

TPO / EPDM Spray Adhesive

TECHNICAL PRODUCT INFORMATION



STRONGHOLD™

StrongHold TPO / EPDM Spray Adhesive is a fast-drying, sprayable adhesive for adhering TPO and EPDM single ply membranes in StrongHold roofing systems. StrongHold TPO / EPDM Spray Adhesive can be used to adhere TPO and EPDM to a variety of common roofing substrates, including wood, metal, and masonry.

FEATURES & BENEFITS

StrongHold TPO / EPDM Spray Adhesive also provides the following features and benefits:

- Compatible with the following substrates: wood (including OSB and plywood), metal flashings, masonry, polyisocyanurate roofing insulation (including HD), DensDeck Prime®, SECUROCK®, DEXcell®, and residual asphalt
- High-strength adhesive with a quick bonding time
- Fast application times yield labor savings for the contractor
- Low VOC content means it can be used in OTC regulated markets

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

PACKAGING

Packaging: 45 lb gross weight canister (38 lbs net weight)

Quantity per pallet: 36

Pallets per truckload (typical): 18-22

NOTE: *The applicator spray gun, tip, and hose are sold separately with multiple options available to suit specific job requirements.*

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.

Shake the StrongHold EPDM / TPO Spray Adhesive canister for 30 seconds prior to use. Attach the spray gun to the hose and then attach the hose to the adhesive canister. Open the valve on the canister and check connecting fittings for leaks. Once the valve has been turned on, do not turn the valve off until the adhesive canister is completely empty or proper

cleaning is performed (see the following instructions).

StrongHold TPO / EPDM Spray Adhesive can be applied at an ambient temperature of 25°F and above. Adhesive canister temperature must be at least 70°F prior to use for the product to spray properly. Utilize a warming blanket or hot box when necessary. The substrate must be clean, dry, and free of debris and contaminants.

Adjust the spray pattern/fan by slowly adjusting trigger lock to the desired pattern and locking when not in use. Apply adhesive with proper overlap to ensure adequate adhesive coverage.

Apply StrongHold TPO Spray Adhesive in an even coat to the deck substrate and membrane, keeping the spray tip approximately 12" (30.5 cm) away and perpendicular to the surface during spray. Avoid high thickness buildup.

For applications taking place in ambient temperature below 70°F, store adhesive canister in heated space and move to the project area during application. Adhesive canisters must be kept warm on the jobsite. Dispense the adhesive from canister while it is still warm. Adhesive will begin to spit rather than spray when the adhesive in the canister is too cold. If this occurs, swap cold canister for warmer one and return the cold canister to a heated area. Before changing the canister, close the valve on the canister and depressurize the hose. Remove the hose and attach to the new canister. Open the valve and do a test spray.

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. Limit application to surfaces that will be covered with membrane the same day.

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 TPO or EPDM 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.

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

TPO / EPDM Spray Adhesive

TECHNICAL PRODUCT INFORMATION



STRONGHOLD™

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.

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

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 70°F (21.1°C) and 100°F (37.8°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. When stored in cooler temperatures, allow the material to warm to room temperature before using. Do not allow StrongHold TPO / EPDM Spray Adhesive to be stored in direct sunlight. Ensure stock is properly rotated and do not use the adhesive past the 12 month shelf life.

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 TPO / EPDM Spray Adhesive is not for use on PVC or KEE membranes and is not to be applied direct to expanded or extruded polystyrene insulation. Never apply to damp or wet surfaces, including primers. Allow solvent based primers to completely dry before applying the adhesive. Do not apply when ambient or surface temperatures fall below 25°F (-3.8°C).

TPO / EPDM Spray Adhesive

TECHNICAL PRODUCT INFORMATION



STRONGHOLD™

Technical Schedule	
Appearance	Pale green
Coverage Rate (Finished surface)	1000 ft ² /canister*
Shelf Life	12 months
VOC	<250 g/L
Application	Spray
Storage Temperature	Between 70°F (21.1°C) and 100°F (37.8°C)
Working Temperature Range	25°F (-3.8°C) and rising, up to 100°F (37.8°C)

*This coverage rate is for the finished roof (both surfaces) when applying to smooth surfaced membranes 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. A rate of 750 ft²/canister should be followed for application of flashing membrane to vertical substrates.

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.

Copyright BITEC, Inc.
Revision Date 01/2026



BITEC, Inc.
PO Box 497
#2 Industrial Park Dr
Morrilton, AR 72110
Phone: (800) 535-8597
Fax: (501) 354-3019
www.bitec.com

BITEC®

WHEN QUALITY MATTERS™