. Proper cleaning has been achieved when the membrane surface is dark grey in color with no evidence of streaks or discoloration. (NOTE: Additional cleaning will be needed at factory seams). Allow the cleaned membrane to dry completely.
3. Stir GenFlex GenSplice Seam Adhesive thoroughly to achieve a uniform mix with no marbling evident before using. **DO NOT THIN!** Adhesive may be applied with a 3" (76 mm) or 4" (102 mm) wide by ½" (12.7 mm) thick solvent resistant paint brush or medium nap roller (minimum ⅜" (9.5 mm)). For brush application, **DO NOT CUT** brush; use a back-and-forth conventional painting stroke. Apply an even coat of adhesive to each membrane surface to be spliced. Avoid globs and puddles.
4. Allow adhesive to dry until slightly tacky to a dry finger touch. As you are touching the adhesive, push straight down to check for stringing, also push forward on the adhesive at an angle to ensure that the adhesive is ready throughout its thickness. If either motion exposes wet or stinging adhesive when the finger is lifted, then it is not ready for mating and the seam should not be closed. Flash off time will vary depending on ambient air conditions.
5. Once the adhesive has dried properly, roll the top membrane back on to the bottom membrane and allow it to fall freely into place without stretching. Immediately apply pressure to bring the bonding surfaces into complete contact.
6. Using a Teflon coated or hard rubber roller, hand roll the entire seam area to ensure good contact between the membranes, first at a right angle toward the outer edge and then along the length of the splice.

## Method of Application Continued

7. Using a clean rag saturated with GenFlex Cleaner, thoroughly clean an area on both sheets at least 2" (51 mm) each way from the edge of the splice.
8. Apply GenFlex Edge Caulk to ensure a watertight seal. Use a "high profile" bead of caulk along the entire edge of the splice. Ensure bead covers factory seams. **DO NOT SCREED!**

## Application Precautions

- Ensure both mating surfaces are cleaned, and no moisture is present on the splicing surfaces.
- For brush application, **DO NOT CUT** brush; use a back- a n d - f o r t h conventional painting stroke.
- Avoid globs and puddles.
- Do not apply Edge Caulk immediately after making splice. Allow at least 2 hrs. after splicing to apply Edge Caulk.
- All splices shall be caulked before the day's end.

## 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.

## Precautions

- 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, heaters, or any source of ignition during use and until all vapors have been dispersed.
- Do not smoke.
- Close containers after use. Use with adequate ventilation.
- Avoid prolonged breathing of vapors.
- Refer to Safety Data Sheets (SDS) for additional safety information.

## LEED® Information

Post-Consumer Recycled Content: 0%  
 Post Industrial Recycled Content: 0%  
 V.O.C. Content: 615 g/L

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

Typical Properties	
Property	Typical Values
Base	Synthetic Polymers
Color	Black
Solvents	Toluene, Hexane, Xylene
Viscosity	2900-3700 cps, RVF Brookfield, #3 Spindle @ 10 RPM
Weight	7.3 lb (12.5 kg/L) nominal
Specific Gravity	.87 nominal
Flash Point	0 °F (-17.8 °C)

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

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