

Technical Information Sheet



Single-Ply LVOC Bonding Adhesive-1168

Item Description	Item Number
5 Gallon Pail	W56358705LC

Description

Elevate Single-Ply LVOC Bonding Adhesive - 1168 is a bonding adhesive designed for adhering RubberGard™ EPDM and UltraPly™ TPO membranes and flashings to substrates such as: insulation, wood, metal, masonry, and appropriate insulation / cover boards.

Method of Application

1. Surfaces to receive Elevate Single-Ply LVOC Bonding Adhesive - 1168 must be clean, smooth, dry and 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, and remove other contaminants from the mating surface.
2. Stir the adhesive thoroughly before and during use, achieving a uniform mix with no sediment on the bottom and no marbling evident. Apply the bonding adhesive evenly, avoiding globs and puddles, at about the same time to both the membrane and the receiving substrate to allow similar flash-off time.
3. **Take care not to apply Elevate Single-Ply LVOC Bonding Adhesive - 1168 over any lap area that will be spliced to adjacent membrane panels.**
4. Allow Elevate Single-Ply LVOC Bonding Adhesive - 1168 to flash-off until tacky. Touch the adhesive surface with a clean, dry finger to be certain that the adhesive does not stick or string. Push down and forward on the adhesive at an angle to ensure that the adhesive is ready throughout its thickness. If either motion exposes wet or stringy adhesive when the finger is lifted, then it is not ready for mating. **Flash off time will vary significantly depending on ambient conditions, and will be extended during cool, cloudy conditions. Use when ambient and substrate temperatures exceed 45 °F (7 °C).**
5. Starting at the fold, roll the adhesive coated portion of the membrane into the adhesive coated substrate slowly and evenly to minimize wrinkles. To ensure mating of the membrane to substrate, broom the surface of the mated membrane with a stiff bristle push broom immediately after mating to the substrate.

Storage

- Store in original unopened containers at temperatures between 60 °F (16.6 °C) and 80 °F (26.7 °C) until ready for use.
- For optimum results, rotate your stock to ensure stored material has not exceeded the shelf life of one year.
- If exposed to lower temperatures, restore to room temperature prior to use.
- Storage below 50° F (10 °C) will cause solids portion of adhesive to separate. To alleviate separation, bring adhesive to room temperature and stir to smooth state.

Coverage Rate

- Coverage rate of 45 – 60 square feet per gallon (1.1 – 1.5 m²/Liter) shall be obtained, depending on the substrate.
- Uneven and porous substrates may yield lower coverage rates.
- Smooth, non-porous substrates may yield higher coverage rates.
- Coverage rates are based on roller application to both mating surfaces.

Clean-Up

The recommended cleaner for the liquid adhesive is acetone.

Shelf Life

- Shelf life of one year can be expected if stored in original sealed container at temperatures between 60 °F (15.6 °C) and 80 °F (26.7 °C).
- Shelf life will be shortened if exposed to elevated temperatures. Rotate stock to ensure material will not go beyond the shelf life of one year.

Precautions

- Refer to Safety Data Sheets (SDS) for additional safety information.
- Use when ambient and substrate temperatures exceed 45° F (7 °C).
- Flammable. Keep away from fire and open flame and other possible ignitions 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 goggles with side shields.
- Do not thin the adhesive.
- Do not use for splicing.
- Do not use with UltraPly TPO XR membrane.
- Cover tightly when not in use.

LEED® Information

Post-Consumer Recycled Content: 0%
 Post Industrial Recycled Content: 0%
 Manufacturing Location: South Bend, IN
 NOTE: LEED® is a registered trademark of the U.S. Green Building Council



Typical Properties	
Properties	Typical Performance
Base	Polychloroprene Rubber
Color	Yellow
Solvents	Acetone; Toluene; Methyl Acetate; 4-Chlorobenzotrifluoride
Solids by Volume	22 - 23%
Viscosity	4000 - 6000 Centipoise
Weight/Gallon	9.2 lb/gal (1.1 kg/L)
Specified Gravity	1.1
V.O.C. Content	< 250 g/L; VOC content is less than 250 G/L in accordance with South Coast Air Quality Management District (SCAQMD).

Product Packaging	
Pail	5 gal (19 L)
Weight	Approx. 47 lb (21 kg)
Units Per Pallet	45

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

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