

# Technical Information Sheet



## EPDM Bonding Adhesive BA-2004(T)

Item Description	Item Number
Bonding Adhesive	W563587052

### Description

Elevate EPDM Bonding Adhesive BA-2004 (T) is a solvent-based contact adhesive designed specifically for bonding Elevate RubberGard™ membranes and flashings to wood, metal, masonry, and other acceptable substrates.

### Method of Application

1. Surfaces to receive EPDM Bonding Adhesive BA-2004 (T) shall be clean, smooth, dry, free of sharp edges, loose and foreign materials, oil, grease, and other contaminants. Sweep the mating surface of the membrane with a stiff broom to remove excess dusting agent, if present, or other contaminants from the mating surface. Substrate and ambient temperatures shall exceed 20 °F (-6.7 °C) and rising before applying EPDM Bonding Adhesive BA-2004 (T).
2. Stir the adhesive thoroughly to achieve a uniform mix with no sediment on the bottom and no marbling evident before and during use.
3. Apply EPDM Bonding Adhesive 2004 (T) at about the same time to both the exposed underside of the sheet and the substrate to which it will be adhered to allow approximately the same drying time. Apply EPDM Bonding Adhesive BA-2004 (T) evenly, avoiding areas of accumulation.
4. Apply the EPDM Bonding Adhesive BA-2004 (T) with a solvent resistant paint roller and roll the adhesive onto the mating surfaces. When applying EPDM Bonding Adhesive BA-2004 (T), ensure complete uniform coverage of both surfaces that will be adhered. Care must be taken not to apply Bonding Adhesive over seam areas.
5. EPDM Bonding Adhesive can be dispensed by means of power rollers or industrial spray equipment. Other equipment may be used as recommended by the manufacturer for application of this adhesive. NOTE: Spray applied bonding adhesive requires back-rolling with 9" (228.6 mm) wide solvent resistant roller (medium nap) to insure 100% coverage of the adhesive on the substrate and membrane.
6. Allow Bonding Adhesive to flash off until tacky. Touch down on the Bonding Adhesive surface with a clean, dry finger to be certain that the adhesive does not string. As you are touching the adhesive, pushing straight down to check for stringing, also push forward on the adhesive at an angle to ensure that the adhesive solvents have flashed off and are ready throughout its thickness. If either motion exposes wet areas or sticking when the finger is lifted, then it is not ready for mating. Flash-off time will vary depending on ambient conditions.

## Method of Application Continued

7. Starting at the fold, roll the previously coated portion of the sheet into the coated substrate slowly and evenly to maintain position and minimize wrinkles.
8. To ensure proper contact, compress the bonded half of the sheet to the substrate with a stiff push broom using heavy pressure immediately after mating.
9. Contact a Regional Technical Coordinator at 1-800-428-4511 for specific application information.

## Storage

- Store in original unopened containers at temperatures between 60 °F (16 °C) and 80 °F (27 °C) until ready for use.
- For optimum results, rotate stock to ensure stored material has not exceeded the shelf life of one year.

## Shelf Life

- Shelf life of one year can be expected if stored in original sealed container at temperatures between 60 °F (16 °C) and 80 °F (27 °C).
- If exposed to lower temperatures, restore to room temperature prior to use.
- Shelf life will be shortened if exposed to elevated temperatures.

## Precautions

- Refer to Safety Data Sheets (SDS) for additional safety information.
- Flammable. Keep away from fire and open flame and other possible ignition sources during storage and use. Do not smoke when using.
- Harmful or fatal if swallowed.
- Avoid prolonged inhalation.
- Avoid prolonged contact with skin. Gloves should be worn (OSHA approved).
- Avoid eye contact by wearing safety glasses with side shields or safety goggles.
- For professional use only.
- Keep out of reach of children.
- Thinning is not allowed.
- Do not use for splicing.
- Do not use with TPO or TPO XR membranes.
- Use only in well ventilated areas.
- Cover tightly when not in use.
- Review Safety Data Sheet specified on the Bonding Adhesive container label.
- Recommended cleaner is Elevate Splice Wash SW-100 Cleaner.

## LEED® Information

Post-Consumer Recycled Content: 0%  
 Post Industrial Recycled Content: 0%  
 Manufacturing Location: South Bend, IN or Rockland, MA  
 NOTE: LEED® is a registered trademark of the U.S. Green Building Council



Typical Properties	
Properties	Value
Base	A blend of Polychloroprene and SBR rubbers
Color	Yellow
Solvents	A blend of Acetone, Hexane, Toluene and Xylene
Solids	≥ 23
Viscosity	3,300-3,800 cps, with R.V.F. #3 spindle @ 10 rpm
Weight/Gallon	6.7 – 7.4 lb/gal
Specific Gravity	0.803 – 0.887
V.O.C. Content	5.282 lb/gal (633 g/L)

Typical Properties	
Pail	5 gal (18.9 L)
Weight	41 lb (18.6 kg)
Coverage	<p>A coverage rate of 45 - 60 ft<sup>2</sup>/gal (1.10 – 1.47 m<sup>2</sup>/L) may be obtained depending on the substrate. Some insulation surfaces are more uneven and porous and will result in a lower coverage rate while smooth non-porous substrates will result in higher coverage rates. Rates are based on roller application to both mating surfaces.</p> <p>Very porous substrates (rough wood, concrete block) may require two coats of EPDM Bonding Adhesive BA-2004(T), to ensure proper adhesion. This can be determined by adhering a small piece of membrane to the porous substrate to verify the bonding strength.</p>
Units per Pallet	45 – 5 gal pails

## Approved Power Equipment

### Garlock 25ST Roller Boss Power Roller

4 hp Honda Engine, 4 CFM Compressor, 25-gal pressurized supply tank (20 gal for material; 60-80 psi), Up to 100 psi rating, 2 - 3/4" x 30' supply hoses with swivels, 2 - 18" roller head assemblies



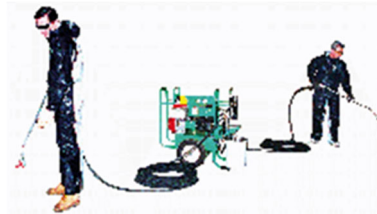
### Garlock 2120 Commander Sprayer

18 hp Kohler Engine, 4500 psi Rating, 5 Gallon per Minute Flow, 1200 psi Pressure (minimum), Pump Displacement 45:1, GPM Rating: up to 5 gpm, 1/2" x 100' hose, 2" Intake pipe with screen, 5- or 55-gal drum containers, Graco Spray Tip: .023 to .031 diameter hose



### Garlock Twin Gun Airless Sprayer

6.5 hp Honda Engine, 3000 psi Rating, Pump Displacement 30:1, GPM Rating: up to 1 gpm, Up to 400' of single 1/2" diameter hose, Up to 200' of dual 1/2" diameter hose, 3/4" Intake pipe with screen, 5- or 55-gal drum containers, Bulk tank containers, Graco Spray Tip: .019 to .025 diameter hose (1850 psi operating pressure)



### Graco Spray Equipment

P70EC4-70 - 70:1 Xtreme Sprayer Package w/Heavy Duty car, Hopper package, w/NXT motor and Data Track, Xtreme-Duty high pressure hose, 3/8" x 50', 7250 psi, with 1/4" x 6' whip hose, XTR-7 applicator with XHD821-825 tip



Please contact Holcim Technical Services at 800-428-4511 for further information.

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