



1168 Low-VOC PVC Bonding Adhesive

High-Strength Solvent-Based Contact Adhesive



PRODUCT DATA SHEET

DESCRIPTION

A high-strength solvent-based contact adhesive that allows bonding of PVC and KEE HP membranes to various porous and non-porous substrates. It is specially formulated to be in compliance with rule 1168 of the South Coast Air Quality Management District (SCAQMD) in California. This product also meets the <250 gpl VOC content requirements of the OTC Model Rule for Single-Ply Roofing Adhesives.

FEATURES AND BENEFITS

- High-strength adhesive that allows quick bonding
- Can be easily applied with a medium nap roller
- Provides excellent adhesion between various substrates and PVC and/or KEE membranes

COVERAGE RATE

50 ft² (4.6 m²) per gallon finished surface. Coverage rates are average and may vary due to conditions on the jobsite. Porous surfaces and substrates may require more bonding adhesive than the typical coverage rate.

MIXING

Stir thoroughly until the adhesive is uniform in color. Minimum 5 minutes stirring is recommended.

APPLICATION

1. The surface on or against which adhesive is to be applied shall be clean, smooth, dry, free of fins, sharp edges, loose and foreign materials, oil and grease. Depressions greater than 1/4" (6 mm) should be feathered using epoxy, mortar or other approved patching material. All sharp projections shall be removed by sweeping, blowing or vacuum cleaning.
2. After thorough stirring (minimum 5 minutes), apply 1168 Low-VOC PVC Bonding Adhesive to substrate and membrane using a 9" (229 mm) medium nap roller. Application shall be continuous and uniform, avoiding globs or puddles. Once flashed off, adhesive will have little to no tackiness and provides an application window of roughly 15-20 minutes depending upon ambient temperature. Any coated area that has been exposed to rain should be allowed to dry and then recoated. Do not apply adhesive to splice areas to be hot-air welded.
3. Roll the membrane onto the adhesive-coated substrate while avoiding wrinkles. Immediately brush down the bonded portion of the sheet with a soft-bristle push broom or a clean dry roller applicator to achieve maximum contact.

PRECAUTIONS

- Review the applicable Material Safety Data Sheet for complete safety information prior to use.

- 1168 Low-VOC PVC Bonding Adhesive is **EXTREMELY FLAMMABLE**. It contains solvents that are dangerous fire and explosion hazards when exposed to heat, flame or sparks. Do not smoke while applying. Do not use in a confined or unventilated area. Vapors are heavier than air and may travel along ground or may be moved by ventilation and ignited by pilot lights, other flames, sparks, heaters, smoking, electrical motors, static discharge, or other ignition sources at locations distant from material handling point. All containers should be grounded when material is transferred from one container to another. A red caution label is required when shipping. A fire extinguisher should be available. In case of fire, use water spray, foam, dry chemical or carbon dioxide. Do not use a solid stream of water because it can scatter and spread the fire.
- Avoid breathing vapors. Keep container closed when not in use. Use with adequate ventilation. If inhaled, remove to fresh air. If not breathing, perform artificial respiration. If breathing is difficult, give oxygen. Call a physician immediately. During application, efforts must be made to prevent fumes from entering the building via air ventilation ducts. Do not place open containers or mix adhesive near fresh air intake units. When possible, shut down or seal off the closest units.
- If swallowed, **DO NOT INDUCE VOMITING**. Call a physician immediately.
- Avoid contact with eyes. Safety glasses or goggles are recommended. If splashed in eyes, immediately flush eyes with plenty of clean water for at least 15 minutes. Contact a physician immediately.
- Avoid contact with skin. Wash hands thoroughly after handling. In case of contact with skin, thoroughly wash affected area with soap and water. Contact physician if irritation persists.

Note: Permeation-resistant gloves (that meet ANSI/ISEA 105-2005) are recommended to be worn when using this product to protect hands from irritating ingredients.
- Do not thin 1168 Low-VOC PVC Bonding Adhesive. Thinning will affect performance. Excessively thick or gelled material should be discarded.
- Jobsite storage in excess of 90°F (32°C) may affect product shelf life. Should the 1168 Low-VOC PVC Bonding Adhesive be stored at temperatures lower than 60°F (15°C), restore to room temperature prior to use.
- Opened containers of 1168 Low-VOC PVC Bonding Adhesive should be used within 48 hours. Adhesives will begin to thicken after this point, making it difficult and eventually impossible to control applied thickness. In hot weather, do not leave sealed containers on roof for prolonged periods of time. In cold weather, keep material at room temperature until ready to use. Stir adhesive occasionally while using.
- Adhesive must be allowed to dry thoroughly. If membrane is mated with the substrate prior to the adhesive being dry, blistering will occur and will not subside over time.
- **KEEP OUT OF REACH OF CHILDREN.**



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TYPICAL PROPERTIES AND CHARACTERISTICS

Base	Synthetic rubber
Color	Pale yellow to orange to amber
Solids	23.6-29.6%
Flash Point	-4°F (-20°C) SETA
Brookfield Viscosity	1,500-4,500 centipoises
Average Net Weight	6.9-7.7 lbs/gal (0.8-0.9 kg/l)
Packaging	5-gallon pail
Shelf Life	1 year

Typical properties and characteristics are based on samples tested and are not guaranteed for all samples of this product. This data and information is intended as a guide and does not reflect the specification range for any particular property of this product.

GREEN BUILDING INFORMATION

Pre-Consumer Recycled Content	0%
Pos-Consumer Recycled Content	0%
Solar Reflectance Index (SRI)	NA
Global Warming Potential (GWP)	Unavailable
Volatile Organic Compounds (VOC) Content	<250 g/L
Manufacturing Location	Carlisle, PA
Corporate Sustainability Report (CSR) Availability	Yes
Environmental Product Declaration (EPD) Availability	No

PROTECTION & SAFETY

MuleHide maintains safety data sheets on all of its non-exempt products. Safety data sheets contain health and safety information for your development of appropriate product handling procedures to protect your employees and customers. MuleHide's safety data sheets should be read and understood by all of your supervisory personnel and employees before using MuleHide products in your facilities.

ADDITIONAL INFORMATION

On projects where a MuleHide standard or premium warranty is requested, an authorized MuleHide representative shall inspect all completed work.

The information given on this PDS is subject to change without notice. Always check the MuleHide website at www.mulehide.com for the latest information, changes and updates or contact MuleHide at 800-786-1492.

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