

To: Carlisle SynTec Systems' Authorized Applicators

November 2, 2015

Attention: Foremen and Project Supervisors

The arrival of fall and lower temperatures provides a good opportunity to review Carlisle's application tips and storage requirements for its Low-VOC Bonding Adhesives and Primers.

Storage Tips for EPDM x-23 Low-VOC Bonding Adhesive, Low-VOC Bonding Adhesive, and Low-VOC Primer

- 1) Keep these products between 60°F-80°F for best results and ease of application.
- 2) When ambient temperatures are expected to fall below 40°F for an extended period of time, a heated enclosure or hot box is strongly recommended for jobsite storage.
- 3) **Extended storage in below-freezing temperatures may cause bonding adhesive to solidify in the can.**
 - a. If adhesive or primer is stored in below-freezing temperatures, restore to room temperature for a minimum of 24 hours prior to use. The material will perform as intended once it is returned to a liquid state.

Application Tips for Low-VOC Bonding Adhesive and EPDM x-23 Low-VOC Bonding Adhesive

- 1) Thorough mixing once per day is essential. Dark streaks (unmixed solvent) in the adhesive should not be visible.
- 2) Allow EPDM and TPO membranes to relax for 30 minutes or longer, especially when using folded sheets of EPDM. This technique results in less stress on the freshly formed bond.
- 3) Achieving the proper coverage rate of 300 square feet per 5-gallon pail is critical.
 - a. Avoid puddles, globs, or heavy areas, as they may cause blisters beneath the membrane due to trapped solvents.
 - b. Re-roll any heavy, "wet" areas to break the skin and allow solvents to flash off.
- 4) Use the "tack test" to ensure that solvents have flashed off and the adhesive is still tacky.
 - a. Adhesive applied to shaded roof areas will take longer to flash off than areas exposed to the sun.
 - b. If the adhesive is not tacky, it has over-dried and must be re-applied at the published coverage rate.
- 5) Monitor the adhesive for flash-off and install the membrane shortly after adhesive passes the tack test.
- 6) Broom or roll the membrane immediately after setting the sheet.
 - a. If blisters occur, allow the solvent to dissipate naturally for 4-5 days; then, re-broom the membrane.

Please share this information with your crews to achieve the best results when working with Carlisle's Low-VOC Bonding Adhesives and Primers.

Sincerely,



Ron Goodman
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