

## CHEM LINK

### Construction & Maintenance

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### Product Description

**Single Ply EPDM Adhesive** is a 100% solvent free, non-water based polyether adhesive that is used to fully adhere EPDM rubber. This patented adhesive saves labor because it is a single coat adhesive. Wall and curb flashings still require a coating of the underside of the rubber and flashing. Unlike water based adhesives, **Single Ply EPDM Adhesive** cannot freeze and be damaged in storage and shipping in freezing temperatures. This unique product is virtually odor free which allow the adhesive to be used in a wide variety of job site environments and can be used in all fifty states without restriction.

**Single Ply EPDM Adhesive** has a patented, moisture cure formula that offers easy installation of EPDM in difficult, damp or cold environments. It is safe for occupied buildings such as schools, offices, hospitals, or food processing plants, where solvent vapors and odors are not tolerated.

**Single Ply EPDM Adhesive** bonds aggressively to iso-board, gypsum composite recovery boards and most other construction surfaces. The adhesive is environmentally compliant, solvent free and contains very low levels of VOC's. **Single Ply EPDM Adhesive** can be shipped and used throughout the United States without restriction, is OSHA compliant and eliminates chronic exposure hazards associated with conventional solvent release.

### Regulatory Compliance

- Conforms to OTC Rule for Adhesives
- Meets requirements of California Regs: CARB and SCAQMD
- This product does not contain cancer causing chemicals listed in California Proposition 65

### Green Standards:

- LEED 2.2 for New Construction and Major Renovations: Low Emitting Materials (Section 4.1) 1 Point
- NAHB Model Green Home Building Guidelines: 5 Global Impact Points
- VOC Content: less than 12 grams / liter ASTM D2369 EPA Method 24 (tested at 240°F / 115°C)



### Advantages

- 100% Solvent free, will not shrink, no red label
- Saves up to 50% adhesive application labor
- One coat application on the field of the roof
- Odor free
- No mixing
- Made in the USA - ISO 9001:2015 certified

### Packaging:

- 2 Gallon Pail  
60 pails/pallet
- 3.5 Gallon & 5 Gallon Pail  
36 pails/pallet

### Color

Clear

## Field Application

All bonding surfaces shall be clean, dry and free of all dust, dirt and all other bond breaking contaminants. The adhesive shall be applied to the insulation/recovery board at a rate of 90-120 square feet per gallon. Rough or absorbent surfaces or cool temperatures may cause the need for additional adhesive. Allow the adhesive to become tacky (forming strings), when touched before setting the rubber in place. "String time" will vary depending on the ambient temperature and humidity. In warm, humid conditions, the rubber can frequently be set in ten minutes. Cool conditions will dramatically slow down the "string time". Secure the bond with a soft bristle floor broom after setting the rubber in place. Weighted rollers are not recommended. Mislaid sheets can be pulled free and reset. Any dry spots shall be coated with additional adhesive. Since this is not a "contact bond adhesive", minor bubbles can occur.

## Adhesive Application Equipment

Single Ply EPDM Adhesive is commonly applied with heavy nap paint rollers, Better Spreaders\*, or Super Spreaders\*

\*Back rolling the adhesive with a heavy nap roller is recommended..

## Suggested Application Rate

Field: 90-120 sq. feet/ gallon depending on substrate.

Flashings: 1.5 gallons per square, double sided application.

## Wall Flashings and Curb Application

Coat both the vertical flashing and the underside of the rubber with adhesive at a minimum application rate of 0.75 gallons per square (1.5 gallons per square total) and allow an open time of 15-20 minutes (time varies with temperature and humidity) before setting the rubber sheet in place. Secure the bond with hand rollers.

## Shelf Life

Six months from date of manufacture when stored at 70 F with 50% relative humidity. High temperature and high relative humidity may significantly reduce shelf life.

## Storage

Store original, unopened containers in a cool, dry area. Protect unopened containers from water, heat and direct sunlight. Elevated temperatures will reduce shelf life. **Single Ply EPDM Adhesive** will not freeze.

All properties described in this document are derived from testing conducted in laboratory conditions. Properties and performance will vary depending on environmental conditions and application technique. Test and evaluate to determine appropriate usage. Visit [www.chemlink.com](http://www.chemlink.com) for the Safety Data Sheet, Technical Data Sheet and full warranty for this product.

LIMITED WARRANTY: **CHEM LINK** warrants this product's performance, provided it is properly stored and applied within 1 year. If this **CHEM LINK** material is proved to be defective, return remaining product and purchase receipt for refund or replacement of product exclusive of labor or cost of labor. This is the sole and exclusive remedy for defects or failure of this product. User must read and follow the direction of the current TDS and SDS prior to product use. User determines suitability of product for intended use and assumes all risks. Manufacturer shall not be liable for damages (including consequential or incidental damages) in excess of the purchase price, except where such exclusion or limitation is prohibited by state law. THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, WRITTEN OR ORAL, STATUTORY, EXPRESS OR IMPLIED INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE; except for the above express warranty given by manufacturer, the product is sold with all faults. **CHEM LINK** SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. This warranty gives you specific legal rights, and you may also have other rights in the U.S. which vary from state to state. For warranty claim information, call 800-826-1681.

Typical Physical Properties		
Chemistry	Moisture Cure	
Viscosity at time of manufacture	7,000 +/- 2,000 cp	Brookfield RVF TC Spindle, 4 RPM, 73°F (23°C)
Density	8.2 +/- 0.2 lbs per gallon	ASTM D1475
Tack Free Time	30 min +/- 15 min	45 +/- 5 % R.H.
Shrinkage	No visible shrinkage after 14 days	
Service Temperature	-40°F to 200°F (-40°C to 93°C)	

## Caution

Avoid prolonged contact with skin. Uncured adhesive irritates eyes. In case of contact with eyes immediately flush with water. Call a physician. Please refer to the SDS for First Aid information.

See [www.chemlink.com](http://www.chemlink.com) for most current SDS .

KEEP OUT OF REACH OF CHILDREN.

## Limitations

- **Single Ply EPDM Adhesive is not to be used as a splice adhesive.** Remove any spilled adhesive on splice areas with rubbing alcohol or acetone and a clean rag
- **Do not use with reinforced EPDM.**
- Maintain adhesive at room temperature in cold weather to help maintain normal application rates.
- Single Ply EPDM Adhesive is not a contact bond adhesive. Minor bubbles can occur in the membrane
- Do not store in elevated temperatures.
- Use only on clean, dry surfaces that are free of all surface contaminants.
- Do not cut or thin the adhesive.  
Best results occur in temperatures of 50°F and rising
- Please contact customer service for application guidelines with temperatures below 50°F (10°C).