

December 2, 2016

To: Carlisle SynTec Systems' Authorized Applicators

Attention: Foremen and Project Supervisors

Subject: Low-VOC Adhesive Cold Weather Installation Tips - Update

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

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

- 1) Keep these products between 60-80°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 cold temperatures may cause bonding adhesive to thicken or solidify in the can.**
 - a. If adhesive or primer is stored in cold 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.
 - b. EPDM x-23's resistance to gelling in cold weather has been improved by 400% compared to the original 2015 formula and exceeds that of competitive low-VOC bonding adhesives.

Application Tips for EPDM x-23 Low-VOC Bonding Adhesive and 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 before applying adhesive, 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 that adhesive is still tacky prior to installing the membrane.
 - 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 must be re-applied at the published coverage rate.

INSTALLATION ADVISORY



- 5) Broom or roll the membrane immediately after setting the sheet.
 - a. If blisters occur, allow the solvent to dissipate naturally for 4-5 days; after this time, re-broom the membrane.

Sincerely,

A handwritten signature in black ink that reads "Ronald I. Goodman".

Ron Goodman
Marketing Manager, EPDM Roofing Systems