

# Technical Guide

"The name trusted in roofing since 1906"



## SUMMARY GUIDELINE FOR ADHESIVE COMPATIBILITY

Revision Date: Jan 2020

Note: Refer to adhesive Product Data Sheets for specific substrate compatibilities and application techniques

EPDM				
Acrylic Water Base Bonding Adhesive	Water Based Not for low temp use	Single side, wet lay-in	100 – 120 sf. Per gallon	Horizontal use only. NOT FOR USE WITH POLYISO INSULATION!
Aqua Base 120	Water Based Not for low temp use	Two sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
EPDM X-23 Low VOC Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
Low-VOC Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
Low-VOC Bonding Adhesive 1168	Solvent Based California Only	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
AeroWeb	Spray Adhesive Solvent Based	Two-sided, contact adhesive	1,000 sf per 40# cylinder	Vertical and Horizontal use

TPO				
Aqua Base 120	Water Based Not for low temp use	Two sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
TPO Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
Low-VOC Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
Low-VOC Bonding Adhesive 1168	Solvent Based California Only	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
AeroWeb	Spray Adhesive Solvent Based	Two-sided, contact adhesive	1,000 sf per 40# cylinder	Vertical and Horizontal use

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<b>TPO Fleece Back</b>				
Aqua Base 120	Water Based Not for low temp use	Single side, wet lay-in for field	100 – 120 sf. Per gallon	Horizontal – single side wet lay-in Vertical – two sided contact application
Helix® Max Low-Rise Foam	Low-rise foam	Single side	Varies by container	Horizontal use only
TPO Bonding Adhesive Low-VOC Adhesive Low-VOC 1168 Adhesive	Solvent Base Solvent Base Solvent - California	Two-sided, contact adhesive	60 sf. Per gallon	Vertical flashings only
AeroWeb	Spray Adhesive Solvent Base	Two-sided, contact adhesive	1,000 sf per 40# cylinder	Vertical flashings only

<b>PVC</b>				
HydroBond™ Water-Based PVC Bonding Adhesive	Water Based Not for low temp use	Single side, wet lay-in for field	100 sf Per gallon	Horizontal – single side wet lay-in Vertical – two sided contact application
Aqua Base 120	Water Based Not for low temp use	Two sided, contact adhesive	60 sf. Per gallon	Horizontal – single side wet lay-in Vertical – two sided contact application
Low-VOC PVC Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use

<b>PVC KEE</b>				
Aqua Base 120	Water Based Not for low temp use	Two sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use
Low-VOC PVC Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical and Horizontal use

<b>PVC Fleece Back and PVC KEE Fleece Back</b>				
Aqua Base 120	Water Based Not for low temp use	Single side, wet lay-in for field	100 – 120 sf. Per gallon	Horizontal – single side wet lay-in Vertical – two sided contact application
HydroBond Water-based PVC Bonding Adhesive	Water Based Not for low temp use	Single side, wet lay-in for field	100 – 133 sf. Per gallon	Horizontal – single side wet lay-in Vertical – two sided contact application
Helix® Max Low-Rise Foam	Low-rise foam	Single side	Varies by container	Horizontal use only
Low-VOC PVC Bonding Adhesive	Solvent Based	Two-sided, contact adhesive	60 sf. Per gallon	Vertical flashings only
AeroWeb	Spray Adhesive Solvent Base	Two-sided, contact adhesive	1,000 sf per 40# cylinder	Vertical flashings only

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### **Acrylic Water Based Bonding Adhesive, Aqua Base 120 & HydroBond™**

Water based adhesives must not be allowed to freeze either during storage or application. These adhesives must be stored in original unopened containers at temperatures between 60°F and 90°F prior to application. In general, these products should be installed when temperatures are 45°F and above and must not be allowed to freeze within a minimum of 48 hours of application. Once subjected to freezing temperatures the product will not perform and must be disposed off. Consult the appropriate Product Data Sheets for specific information on the adhesive being installed.

### **Mule-Hide Bonding Adhesive (EPDM), EPDM X-23, Mule-Hide TPO Bonding Adhesive, Mule-Hide PVC Bonding Adhesive, Low-VOC Bonding Adhesive, Low-VOC PVC Bonding Adhesive, Low-VOC Bonding Adhesive 1168 (CA only)**

Solvent based adhesive and sealants must be stored in original unopened containers at temperatures between 60°F and 90°F for 24 hours prior to use. Storage at temperatures over 90°F may alter product shelf life. Mix product thoroughly until all settled pigments are dispersed and adhesive is uniform in color. Mule-Hide recommends a minimum of 5 minutes of stirring with a variable speed drill and mixing paddle. Products stored at cold temperatures and then restored to room temperatures may experience separation of solvents. Always remix products thoroughly prior to use.

### **AeroWeb**

Store cylinders in protected, conditioned space at temperatures above 70°F but not exceeding 110°F. Propellant in cylinders must be kept about 70°F for product to spray properly. Utilize power-heated blankets and hot boxes when necessary.

**Low-VOC Adhesives** - Opened containers of Low-VOC adhesives must be used within 48 hours. Stir adhesive occasionally while using. Adhesive will begin to thicken after this point, making it difficult 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.

**Cold Weather Applications** - Working in low temperatures will also result in longer drying times for solvent based products. Failure to allow the products to properly flash off will result in solvent blistering of the membrane. In addition to extended drying times, there is an increased likelihood of condensation forming on the surface of the adhesive. If condensation forms, the surfaces cannot be mated and work must stop until conditions improve.

**Coverage Rates** - Coverage rates are average and will vary based on job site conditions. Porous or slightly rough surfaces may require the use of a prime coat followed by a finish coat of adhesive. The performance of the roofing system will be diminished if proper amounts of adhesive are not applied.

**Please consult the appropriate Product Data Sheet or other information on our website for complete information and instructions.**

Any information given on this Technical Guide is subject to change without notice. Please visit our website at [www.mulehide.com](http://www.mulehide.com) or contact Mule-Hide Products at (608) 365-3111 for questions or additional information.