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# ARDEX WPM 649

## TPO Bonding Adhesive

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Designed for bonding TPO membrane to approved substrates

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# ARDEX WPM 649

## TPO Bonding Adhesive

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### DESCRIPTION

ARDEX WPM 649 TPO Bonding Adhesive is a solvent based contact adhesive designed specifically for bonding ARDEX WPM 615 TPO membranes to approved insulations in addition to wood, metal, masonry and other acceptable substrates.

### PREPARATION

1. Stir the adhesive thoroughly to achieve a uniform mix with no sediment on the bottom and no marbling evident before and during use.
2. Apply ARDEX WPM 649 Bonding Adhesive at about the same time to both the exposed underside of the sheet and the substrate to which it will be adhered so as to allow approximately the same drying time. Apply ARDEX WPM 649 Bonding Adhesive evenly avoiding areas of accumulation.
3. Apply the ARDEX WPM 649 Bonding Adhesive with a solvent resistant paint roller, and roll the adhesive onto the mating surfaces. When applying ARDEX WPM 649 Bonding Adhesive, ensure complete uniform coverage of both surfaces that will be adhered. Care must be taken not to apply Bonding Adhesive over seam areas.
4. ARDEX WPM 649 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 a 230mm wide solvent resistant roller (medium nap) to insure 100% coverage of the adhesive on the substrate and membrane.
5. 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.
6. Starting at the fold, roll the previously coated portion of the sheet into the coated substrate slowly and evenly so as to minimize wrinkles.
7. 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.
8. Contact your ARDEX Technical Services on 1800 224 070 for specific application information.

### COVERAGE

A coverage rate of 1.10 – 1.47m<sup>2</sup> per litre 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. Very porous substrates (rough wood, concrete block) may require two coats of Bonding Adhesive, to ensure proper adhesion. This can be determined by testing a small area. Check by adhering a small piece of membrane to the porous substrate to verify the bonding strength.

## 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 – ¾" 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, ½" x 100' hose, 2" Intake pipe with screen, 5 or 55 gal drum containers, Graco Spray Tips: .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 ½" diameter hose, Up to 200' of dual ½" diameter hose, ¾" Intake pipe with screen, 5 or 55 gal drum containers, Bulk tank containers, Graco Spray Tips: .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 ¼" x 6' whip hose, XTR-7 applicator with XHD821-825 tips.

## PRECAUTIONS

Review applicable Material Safety Data Sheet prior to using. 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 goggles with side shields. Thinning is not allowed. Do not use for splicing. Use only in well ventilated areas. Cover tightly when not in use. Recommended cleaner is Toluene (white fluid).

## TECHNICAL DATA

<b>Base:</b>	A blend of Polychloroprene and SBR rubbers
<b>Colour:</b>	Yellow
<b>Solvents:</b>	A blend of acetone, hexane, toluene and xylene
<b>Viscosity:</b>	3,300 – 3,800 cps, with R.V.F. spindle @ 10 rpm
<b>Weight/Gallon:</b>	6.6 – 7.4 lb/gal
<b>Specific Gravity:</b>	0.7909-0.8868

## PACKAGING/STORAGE/SHELF LIFE

<b>Packaging:</b>	18.9L pail
<b>Storage:</b>	Store in original unopened containers at temperatures between 15 – 25°C.  If exposed to lower temperatures, restore to room temperature prior to use. Do not allow to freeze.
<b>Shelf Life:</b>	12 months if stored in above mentioned conditions. Shelf life will be shortened if exposed to elevated temperatures for a prolonged period of time.

## **GUARANTEE**

ARDEX Australia Pty Ltd (“we” or “us”) guarantees this product (“our goods”) is free from manufacturing defects and will perform to any applicable specification published by us for 10 years from the date of purchase. Our liability under this guarantee is limited at our option to replacement of the product, repair of any damage to the immediate surface or area of application of the product, or compensation, in each case if we are satisfied loss or damage was due to a breach of this guarantee.

This guarantee does not apply if damage or loss is due to failure to follow published instructions or any act or circumstance beyond our control, including shade variations and efflorescence. If you wish to make a claim under this guarantee you must notify us (ARDEX Australia Pty Ltd, 20 Powers Road Seven Hills NSW 2147; Toll Free: 1800 224 070; Email: [techinfo@ardexaustralia.com](mailto:techinfo@ardexaustralia.com)) and provide evidence of your purchase of the product within 30 days of any alleged loss or damage occurring. We reserve the right to ask you for satisfactory evidence of any alleged loss or damage. Any claim under this guarantee is at your cost.

This guarantee is in addition to any rights or remedies you may have as a “consumer” under the Australian Consumer Law and to that extent you need to be aware that: “Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and for compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure”.

### **DISCLAIMER**

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