

# Technical Information Sheet



## EPDM BONDING ADHESIVE BA-2004(T)

Item Description	Item Number
Bonding Adhesive	W563587052

### DESCRIPTION

Elevate EPDM Bonding Adhesive BA-2004(T) is a solvent-based contact adhesive designed specifically for adhering Elevate RubberGard™ EPDM membranes to approved insulations in addition to wood, metal, masonry, and other acceptable substrates.

### METHOD OF APPLICATION

1. Surfaces to receive EPDM Bonding Adhesive BA-2004(T) shall be clean, smooth, dry, free of sharp edges, loose and foreign materials, oil, grease, and other contaminants. Sweep the mating surface of the membrane with a stiff broom to remove excess dusting agent, if present, or other contaminants from the mating surface. Substrate and ambient temperatures shall exceed 20 °F (-6.7 °C) and rising before applying EPDM Bonding Adhesive BA-2004(T).
2. If pails are exposed to lower temperatures, restore to between 60 °F (16 °C) and 80 °F (27 °C) prior to use. Stir the adhesive thoroughly to achieve a uniform mix with no sediment on the bottom and no marbling evident before and during use.
3. Apply EPDM Bonding Adhesive 2004(T) at about the same time to both the exposed underside of the membrane and the receiving substrate to allow approximately the same drying time. Apply EPDM Bonding Adhesive BA-2004(T) evenly, avoiding heavy areas of accumulation.
4. Apply the EPDM Bonding Adhesive BA-2004(T) using a solvent resistant paint roller and roll the adhesive on the membrane and receiving substrate. When applying EPDM Bonding Adhesive, ensure complete uniform coverage on the membrane and receiving substrate. *Take Care not to apply EPDM Bonding Adhesive on membrane seam areas.*
5. EPDM Bonding Adhesive can be dispensed by power rollers or industrial spray equipment. Other equipment may be used as recommended by the manufacturer for application of this adhesive. NOTE: Spray applied bonding adhesive requires back-rolling with 9" (228.6 mm) wide solvent resistant roller (medium nap) to insure 100% adhesive coverage.
6. Allow EPDM Bonding Adhesive to flash off until tacky. Touch down on the Bonding Adhesive surface with a clean, dry, finger to verify that the adhesive does not string. As you are touching the adhesive, pushing straight down to check for stringing, also push forward at an angle to ensure that the adhesive solvents have flashed off throughout its thickness. If either motion reveals wet areas or stringing when the finger is lifted, then it is not ready for mating. *Flash-off time will vary depending on ambient conditions.*

7. When the adhesive is ready for mating, roll the adhesive coated portion of the membrane into the adhesive coated substrate slowly and evenly to maintain position and minimize membrane wrinkles.
8. To ensure proper adhesive contact, broom the mated membrane using a stiff push broom with heavy pressure immediately after mating the membrane.
9. Contact your Elevate Regional Technical Coordinator at 1-800-428-4511 for specific application instructions.

## COVERAGE

Coverage rate is based on roller applied adhesive for mating both surfaces and is highly dependent on the substrate. Some insulation surfaces are more uneven and porous requiring heavier coverage, while smooth non-porous substrates may need lighter coverage

Very porous substrates (rough wood, concrete block) may require two coats of EPDM Bonding Adhesive, to ensure proper adhesion. Check by adhering a small piece of membrane to the porous substrate to verify the bonding strength.

TYPICAL COVERAGE RATE		
Application	Total Coverage Rate	
	Per Pail	Per Gallon
Field and Flashing: Two-Sided	225 - 300 Ft <sup>2</sup> (20.9 - 27.9 m <sup>2</sup> )	45 - 60 Ft <sup>2</sup> (1.10 - 1.47 m <sup>2</sup> per liter)

## STORAGE

- Store EPDM Bonding Adhesive in original unopened containers at temperatures between 60 °F (16 °C) and 80 °F (27 °C) until ready for use.
- If exposed to lower temperatures, restore to between 60 °F (16 °C) and 80 °F (27 °C) prior to use.
- For optimum results, rotate stock to ensure stored material has not exceeded the shelf life of one year.

## SHELF LIFE

- Shelf life of one year can be expected if stored in original sealed container at temperatures between 60 °F (16 °C) and 80 °F (27 °C).
- Shelf life will be shortened if exposed to elevated temperatures for a prolonged period of time.

## PRECAUTIONS

- Refer to Safety Data Sheets (SDS) for additional safety information.
- Flammable. Keep away from fire and open flame and other possible ignition sources during storage and use. Do not smoke when using.
- Harmful or fatal if swallowed.
- Avoid prolonged inhalation. Use only in well ventilated areas.
- Avoid prolonged contact with skin. Gloves should be worn (OSHA approved).
- Avoid eye contact by wearing safety glasses with side shields or safety goggles.
- For professional use only. Keep out of reach of children.
- Thinning is not allowed.
- Do not use for splicing.
- Do not use with TPO or TPO XR membranes.

- Cover tightly when not in use.
- Review Safety Data Sheet specified on the Bonding Adhesive container label.
- Recommended cleaner is Elevate Splice Wash SW-100 Cleaner.

### LEED® INFORMATION

Post-Consumer Recycled Content: 0%  
 Post Industrial Recycled Content: 0%  
 Manufacturing Location: South Bend, IN or Rockland, MA



NOTE: LEED® is a registered trademark of the U.S. Green Building Council

## TYPICAL PROPERTIES

Properties	Value
Base	A blend of Polychloroprene and SBR rubbers
Color	Yellow
Solvents	A blend of Acetone, Hexane, Toluene and Xylene
Solids	≥ 23 %
Viscosity	3,300-3,800 cps, with R.V.F. #3 spindle @ 10 rpm
Weight/Gallon	6.7 - 7.4 lb/gal
Specific Gravity	0.803 - 0.887
V.O.C. Content	5.282 lb/gal (633 g/L)
Pail	5 gal (18.9 L)
Weight	41 lb (18.6 kg)
Units per Pallet	45 - 5 gal pails

## APPROVED POWER EQUIPMENT

### Garlock 25ST Roller Boss Power Roller

4 hp Honda Engine, 4 CFM Compressor, 25-gal pressurized supply tank (20 gal for material; 60-80 psi), Up to 100 psi rating, 2 - ¾" x 30' supply hoses with swivels, 2 - 18" roller head assemblies



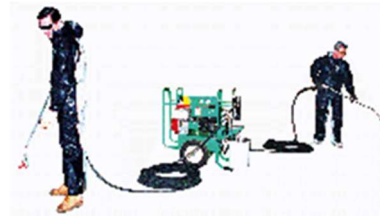
### Garlock 2120 Commander Sprayer

18 hp Kohler Engine, 4500 psi Rating, 5 Gallon per Minute Flow, 1200 psi Pressure (minimum), Pump Displacement 45:1, GPM Rating: up to 5 gpm, ½" x 100' hose, 2" Intake pipe with screen, 5- or 55-gal drum containers, Graco Spray Tip: .023 to .031 diameter hose



### Garlock Twin Gun Airless Sprayer

6.5 hp Honda Engine, 3000 psi Rating, Pump Displacement 30:1, GPM Rating: up to 1 gpm, Up to 400' of single ½" diameter hose, Up to 200' of dual ½" diameter hose, ¾" Intake pipe with screen, 5- or 55-gal drum containers, Bulk tank containers, Graco Spray Tip: .019 to .025 diameter hose (1850 psi operating pressure)



### Graco Spray Equipment

P70EC4-70 – 70:1 Xtreme Sprayer Package w/Heavy Duty car, Hopper package, w/NXT motor and Data Track, Xtreme-Duty high pressure hose, ¾" x 50', 7250 psi, with ¼" x 6' whip hose, XTR-7 applicator with XHD821-825 tip



<b>APPROVED SUBSTRATES</b>		
<b>TIS</b>	<b>Product Name</b>	<b>Approved (✓) / Not Approved</b>
901A	ISO 95+ GL	✓
901B	ISOGARD GL	✓
903	ISO 95+ GL Woodfiber Composite	✓
905A	HailGard Composite Board	✓
905B	ISOGARD HG Composite	✓
909	DensDeck Roof Board	✓
910	DensDeck Prime Roof Board	✓
916	ISOGARD HD Cover Board	✓
917A	Resista	✓
917B	ISOGARD CG	✓
918A	ISOGARD HD Composite	✓
918B	ISOGARD HD Composite	✓
952	Securock Ultralight Glass-Mat	Not Approved
953	Structodek	✓
954	Securock Gypsum-Fiber	✓
956	DensDeck StormX	✓
<b>Substrate</b>		<b>Approved (✓) / Not Approved</b>
EPS		Not Approved
XPS		Not Approved
Fiberglass Insulation		Not Approved
Perlite		Not Approved
Coal Tar Pitch		Not Approved
Structural Concrete (New)		✓
Structural Concrete (Existing) (Clean/Dry/Free of Contaminants)		✓
Steel		Not Approved
Gypsum		Not Approved
Cementitious Wood Fiber		Not Approved
Plywood		✓
OSB		✓
Wood Plank		✓
Lightweight Insulating Concrete (Cellular)		✓
Lightweight Insulating Concrete (Aggregate)		Not Approved
Structural Lightweight Concrete		✓
<b>NOTE:</b>		
Contact a Regional Technical Coordinator for materials or conditions not listed. All substrates must be clean, dry, free of contaminants or debris and prepared properly prior to application.		

Please contact Elevate Technical Services at 800-428-4511 for further information.

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