



Solvent Base Adhesive Data Sheet

Product Handling, Storage, and Installation Guidelines

This roller applied system is designed to bond Phoenix Products PVC roof membranes to approved substrates (polyisocyanurate insulation, gypsum coverboards, plywood, concrete, and masonry surfaces) with minimal cleanup or maintenance. This system is different than “standard” contact cements and thus requires some understanding of the specific adhesive traits and installation guidelines.

Instructions for use:

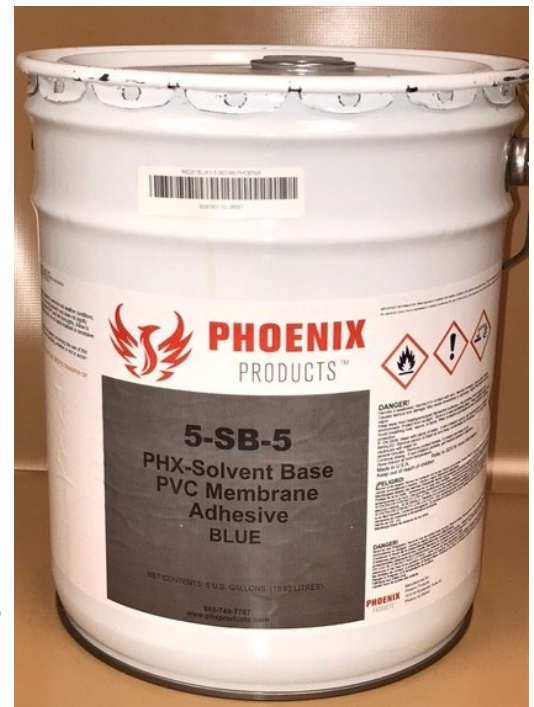
1. Prior to use, stir to agitate contents that may have settled.
2. Roll adhesive on membrane and substrate with a continuous and uniform pattern (avoid globs or puddles). Porous substrates may require an additional pass of adhesive to provide enough deposition on the surface or “layup” to contact bond with the membrane. Best installation practice is to orient membrane adhesive pattern perpendicular to (90 degrees) substrate patterns. Do not apply adhesive to seam areas intended to be hot air welded.
3. Allow both coated surfaces to dry (solvent flashes off) until it does not transfer to finger or knuckle when touched. After drying, this adhesive will **NOT** be tacky to the touch but will contact bond together. In most cases, adhesive will dry within 3-5 minutes. **Maximum open time after adhesive has dried is 30 minutes. As a rule, contact bond the substrates together as quickly as possible after drying.**

The longer the product is “open” the more pressure is required to achieve desired bonds. If left open too long, beyond 30 minutes, simply reapply a new light coat of adhesive to one of the surfaces and follow Step #2. The product will yield full bond strength after approximately 72 hours of curing at 70°F.

4. When the adhesive is dry, roll the membrane into the substrate while avoiding wrinkles. Smooth with hand or spreader (smoothie) to ensure there are no wrinkles or air pockets, then apply as much uniform pressure as possible across the entirety of the bonded surface, this pressure should equal what would be obtained by using a 100 lb. linoleum roller to achieve maximum contact. ANY area that does not receive adequate pressure has potential to yield a false bond and could lead to unacceptable / undesirable bonds. ***IMPORTANT*: AFTER SURFACES HAVE BEEN BONDED AND ROLLED, CHECK THE ADHESION BY PEELING BACK THE EDGE OF MEMBRANE. ADHESIVE SHOULD NOT RELEASE FROM EITHER SURFACE. AN ACCEPTABLE INITIAL BOND WILL EXHIBIT LEGGING/STRINGING OF ADHESIVE FROM BOTH SURFACES.**

Adhesive dry time (or flash-off time) is affected by temperature, humidity, clouds/sun, wind and shade. Understanding how relative humidity and dew point temperature affects the ability of adhesives to properly dry (flash-off) is very important. The dew point is the temperature at which moisture in the air (water vapor) begins to condense into liquid water on a surface. Certain combinations of temperature and humidity may cause condensation (blushing) on the surface of the adhesive. Generally, when the ambient outside air temperature is $\leq 10^{\circ}\text{F}$ of the dew point temperature, condensation may occur on the surface of the applied adhesive. If this occurs, do not mate surfaces and wait until ambient air conditions no longer cause condensation. Condensation on the surface of drying adhesives usually occurs in extreme temperature conditions (i.e. very hot, humid conditions just prior to expected rain or shaded/cloudy cold conditions).

5. Use Acetone or MEK to clean tools and surfaces.





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Installation Recommendations:

1. All surfaces shall be clean, smooth, dry, and free of films, sharp edges, loose and foreign materials, oil and grease.
2. For applications taking place in ambient temperature below 65°F, store adhesive in heated space and move to project area during application. **Pails of adhesive must be kept warm on the jobsite.** Apply product from container while it is still warm. When product in container becomes too cold, the adhesive will become inconsistent and not roll out evenly. If this occurs, swap cold container for warmer one and return cold container to heated area.
3. Adhesive can be applied at ambient temperatures of 40°F and rising, provided containers are kept warm. Utilize power-heated blanket (maximum 100°F) or hot boxes when necessary. Power-heated blankets will only keep warm containers from getting cold and are not intended to heat cold containers. **Never use band heaters or any device capable of heating above 100°F as these devices may cause explosion or personal injury.**

Personal Protective Equipment

Eyes/Face: Safety goggles or glasses

Skin: Protective gloves and impervious clothing.

Cleanup

Acetone or MEK can be used to clean tools and surfaces.

Storage and Handling

Store containers in protected, conditioned space with temperature maintained above 65°F. Do not store containers in areas where temperatures reach 100°F or higher. Contents are flammable. Store in accordance with local, state, provincial and federal regulations. If frozen, return to room temperature and agitate before use.

Precautions

Adhesive is a flammable liquid and vapor. Vapors are heavier than air and may travel along the ground or may be moved by ventilation and ignited by pilot lights, other flames, sparks, heaters, smoking, electrical motors, static discharge or other ignition sources at locations distant from the material handling point and flashback. Keep away from open flame. Use with adequate ventilation. Avoid inhalation of vapors. Harmful or fatal if swallowed. May cause eye irritation. Keep out of reach of children. Review Safety Data Sheet for complete safety information prior to use. Dispose according to local codes and laws. Read safety precautions and warnings on container label. PPE gloves and goggles must be used while handling material.

For industrial professional use only.



Typical Properties and Characteristics

Color: Blue

Weight: 41 lbs./container

Odor: Acetone

Base: Synthetic Rubber and Resin

Coverage Rate: Coverage rate is net 60 sq.ft./gal or 300 sq.ft./ 5 gal pail. Coverage on each surface before bonding is 120 sq.ft./gal. Porous substrates will require more adhesive.

Dry Time: 3-5 minutes**

Adhesion: Excellent

Flammability: Flammable when wet, Non-Flammable when dry.

Shelf Life: 12 months (unopened containers)

VOC 196 g/l (EPA Method 24)

Prop 65 "WARNING! This product can expose you to chemicals which are known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov."

*Approximate coverage, rough or porous surfaces will require more adhesive

** Or longer depending on climate conditions

Disclaimer

The statements provided concerning the material shown are intended as a guide for material usage and are believed to be true and accurate at the time of printing. No statement made by anyone may supersede this information, except when done in writing by Phoenix Products. Since the manner of use is beyond our control, Phoenix Products does not authorize anyone to make any warranty of merchantability or fitness for any particular purpose or any other warranty, guarantee or representation, expressed or implied, concerning this material. Buyer and user accept the product under these conditions and assume the risk of any failure, any injury of person or property (including that of user), loss or liability resulting from the handling, storage or use of the product whether or not it is handled, stored or used in accordance with the directions or specifications. Phoenix Products must be notified in writing of any claims and be given the opportunity to inspect the alleged failure before repairs are made.

Trouble Shooting Problems

Problem

Poor bond strength

Possible cause

- * Bond is still green
- * Solvent trapped in the bond line
- * Substrate contamination
- * Insufficient adhesive applied
- * Lack of pressure applied
- * Insufficient open time

- * Open time exceeded

- * Surface is too cold or damp

- * Incompatible substrate
- * Adhesive is too cold

Remedy

- * Full bond strength will develop in 72 hours
- * Ensure solvent has flashed off prior to bonding
- * Ensure substrate surfaces are clean and dry
- * Evenly apply 100% coverage to both surfaces
- * Apply consistent uniform pressure to surface
- * Allow adhesive film to dry to the touch. Colder temperatures or humid environments may require longer open times.
- * If the open time is exceeded, reapply adhesive to both surfaces to reactivate.
- * Surface should be dry with a temperature of 40°F and rising. Ideal surface temperature is between 65° - 100°F.
- * Refer to manufacturer's Approved substrates
- * Keep container stored above 65°F for best performance.

Please contact Technical Support for further assistance.