



## FLEX HE903 MODIFIED BITUMEN ADHESIVE

### PRODUCT DESCRIPTION

Flex HE903 Modified Bitumen Membrane Adhesive is a premium, modified and rubberized, cold process, waterproofing roofing adhesive which contains low solvent content compared with conventional cold applied adhesives. Designed specifically for adhering Flex SBS Modified Bitumen and asphalt coated membranes to properly prepared surfaces.

### FEATURES AND BENEFITS

- High solids fibered formulation is modified with SBS rubber polymer, resulting in a high strength bond when used to adhere Flex SBS Modified Bitumen Membranes and other asphalt based roofing sheets.
- Excellent low temperature flexibility. Roofing can be applied under controlled conditions. The hazard of torch application, as well as hot asphalt fumes and odors, are eliminated.
- Eliminates the hazard of kettle fires around industrial plants.
- Lap strength adhesion properties far exceed the minimum requirements of ASTM D3019.
- It does not require red label solvent identification.
- Low solvent content, thereby eliminating the potential of softening or damaging SBS membranes.
- VOC Compliant.

### PHYSICAL PROPERTIES

Appearance:	Black Fibrous
Asphalt By Weight	45% (ASTM D4479)
Base:	Selected Asphalts
Flash Point:	105° F (ASTM D3278)
Freezability:	Will Not Freeze
Lap Peel Strength:	30 lbf/in. min. (ASTM D3019)
Maximum VOC:	250 g/l
Maximum VOS:	2.08 lbs/gal
Solids By Weight	80% +/- 2% (ASTM D4479)
Specific Gravity @ 77° F (25° C):	1.2
Stormer Viscosity:	60-80 (ASTM D4479)
Weight Per Gallon:	9.9-10.4 (ASTM D1475)

### PACKAGING

5 Gallon Pails:	53 lbs. each
55 Gallon Drums:	527.5 lbs. each

### COVERAGE

100 square feet per 1.5 Gallons

### USES

Flex HE903 Modified Bitumen Adhesive is especially formulated for horizontal applications of roofing plies and Flex SBS Modified Bitumen Membranes. It has many advantages over the use of hot asphalt in applying SBS based Modified Bitumen cap sheets such as its compatibility with SBS and BUR roofing membranes. Flex HE903 Modified Bitumen Adhesive is ready for use as shipped.

## **SURFACE PREPARATION**

All surfaces to be coated must be dry, clean and free from oil, grease, rust, scale, loose paint and dirt. For best adhesion over worn or previously coated surfaces, an application of Asphalt Primer is recommended.

## **APPLICATION**

Stir in container and apply by notched squeegee or commercial grade spray equipment. A notched squeegee with notches 1/4" long, 1/8" deep, spaced on 1" centers, is preferred for smooth surfaces. For irregular surfaces, the notch should be 1/4" deep. Average application rate over smooth surface is 1.5 gal/100 sq. ft. Over porous substrates, the coverage rate will increase to approx. 2 gal/100 sq. ft. **DO NOT OVER APPLY.** Sufficient adhesive should be applied at laps to result in a visible bead of adhesive at completed lap edge. Flex SBS modified bitumen should be cut in maximum 18 foot lengths and membrane allowed to relax on job site. For best results, it is recommended that the end and side laps be rolled with a weighted roller immediately after installation. For cold process assemblies, apply uniformly between layers of roofing plies at the rate of 1.5 to 2 gallons per 100 sq. ft. **DO NOT OVER APPLY.** For spot application of the first layer to smooth, non-nailable surfaces, adhere with 9 inch diameter spot application 18 inches o.c. staggered in two rows.

Flex HE903 Modified Bitumen Adhesive is suitable for spray application using a Garlock Commander with Hot Max spray rig or a Graco 733 spray rig, or similar. The pump must be able to deliver at least 2000 to 3000 psi. The spray tip must be 0.080" or larger, without a breaker bar. O rings should be made from Viton. The hose diameter must be at least 3/4" I.D; the last 50 feet can be 1/2" I.D. For hose lengths longer than 200 feet, 1" I.D. is recommended. The product must be at least 70°F at the tip for spray applications.

## **IMPORTANT**

Flex Modified Bitumen Adhesive does not freeze. Cold weather will cause it to stiffen. Store unopened container in a warm area at least 24 hours before using. Do not thin. Do not use with Modified Bitumen Membranes with polyethylene backing. For use with modified bitumen membranes that are sand backed or do not contain polyethylene or film surfacing.

## **CLEAN-UP**

All equipment can be cleaned with kerosene or mineral spirits. Use care when handling solvents. Clean hands with a waterless hand cleaner.

## **CAUTION**

Keep out of reach of children. For external use only. Combustible. Contains petroleum distillate. Keep away from heat and open flame. Do not heat container or store at temperatures greater than 110°F. **CLOSE AIR INTAKES** on roof until solvents dissipate. Contains volatile solvents that might contaminate potable water. Close container after use. Dispose of container and unused contents in accordance with Local, State and Federal regulations.

Flex Membrane International Corp. maintains Safety Data Sheets on all of its products. Safety Data Sheets should be read and understood by all supervisory personnel and employees before using Flex products in your facilities.