

RPI ROYAL EDGE LOW VOC BONDING ADHESIVE (Solvent Based) TECHNICAL DATA SHEET

PRODUCT DATA			
SOLIDS: 23%	COLOR: Yellow	SPECIFIC GRAVITY: 0.899 %	WEIGHT: 7.48 lb/gal
CONTENT: 5.13 lb/gal	FLASH POINT: 2° F (-19° C)	BASE: Polychloroprene	
SOLVENTS: Acetone, Toluene, Methyl Acetate, Tert Butyl Acetate			
VOC CONTENT: VOC Rule 1168 for OTC: 215 gm/l VOC 52 gm/l			
VISCOCITY: 2300-2700 Centipoises, R.V.F. Brookfield #3 Spindle			



DESCRIPTION:

RPI Royal Edge Low VOC Bonding Adhesive is a solvent based contact adhesive formulated to adhere RPI Royal Edge and Re-Flex EPDM, and Re-Flex TPO membranes to metal, brick or block masonry, rooftop flashings, insulation, recover, barrier boards, and other acceptable substrates.

APPLICATION INSTRUCTIONS: VERY IMPORTANT!!

This product must be a minimum of 60° F before attempting to mix or stir. RPI Low VOC Bonding Adhesive stored or allowed to cool below 60° F will not properly blend. Coverage rates and product performance will be compromised. Allow ample time for the temperature of the adhesive to rise to 60° F or higher before attempting to stir or mix the adhesive. Mix or stir each pail a minimum of 4 minutes to completely blend contents.

1. All surfaces to be adhered should be thoroughly dry, clean, and free of dust and loose debris. Membranes and substrates should be free of oil, grease, and other contaminants. If necessary, sweep the substrate and membrane with a push broom prior to applying Bonding Adhesive.
2. Thoroughly stir the adhesive before and during use. The color should be consistent, without marbling, with no solids remaining on the bottom. **Do not use electric drills to mix the adhesive.**
3. RPI Low VOC Solvent Based Bonding Adhesive is a contact adhesive and must “flash-off” before the membrane and substrate surface are mated together. To ensure the adhesive flash-off time is approximately the same, apply the Bonding Adhesive to both surfaces in one application. Bonding Adhesive can be applied using a solvent resistant paint roller, brush, or a spray rig designed to apply adhesives. If sprayed, it is recommended to roll the adhesive with a solvent resistant roller.
4. Position the membrane into place and allow adequate time for the membrane to acclimate to current conditions.
5. Fold the membrane onto itself exposing the substrate and bottom of the membrane. Apply the adhesive in a uniform and consistent coat; avoiding globs and puddles. **DO NOT APPLY BONDING ADHESIVE OVER AREAS WHICH WILL LATER BE USED TO CREATE FIELD OR FLASHING SEAMS.**
6. Allow the adhesive to flash-off and become tacky. Using the finger-push method, check the adhesive by applying pressure with a finger to the adhesive while pushing across the adhesive. If the finger slides, the adhesive is still wet and more flash-off time should be allowed. Flash-off time is dependent upon ambient weather conditions. Do not allow the surfaces to stay open longer than necessary.

After adequate flash-off time, roll the coated membrane onto the coated substrate by fluffing air under the coated membrane and allowing the membrane to float (roll) onto the substrate. Start in the middle of the membrane and mate the surfaces together while working towards the roll ends. After the adhered membrane is in place, ensure complete contact by mating the surfaces together with a push broom using heavy pressure.

PHYSICAL CHARACTERISTICS:

1. Excellent resistance to aging.
2. Good resistance to degradation from heat, cold, and water.
3. Excellent strength from application to complete cure.

COVERAGE RATES:

A coverage rate of 60 sq. ft. of finished roof, per gallon, should be expected. Coverage rates will vary depending upon the type of substrate, substrate surface, and ambient temperature. Some substrates are more porous and will absorb more adhesive resulting in a lower coverage rate. Other substrates may have smooth dense facers resulting in a higher coverage rate. Coverage rates are based on applications using a 3/8 inch solvent based paint roller cover.

PACKAGEING:

Available in:

1 gallon pails	4-pails per carton
5 gallon pails	45 pails per pallet

PRECAUTIONARY DATA:

1. **Extremely flammable.** Vapors may ignite explosively under certain conditions. Do not smoke when using. Keep away from open flames, sparks, and other sources of ignition. Provide adequate ventilation. Close containers after use.
2. Avoid contact with skin and eyes. Protective eyewear along with OSHA approved gloves should be worn.
3. Do not thin.
4. When using in cold temperatures, keep adhesive at room temperature before applying.
5. Keep out of reach of children.
6. Acetone is recommended for the clean-up of wet Bonding Adhesive.
7. Always cover adhesive when not in use. Do not allow adhesive to "skin over", or sit open for extended periods. Opened containers can be sealed and reopened depending upon storage conditions and previous open time. Re-use after one week is not recommended.
8. For professional use only.
9. Use only in well ventilated areas.
10. Refer to RPI Application Specifications, Product Data Sheets, MSDS data, and Precautionary Data prior to application of RPI Bonding Adhesive.

SHELF LIFE:

1. When stored in original unopened containers at temperatures between 60° F (15.6°C) and 80° F (26.7°C), a shelf life of 12 months can be expected.
2. The expected shelf life can be shortened if product is stored in temperatures exceeding recommended storage levels.

RECOMMENDED STORAGE:

1. Store in original unopened containers at temperatures between 60° F and 80° F.
2. When stored in cooler temperatures, allow material to warm to room temperature before using.
3. Do not allow material to be stored in direct sunlight.
4. Rotate stock. Do not use product past 12 month shelf life.



See UL Roofing Materials and Systems Directory
R10073

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