



Thermoplastic Single Ply and Multi-Ply Roofing Systems

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FLEX TPO PLUS BONDING ADHESIVE **TECHNICAL DATA SHEET**

GENERAL:

Flex TPO Plus Bonding Adhesive is a high strength solvent-based contact adhesive that allows bonding of Flex TPO Plus membrane to various porous and non-porous substrates.

TYPICAL FLEX TPO PLUS PROPERTIES AND CHARACTERISTICS: *

Base:	Synthetic Rubber
Color:	Yellow
Solids:	20%
Flash Point:	-4°F (-20°C) Closed Cup
Brookfield Viscosity:	2600 Centipoises
Avg. Net Weight:	7.1 lbs/gal (3.2 Kg)
Packaging:	5 Gal Pail
Shelf Life:	1 Year

CAUTIONS AND WARNINGS:

1. Review the applicable Material Safety Data Sheet for complete safety information prior to use.
2. Flex TPO Plus Bonding Adhesive is **EXTREMELY FLAMMABLE**- It contains solvents that are dangerous fire and explosion hazards when exposed to heat, flame or sparks. Do not smoke while applying. Do not use in a confined or unventilated area. Vapors are heavier than air and may travel along 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 material handling point and flashback. All containers should be grounded when material is transferred from one container to another. A red caution label is required when shipping. A fire extinguisher should be available. In case of fire, use water spray, foam, dry chemical or carbon dioxide. Do not use a solid stream of water because it can scatter and spread the fire.
3. Avoid breathing vapors. Keep container closed when not in use. Use with adequate ventilation. If inhaled, remove to fresh air. If not breathing, perform artificial respiration. If breathing is difficult, give oxygen. Call a physician immediately. During application, efforts must be made to prevent fumes from entering the building via air ventilation ducts. Do not place open containers or mix adhesive near fresh air intake units. When possible, shut down or seal off the closest units.

4. If swallowed, **DO NOT INDUCE VOMITING**. Call a physician immediately.
5. Avoid contact with eyes. Safety glasses or goggles are recommended. If splashed in eyes, flush eyes with plenty of clean water for at least 15 minutes. Contact a physician immediately.
6. Avoid contact with skin. Wash hands thoroughly after handling. In case of contact with skin, thoroughly wash affected area with soap and water. Contact physician if irritation persists.

Note: Solvent resistant gloves are recommended to be worn when using this product to protect hands from irritating ingredients.

7. Do not thin Flex TPO Plus Bonding Adhesive. Thinning will affect performance. Excessively thick or gelled material should be discarded.
8. Job site storage in excess of 90°F (32°C) may affect product shelf life. Should the Flex TPO Plus Bonding Adhesive be stored at temperatures lower than 60°F (15°C), restore to room temperature prior to use.
9. Opened containers of Flex TPO Plus Bonding Adhesive should be used within 48 Hours. Adhesives will begin to thicken after this point, making it difficult and eventually impossible, to control applied thickness. In hot weather, do not leave sealed containers on roof for prolonged periods of time. In cold weather, keep material at room temperature until ready to use. Stir adhesive occasionally while using.
10. **Adhesive must be allowed to dry thoroughly.** If membrane is mated with the substrate prior to the adhesive being dry, blistering will occur and not subside over time.

11. KEEP OUT OF THE REACH OF CHILDREN.

MIXING:

Stir thoroughly until all settled pigments are dispersed and the adhesive is uniform in color. Minimum 5 minutes stirring is recommended.

COVERAGE RATES:

Flex TPO Plus Bonding Adhesive- 60 ft² (5.6m²) per gallon finished surface. Coverage rates are average and may vary due to conditions on the job site. Porous surfaces and substrates may require more bonding adhesive than the typical coverage rate.

APPLICATION: **

1. The surface, on or against which adhesive is to be applied, shall be clean, smooth, dry, free of fins, sharp edges, loose and foreign materials, oil and grease. Depressions greater than ¼” (6 mm) should be feathered, using epoxy, mortar or other approved patching material. All sharp projections shall be removed by sweeping, blowing or vacuum cleaning.

2. After thorough stirring (minimum 5 minutes), apply Flex TPO Plus Bonding Adhesive to substrate and membrane using a 9” (23 mm) medium nap roller. Application shall be continuous and uniform avoiding globs or puddles. An open time of 5 to 50 minutes, based on drying conditions are recommended before assembly. Flex TPO Plus Bonding Adhesive must be allowed to dry until it does not string or stick to dry finger touch. Any coated area which has been exposed to rain should be allowed to dry and then recoated. **Do not apply adhesive to splice areas to be hot air welded.**
3. Roll the membrane onto the adhesive coated substrate while avoiding wrinkles. Immediately brush down the bonded portion of the sheet with a soft bristle push broom or a clean dry roller applicator to achieve maximum contact.

This product is approved for use by Flex authorized applicators only and is for use in Flex TPO Plus Membrane roofing installations.

- * General properties. Typical properties and characteristics are based on samples tested and are not guaranteed for all samples of this product.
- ** REVIEW CURRENT FLEX SPECIFICATIONS AND DETAILS FOR SPECIFIC APPLICATION REQUIREMENTS.