

Sure-Weld® TPO

Bonding Adhesive



Overview

Carlisle's Sure-Weld TPO Bonding Adhesive is a high-strength solvent-based contact adhesive that allows bonding of TPO membrane to various porous and non-porous substrates.

Features and Benefits

- » Solvent-based bonding adhesive that allows for quick drying
- » Can be roller-applied with medium nap roller
- » Provides excellent adhesion to various substrates

Coverage Rate

60 ft² (5.6 m²) per gallon finished surface. Coverage rates are average and may vary due to conditions on the jobsite. Porous surfaces and substrates may require more bonding adhesive than the typical coverage rate.

Mixing

Stir thoroughly until all settled pigments are dispersed and the adhesive is uniform in color. Minimum 5 minutes stirring is recommended.

Application

1. The surface, on or against which adhesive is to be applied, shall be clean, smooth, dry, free of fins, sharp edges, loose and foreign materials, oil and grease. Depressions greater than ¼" (6 mm) should be feathered, using epoxy, mortar or other approved patching material. All sharp projections shall be removed by sweeping, blowing or vacuum cleaning.

2. After thorough stirring (minimum 5 minutes), apply TPO Bonding Adhesive to substrate and membrane using a 9" (23 mm) medium nap roller. Application shall be continuous and uniform, avoiding globs or puddles. An open time of 5 to 50 minutes, based on drying conditions is recommended before assembly. TPO Bonding Adhesive must be allowed to dry until it does not string or stick to a dry finger touch. Any coated area which has been exposed to rain should be allowed to dry and then recoated. Do not apply adhesive to splice areas to be hot-air welded.
3. Roll the membrane onto the adhesive-coated substrate while avoiding wrinkles. Immediately brush down the bonded portion of the sheet with a soft-bristle push broom or a 150 lb. segmented roller to achieve a maximum contact.

Review current Carlisle specifications and details for specific application requirements.

Precautions

- » Review the applicable Safety Data Sheet for complete safety information prior to use.
- » TPO Bonding Adhesive is EXTREMELY FLAMMABLE – it contains solvents that are dangerous fire and explosion hazards when exposed to heat, flame or sparks. Do not smoke while applying. Do not use in a confined or unventilated area. Vapors are heavier than air and may travel along ground or may be moved by ventilation and ignited by pilot lights, other flames, sparks, heaters, smoking, electrical motors, static discharge or other ignition sources at locations distant from material handling point and flashback. All containers should be grounded when material is transferred from one container to another. A red caution label is required when shipping. A fire extinguisher should be available. In case of fire, use water spray, foam, dry chemical or carbon dioxide. Do not use a solid stream of water because it can scatter and spread the fire.
- » Avoid breathing vapors. Keep container closed when not in use. Use with adequate ventilation. If inhaled, remove to fresh air. If not breathing, perform artificial respiration. If breathing is difficult, give oxygen. Call a physician immediately. During application, efforts must be made to prevent fumes from entering the building via air ventilation ducts. Do not place open containers or mix adhesive near fresh air intake units. When possible, shut down or seal off the closest units.
- » If swallowed, DO NOT INDUCE VOMITING. Call a physician immediately.
- » Avoid contact with eyes. Safety glasses or goggles are recommended. If splashed in eyes, immediately flush eyes with plenty of clean water for at least 15 minutes. Contact a physician immediately.

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- » Avoid contact with skin. Wash hands thoroughly after handling. In case of contact with skin, thoroughly wash affected area with soap and water. Contact physician if irritation persists.
 Note: Permeation-resistant gloves (that meet ANSI/ISEA 105-2005) are recommended to be worn when using this product to protect hands from irritating ingredients.
- » Do not thin TPO Bonding Adhesive. Thinning will affect performance. Excessively thick or gelled material should be discarded.
- » Jobsite storage in excess of 90°F (32°C) may affect product shelf life. Should the TPO Bonding Adhesive be stored at temperatures lower than 60°F (15°C), restore to room temperature prior to use.
- » Opened containers of TPO Bonding Adhesive should be used within 48 hours. Adhesives will begin to thicken after this point, making it difficult, and eventually impossible, to control applied thickness. In hot weather, do not leave sealed containers on roof for prolonged periods of time. In cold weather, keep material at room temperature until ready to use. Stir adhesive occasionally while using.
- » Adhesive must be allowed to dry thoroughly. If membrane is mated with the substrate prior to the adhesive being dry, blistering will occur and not subside over time.
- » KEEP OUT OF THE REACH OF CHILDREN.

Typical Properties and Characteristics

Base	Synthetic rubber
Color	Yellow
Solids	20%
Flash Point	-4°F (-20°C) closed cup
Brookfield Viscosity	2600 centipoises
Average Net Weight	7.1 lbs/gal (3.2 kg)
Packaging	5-gal pail
Shelf Life	1 year

Typical properties and characteristics are based on samples tested and are not guaranteed for all samples of this product. This data and information is intended as a guide and does not reflect the specification range for any particular property of this product.

LEED® Information

Pre-consumer Recycled Content	0%
Post-consumer Recycled Content	0%
Manufacturing Location	Carlisle, PA
VOC Content	670 g/L