KEE / PVC Bonding Adhesive

TECHNICAL PRODUCT INFORMATION

STRONGHOLD™

StrongHold KEE / PVC Bonding Adhesive is a solvent based contact adhesive, specially formulated for adhering KEE and PVC single ply membranes in StrongHold roofing systems. StrongHold KEE / PVC Bonding Adhesive can be used to adhere StrongHold KEE and PVC to a variety of common roofing substrates, including wood, metal flashings, brick or masonry, and roofing insulation boards. StrongHold KEE / PVC Bonding Adhesive can be applied with rollers, spray rigs, or commercial adhesive dispensers.

FEATURES & BENEFITS

StrongHold KEE / PVC Bonding Adhesive also provides the following features and benefits:

- Compatible with the following substrates: wood, metal flashings, brick or block masonry, insulation, coverboards
- High-strength adhesive with excellent long term wind uplift performance
- Approved for use and spreadable down to 25°F (-3.9°C), making it possible to extend the roofing season in cold climate regions
- Approved for use in all VOC regulated markets

For any insulation or substrate not on the list, please contact BITEC Technical Services.

PACKAGING

Packaging: 5-gallon pails

Quantity per pallet: 45

Pallets per truckload (typical): 18

APPLICATION

The surface to be adhered must be clean, dry, and sound, as well as free of dirt, moisture, oils, algae, or other contaminants that may interfere with proper adhesion. Carefully remove any loose material from the surface with a wire brush or scraper. Grease and oil should also be removed with environmentally safe solvents or an appropriate cleaner. In most cases, a high-pressure water blast will be sufficient to prepare the surface. As with all adhesives, proper preparation is key to yielding optimal results.

Product application should be suspended immediately and our technical service personnel contacted if the results being obtained are less than desirable.

StrongHold KEE / PVC Bonding Adhesive is designed to be applied with a solvent resistant paint roller, spray rig designed to apply adhesives, or commercially available adhesive dispensers. If the adhesive is spray applied, it is recommended to roll the adhesive with a solvent resistant roller.

Before and during use, thoroughly stir the adhesive - do NOT use an electric drill. Do not thin the adhesive as it will affect adhesive performance. After stirring, the adhesive should be consistent in color with no solids remaining on the bottom.

StrongHold KEE / PVC Bonding Adhesive is a contact adhesive that needs to “flash-off” before the membrane and substrate surfaces are joined together. To ensure the flash-off time is approximately the same, apply the adhesive to both surfaces in one application.

Position the membrane into place and allow time for the membrane to relax. Using a “barn door” folding method, fold the membrane onto itself, exposing the substrate and bottom of the membrane. Apply the adhesive in a uniform and consistent coat to both the substrate and the underside of the KEE or PVC waterproofing membrane, avoiding puddles and light areas. Make sure not to apply the adhesive over areas which will be used to create field or flashing seams.

Allow the adhesive to fully 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.

NOTE: The adhesive must be completely dry before mating the membrane with the substrate. Covering wet adhesive and trapping solvent between the membrane and the substrate may result in blistering and other surface defects.

After adequate flash-off time, roll the membrane onto the adhesive coated substrate and immediately brush the membrane with a stiff bristle broom to ensure maximum contact.

Specific application methods may vary, depending on the roof system being installed, as well as the substrate and type of insulation being adhered. Please refer to the BITEC Roofing Products Installer’s Guide for detailed application guidelines.

As with any roofing project, good roofing practices should always be followed.

STORAGE & HANDLING

Use only with adequate ventilation. Avoid formation of dust and aerosols. Take note of emission threshold. Use solvent-proof equipment. Handle with care. Keep eye wash bottle available in working location. Keep out of reach of children. Avoid release to the environment. Take precautionary measures against static discharge and always use explosion-

proof equipment. Do not freeze. Do not store together with other oxidizing or self-igniting products.

Store materials locked up and in a well-ventilated, dry, and temperature conditioned location. Keep containers tightly closed to avoid contamination. When stored in the original, unopened container between 60°F (15.6°C) and 80°F (26.7°C), the recommended shelf life is 12 months from the date of manufacture. The product life can be significantly shortened when stored in temperatures exceeding the recommended storage levels.

PRECAUTIONS

Do not use StrongHold KEE / PVC Bonding Adhesive in a confined space or around heat, flames, or sparks. Prevent fumes from entering building via air ventilation ducts. Avoid breathing adhesive vapors. Wear safety glasses or goggles to prevent contact with the eyes. Wear gloves that meet ANSI / ISEA 105-2005 to protect when applying adhesive. Keep out of reach of children.

StrongHold KEE / PVC Bonding Adhesive is not for use on EPDM or TPO membranes and is not to be applied direct to expanded or extruded polystyrene insulation. Never apply to damp or wet surfaces. Do not apply when ambient or surface temperatures fall below 25°F (-3.8°C).

Safety first! Read all label information, SDS, and precautions before using. For safety information on our products, please visit www.bitec.com.

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Technical Schedule	
Appearance	Tan
Coverage Rate (Finished surface)	45-60 ft^2/gal*
Shelf Life	12 months
Weight	7.1 lbs/gal
Viscosity (#2 @ 20)	500-2,000 cps
Solids by Weight	24% ± 3
VOC	<200 g/L
Application	Spray, brush, or roller
Open Time	10-30 min
Storage Temperature	Between 60°F (15.6°C) and 80°F (26.7°C)
Working Temperature Range	25°F (-3.8°C) and rising, up to 90°F (32.2°C)

*A coverage rate of 45 to 60 ft^2 of finished roof (both surfaces) per gallon should be expected but coverage rates will vary depending on the substrate and the nature of the substrate's surface. More porous substrates will absorb more adhesive, resulting in a lower coverage rate. Substrates with a smooth dense facer will result in higher coverage rates. All printed rates are based on applications using a 3/8" solvent-based paint roller cover.

All information is given in good faith but normal tolerances of manufacture and testing will apply. BITEC reserves the right to improve and change its products at any time without prior notice or advice. The use of BITEC products is determined by local conditions and individual requirements of each contract. In consideration of the many factors involved, BITEC cannot be held responsible for the improper application of its products and for conditions beyond its control. All claims filed against BITEC warranties will be subject to the provisions set forth at the date of the warranty issuance, and any addendum thereto. Under no circumstances will BITEC be held liable for any damage, whether personal injury or property damage, which

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