

Technical Information Sheet



XR Stick™

Item Description	Item Number
Box – Part 1, 5 Gallon bag in box	W56TPO3401
Box – Part 2, 5 Gallon bag in box	W56TPO3402
Cartridge – 1500 ml Cartridge Kit (750 ml Part 1, 750 ml Part 2)	W56TPO3400

Description

Elevate XR Stick adhesive is a two-component, LVOC, low-rise polyurethane adhesive designed to attach Elevate PVC XR, PVC KEE XR and UltraPly™ TPO XR, fleece backed roofing membranes to a variety of acceptable substrates as allowed by Elevate specifications. XR Stick (cartridges) can be dispensed using various Elevate approved hand or multi bead electric dispensing units. The dispensing units extrude Part A and Part B simultaneously through a static mixer which results in a properly mixed bead of adhesive to be applied to the receiving substrate. XR Stick (box) is specifically designed to be dispensed using the PaceCart 2™ dispenser. The PaceCart 2 dispenser pumps the XR Stick Parts 1 and 2 simultaneously to a static mixer, which allows a properly mixed bead of adhesive to be applied to the receiving substrate. **NOTE:** PaceCart 2 is a registered trademark of OMG, INC.

Method of Application

1. Install only as much roof membrane anchored with XR Stick adhesive as can be covered and made watertight during that working day.
2. The substrate must be clean, smooth, dry, and free of sharp edges, loose and foreign materials, oil, grease, and other contaminants.
3. Proper equipment must be used to install XR Stick Membrane Adhesive. Install XR Stick adhesive only when ambient conditions, and bonding substrates and membranes, exceed 40 °F (4.4 °C) and are rising.
4. To mix and dispense XR Stick adhesive with the Pace Cart 2, properly install the XR Stick Parts 1 and 2 onto the PaceCart 2 and apply the product as per the equipment manufacturer's instructions.
5. Unroll the Elevate PVC XR or UltraPly TPO XR membrane sheet and position in place. Fold the sheet in half width wise.
6. The adhesive should be properly mixed in a 1:1 ratio through the attached static mix tip. When properly mixed, there should be no marbling in the adhesive.
7. Apply the adhesive on the substrate in beads spaced at a maximum of 12" (300 mm) on center with a 3/4"- 1" (19 mm – 25.4 mm) wide bead.

Method of Application Continued

8. It is important to allow the adhesive to rise in height. Before a skim coat develops (See Reaction Time section) on the adhesive, mate the XR membrane to the substrate.
9. Immediately after setting the membrane in the XR Stick Adhesive, it is required to thoroughly apply continuous pressure to the bonded membrane using a roller (not to exceed 150 lb). It is important that freshly installed membrane remains in contact with the substrate and XR Stick adhesive until the adhesive sets to ensure proper adhesion.
10. To store previously opened XR Stick containers for an extended period, turn off the pump on the PaceCart 2 and relieve pressure by closing the valves located. Remove and discard the static mixing tip. Apply grease to the PaceCart 2 manifold. Keep Part 1 and Part 2 containers of XR Stick adhesive connected to the PaceCart 2.

Coverage Rate

These typical coverage rates are applicable when the XR Stick adhesive is properly mixed with 1:1 ratio and applied in the appropriate bead spacing in a serpentine pattern at a bead width of 3/4" to 1" (19 mm to 25.4 mm). Coverage rates will vary if the bead spacing is increased. Coverage rate may differ due to substrate type. (On approved, smooth, non-porous surface with a 3/4" to 1" (19-25 mm) wide bead)

Coverage, ft ² /gal (m ² /L)	Bead Spacing	Coverage (ft ² /4 cartridge carton)
170-200 (4.1-4.8)	12" o.c.	270 -317
90-120 (2.2-2.9)	6" o.c.	143 - 190
60-90 (1.4-2.2)	4" o.c.	95 - 143

Reaction Time

When applying XR Stick adhesive, the XR membrane must be placed into the adhesive while it is still wet and tacky (before it reaches tack free state). The membrane may be placed into adhesive shortly after it has reached its maximum rise, typically after 2-3 minutes.

Substrate Temperature	Tack Free* State (minutes)	Set Up (minutes)
40-90 °F (4 - 32 °C)	5	8

* Definition- Tack Free State: The point at which no adhesive will transfer from the surface to a gloved finger upon touching.

Storage

- Store in original unopened containers at temperatures between 60 °F - 80 °F (16 °C - 27 °C) prior to use.
- Do not store in direct sunlight.
- Do not allow to freeze.
- Ship and store product with handle side up and keep caps of nozzle closed tightly. Do not expose to moisture.

Shelf Life

Stored in original unopened containers indoors away from direct sunlight between 60 °F - 80 °F (16 °C - 27 °C), shelf life is 18 months.

Precautions

- Refer to Safety Data Sheets (SDS) for additional safety information.
- Personnel who are sensitive/allergic to isocyanate or polyurethane should not work with XR Stick adhesive.
- At the start and throughout each workday, test samples made with XR Stick adhesive should be created to verify that proper mixing, set-up, and overall adhesion of membrane to substrate is being achieved before proceeding.
- Avoid contact with eyes. Wear safety glasses with side shields.
- Avoid breathing of vapors. A Self-Contained Breathing Apparatus (SCBA) or Respirator should be used in areas of limited ventilation (i.e., confined space).
- Avoid contact with skin. Wear gloves when dispensing. Wash hands thoroughly after handling.
- Use caution when removing caps from cartons.
- Do not burn empty kit containers. Dispose in accordance with local, federal, and state regulations.

LEED® Information

Post-Consumer Recycled Content: 0%
 Post Industrial Recycled Content: 0%
 Manufacturing Location: Rockford, MN



NOTE: LEED® is a registered trademark of the U.S. Green Building Council

Typical Properties		
Properties	Part A	Part B
Composition	Polymeric MDI	Polyurethane Component
Max Ratio (Part A: Part B)	1:1	
Specific Gravity	1.23	1.02
Viscosity	400-600 cps	250-400 cps
V.O.C. Content	≤ 13 grams/Liter	

Packaging Information	
Boxes	Part 1 and Part 2 are each packaged in separate 5-gallon (18.9 L) box container. 18 sets per Pallet
Cartridges	One 1500 ml Cartridge Kit (750 ml Part 1, 750 ml Part 2)
Carton	Each Carton of cartridges contains four-1500 ml Cartridge Kits and includes 4 state mixing tips

Substrates	
Acceptable	NOTE
Structural Concrete (New)	New poured decks must be dry prior to the application of XR Stick.
Structural Concrete (Existing)	
Gypsum Decks Plywood and OSB Lightweight Concrete	Acceptable Lightweight concrete substrates include cellular or air-entrained concrete. Lightweight concrete substrates with aggregate (such as perlite or vermiculite) are not acceptable. Positive adhesive test required.
Existing Asphalt and Modified Bitumen Roofs (Mineral or Smooth Surfaced)	Any residual asphalt must be cleaned and scraped as smooth as possible.
SBS Base Sheets	
Acceptable Insulations	Iso 95+™ GL / ISOGARD™ GL, ISOGARD HD, Resista / ISOGARD CG, HailGard / ISOGARD HG, Dens-Deck® and Dens-Deck Prime, Securock® and Structodek® HD wood fiberboard (maximum 15-year warranty)
Not Acceptable	Existing Single Ply roofs, Coal Tar Pitch, Fiberglass insulation, Perlite insulation, EPS, XPS, Cementitious WoodFiber
NOTE	Existing substrates containing residual asphalt must be cleaned and scraped smooth as possible. The substrate shall be smooth, flat, clean, dry, free of sharp fins, or foreign materials All perimeters, deck seams and all penetrations must be sealed to prevent air infiltration through the deck. Elevate recommends an expanding foam or similar product be used. Dens-Deck is a registered Trademark of Georgia-Pacific. Securock is a registered trademark of USG. Structodek is a registered trademark of Blueridge Fiberboard.

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

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