

## RPI Re-Flex TPO Bonding Adhesive Data Sheet

SOLVENT BASED

| PRODUCT DATA                                                            |                                     |
|-------------------------------------------------------------------------|-------------------------------------|
| SOLIDS: 22.2%                                                           | BASE: Polychloroprene               |
| COLOR: Amber                                                            | SOLVENTS: Naphtha, Toluene, Acetone |
| FLASH POINT: 0°F (-18°C)                                                | WEIGHT: 6.87 lb/gal                 |
| SPECIFIC GRAVITY: .825%                                                 | V.O.C. CONTENT: 4.05 lb/gal         |
| VISCOCITY: 2300-2700 Centipoises, R.V.F. Brookfield #3 Spindle @ 10 rpm |                                     |

### **DESCRIPTION:**

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

### **APPLICATION INSTRUCTIONS:**

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 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. Re-Flex 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 the adhesive is spray applied, it is recommended to roll in the adhesive with a solvent resistant roller to ensure a consistent and properly adhered adhesive coating.
4. Position the membrane into place and allow adequate time for the membrane to acclimate to current conditions. 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 RE-FLEX TPO BONDING ADHESIVE OVER AREAS WHICH WILL LATER BE USED TO CREATE FIELD SEAMS.**

### **FIELD OR FLASHING SEAMS.**

5. 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.
6. After adequate flash-off time, mate the coated Re-Flex TPO membrane onto the coated substrate by 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 stiff 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 45-60 sq. ft. of finished roof, per gallon, should be expected. Coverage rates will vary depending upon the type of substrate and substrate surface. Some substrates are more porous and will absorb more adhesive resulting in a lower coverage rate. Other substrates have smooth dense facers resulting in a higher coverage rate. Coverage rates are based on applications using a solvent based paint roller and are dependent upon ambient temperatures.

### **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. 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.
7. For professional use only. Use only in well ventilated areas.

Refer to RPI Application Specifications, Product Data Sheets, MSDS data, and Precautionary Data, prior to application of Re-Flex TPO 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.

Information stated on this Roofing Products International, Inc. Data Sheet is intended to provide basic guidance as to storage, application, coverage, shipping, and other product data. Information is subject to change without notice. For more information regarding this product, refer to RPI MSDS, and the RPI Specification Manual. As neither Roofing Products International, Inc. nor its representatives practice structural engineering or architecture, RPI disclaims any responsibility and offers no opinion as to the structural soundness of any structure on which its products may be applied. The building owner should obtain the services of a competent structural engineer before proceeding. RPI accepts no responsibility for any structural failure or resultant damages. No Roofing Products International, Inc. representative is authorized to vary this disclaimer.



57460 Dewitt St. Elkhart, IN 46517

[www.roofingproductsint.com](http://www.roofingproductsint.com)

Sales/Technical 1-800-628-2957 Fax: 574-294-3450