

Technical Service Bulletin No. S-13-05

Vulkem 350NF Mixing Instructions

The following establishes standard mixing requirements, techniques, and blade styles.

- Vulkem 350NF must be thoroughly mixed prior to use.
- Mixing time requirements can vary depending on temperature and humidity. Colder material may require longer mixing times as the Vulkem 350NF viscosity will be higher.
- Large spiral “paint” mixing blades should be used. Spiral mix blades create the desired vortex for even disbursement of material. (Tremco does NOT recommend using blades with a nut or extension below the actual mixing blades. Paddles with this design will not effectively disperse heavier components that may have settled to the bottom of the pail.)
- For best results, mixing drills offering speed \geq 500 RPM are required.
- Tremco requires a minimum of 5 minutes of mixing, to fully disperse settling.
- Starting at the bottom of the Vulkem 350NF pail, mix for 1 minute minimum. The mixing blade should be in full contact with the bottom of the pail. After 1+ minute(s) of bottom only mixing, begin to mix the entire pail for the remaining 4+ minutes by moving the mixing paddle up and down within the material to properly disperse settling at all levels.
- Pails of Vulkem 350NF that are capped for reuse will require 1 minute of mixing per day of non-use but not more than 3 minutes total when re-opened. If a skin develops on top during storage, it should be removed prior to re-mixing.

Temperature @ 50% Relative Humidity	Cure Rate
32°F – 40°F (0°C – 4.4°C)	72+ hours
40°F – 55°F (4.4°C – 12.8°C)	48 hours
55°F – 65°F (12.8°C – 18.3°C)	16-24 hours
65°F – 85°F (18.3°C – 29.4°C)	4-6 hours
85°F (29.4°C)	\leq 4 hours

Variations in temperature and humidity can affect the cure rate of the waterproofing membrane. The above chart should be used as a guide only to determine the approximate rate of cure. Other factors can also influence the cure rate such as substrate temperature and enclosed environments. For more information about proper application procedures please refer to the installation instructions or contact Technical Services.