

# Pump Grade Adhesive

## TECHNICAL PRODUCT INFORMATION



**STRONGHOLD™**

StrongHold Pump Grade Adhesive is a dual component, nearly VOC free, all-purpose, low rise polyurethane foam adhesive with essentially no solvents that sets fast, literally within minutes after application. Designed for use as an adhesive for bonding approved roof insulations to a building's structural roof deck, base sheets, other insulation boards, and smooth or gravel surface built-up roof surfaces, StrongHold Pump Grade Adhesive offers quick and easy application, resulting in significant labor savings for the contractor. StrongHold Pump Grade Adhesive is dispensed by specialized low pressure pump cart dispensers, which equally mix both parts to provide a quality, consistent application every time.

### FEATURES & BENEFITS

StrongHold Pump Grade Adhesive also provides the following features and benefits:

- Compatible with the following substrates: HD wood fiber, polyisocyanurate, perlite (upon approval), polystyrene, gypsum cover board, HD PUR cover board, asphaltic cover boards, concrete, gypsum roof deck, cementitious wood fiber, wood, steel, mineral wool,, lightweight insulating concrete, modified bitumen membranes and base sheets (sanded or granule surfaced), approved insulations in multi-layer applications, and smooth or gravel surface built-up roofs (re-roof applications)
- Eliminating or reducing mechanical fasteners on the roof eliminates thermal bridging and maximizes the potential R-value of the roof assembly
- Meets OTC and SCAQMD regulations due to being essentially VOC free
- Suitable for use with XPS and EPS insulations

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

### PACKAGING

StrongHold Pump Grade Adhesive is available in multiple sizes for different applications.

5-gal boxes: 18 sets per pallet

15-gal drums: 4 sets per pallet

50-gal drums: 2 sets per pallet

NOTE: 5-gal box sets include 5 mixing tips per set. No mixing tips are included with the 15-gal or 50-gal drum sets. Mixing tips are available for individual sale.

### 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 the optimal results.

The following equipment has been tested with StrongHold Pump Grade Adhesive and is recommended for use: Millennium Cyclone 1 Low Pressure Pump Cart, Millennium Cyclone 5/15 Low Pressure Pump Cart, Graco E-10 Reactor, Graco Predator, Adhesives Systems Technology GMP-075, and Adhesives Systems Technology PCH-GMP-500.

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

For best results, only apply StrongHold Pump Grade Adhesive when both the ambient and substrate surface temperatures are at 25°F (-4°C) and rising (see Storage & Handling for information on proper storage before use). If exposed to cooler temperatures for an extended period of time, StrongHold Pump Grade Adhesive must be brought back up to the recommended temperature before use.

Do not apply to wet or improperly prepared surfaces. It is not recommended for use with insulation boards larger than 4' x 4'. Avoid use of warped or curled insulation boards - all insulation boards must lay flat on the roof surface for proper installation.

StrongHold Pump Grade Adhesive is designed for use as an adhesive for bonding approved roof insulations to a building's structural roof deck, base sheets, other insulation boards, and smooth or gravel surface built-up roof surfaces

Open the box utilizing the convenient tear strip and remove the plastic bladder from the box utilizing the easy-lift handle. Remove the cap on the plastic bladder and replace by attaching the quick connect fitting supplied in each box. (Connect the black fitting to the Part A bladder and the gray fitting to the Part B bladder.) Place the plastic bladder on the approved pump cart. Make sure that the bladder labeled "Part A" is placed in the tray labeled "Part 1" and that the bladder labeled "Part B" is placed in the tray labeled "Part B". For instructions on loading drum sets, contact BITEC Technical Services.

When using the Millennium Cyclone low pressure pump cart, connect the black Part A fitting to the black feed hose fitting. Connect the gray Part B fitting to the gray feed hose fitting. Operate the pump according to the manufacturer's

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instructions.

Utilize the empty cardboard bladder container to capture adhesive pre-dispense or recycle empty cardboard containers.

Apply StrongHold Pump Grade Adhesive directly to the substrate using a ribbon pattern. Space the beads 12" (30cm) on center to achieve proper coverage rates for standard insulation attachment. Note: Bead spacing requirements may vary depending on job and warranty requirements.

Once StrongHold Pump Grade Adhesive is applied, allow the foam to begin rising and place the insulation board into the adhesive before the adhesive has skinned over. Eliminate uneven surfaces to ensure positive contact between the insulation boards, adhesive, and substrates.

Plastic bladders are designed for easy visibility to ensure the adhesive maintains a 1:1 ratio. If material is not consumed at a 1:1 ratio stop application and check for potential blockage in hose or dispensing manifold.

Unused material can be applied at a later date. Properly clean and grease the dispensing wand and pump unit according to the manufacturer's recommendations.

StrongHold Pump Grade Adhesive provided in 15 or 50 gallon drum sets can be used with approved pump systems. The adhesives should be placed on a drum roller or agitated prior to use.

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

StrongHold Pump Grade Adhesive should be stored at approximately 70°F (21.1°C) for at least 48 hours prior to use. Storing below the recommended temperature range can have a negative impact on product performance, including a reduction in coverage rate, delayed or extended reaction and set up times, and/or the proportions of the components as they are mixed. Keep from freezing or exposing to freezing temperatures. If exposed to cooler temperatures for an extended period of time, bring the temperature of the material up to 70°F (21°C) prior to use. Never store in direct sunlight or in temperatures above 95°F (35°C).

Store materials locked up and in a well-ventilated, dry, and temperature conditioned location. Keep containers tightly closed with the valve side up. When stored in the original,

unopened containers between 45°F (7°C) and 95°F (35°C), the recommended shelf life is 12 months from the date of manufacture.

## PRECAUTIONS

StrongHold Pump Grade Adhesive should not be applied to wet or damp surfaces. Not recommended for use with insulation boards greater than 4' x 4' (1.2 m x 1.2 m). Never use warped or curled insulation boards. All insulation boards must lay flat on the roof surface. Never apply when temperatures are below 25°F (-4°C).

Safety first! Read all label information, SDS, and precautions before using. For safety information on our products, please visit [www.bitec.com](http://www.bitec.com).

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Technical Schedule	
Combined Appearance	White to light amber
Coverage Rate - 5-gal kit	2,500-3,000 ft <sup>2</sup> (232-279 m <sup>2</sup> )
Coverage Rate - 15-gal kit	7,500-9,000 ft <sup>2</sup> (697-836 m <sup>2</sup> )
Coverage Rate - 50-gal kit	25,000-30,000 ft <sup>2</sup> (2,323-2,787 m <sup>2</sup> )
Shelf Life	12 months
Ambient Application Temperature	25°F (-4°C) and rising
Adhesive Application Temperature	70°F (21°C)
Storage Temperature	45°F (7°C) to 95°F (35°C)

\*Coverage rate estimates indicate total square feet of insulation attachment per kit. Rates are based on an application pattern of 4 1/2-3/4" (1.3-1.9 cm) ribbons spaced 12" (30 cm) on center per 4' x 4' (1.2 x 1.2 m) insulation board. NOTE: A 1/2-3/4" (1.3-1.9 cm) wide uncured adhesive bead will product a 2-3" wide cured adhesive bead that will rise approximately 3/4-1" (1.9-2.5 cm) above the substrate. Coverage rates may be lower when used over irregular surfaces or porous surfaces.

*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 occur during or after the application of any BITEC products.*

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