

**Technical Data Sheet**
**PRODUCT DESCRIPTION**

DAT-SB-650 is a premium strength Low VOC solvent-based contact adhesive recommended for bonding EPDM and TPO membranes to various porous and non-porous substrates and can be used on both horizontal and vertical surfaces. It is extremely resistant to high temperatures and forms strong bonds between bonded substrates.

**APPLICATIONS**

DAT-SB-650 comes ready mixed (1 component). It should be applied to both substrates using a medium nap roller and allow the adhesive to dry for 5-20 minutes or until touch dry before applying both substrates together ensuring no air bubbles. Apply even pressure for adhesion. Once dried – bonded material can be reworked or adjusted using a heat gun.

**PRODUCT CHARACTERISTICS**

Appearance	Viscous liquid product
Colour	Yellow
Base	SBR
Solid Content	60-65%
Viscosity	2,500 – 3,000 cps
Coverage	1.5-1.7m <sup>2</sup> /l
Working Time	5 – 20 minutes

**STORAGE AND SHELF LIFE**

Store in well-sealed containers. Keep satisfactorily for at least 12 months. High temperature storage should be avoided and recommend to store within the temperature 4 to 30 c.


**KEY BENEFITS**

- ✓ High Bond Strength
- ✓ Easy Application
- ✓ Low VOC (<230g/l)

**PRIMARY SUBSTRATES**

- ✓ EPDM
- ✓ TPO
- ✓ Insulation and Cover boards
- ✓ Metal
- ✓ Concrete
- ✓ Plywood

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**PREPARATION**

1. The substrates should be clean, dry, free of dust, oil, grease and other contaminants.
2. Any imperfections to the base substrate should be adequately smoothed out with filler and/or sealant.
3. Do not apply to wet or damp surfaces.

**APPLICATION DATA**

Coverage	1.5-1.7m <sup>2</sup> /l, 60-70sq.ft/gal  Refers to area of finished roof. Coverage rates will vary depending on substrate porosity.
Application temp	4°C - 50°C
Working Time	5 - 20 minutes  Dependent on ambient conditions
Drying Time	24 hours to full cure
Cleaning	Clean excess wet adhesive from material and tools with DAT Thinners. Dried adhesive must be cut or scraped away. Clean hands with warm water and soap. DO NOT use solvents to remove product from skin.

**METHOD GUIDE**

1. Before and during use, thoroughly stir the adhesive by hand. Do not use electric drills, and do not thin the adhesive, as this can affect its performance. The adhesive colour should be consistent, with no solids remaining at the bottom.
2. DAT SB-650 is a contact adhesive that needs to dry before the membrane and substrate are joined together. To ensure the adhesive dries at approximately the same rate, apply it to both surfaces in one go. Use a medium nap roller, adhesive dispenser, or spray rig designed for adhesives to apply the bonding adhesive.
3. Position the membrane into place and give it enough time to relax in place.
4. Fold the membrane onto itself to expose the substrate and underside of the membrane. Apply a uniform and consistent coat of adhesive to both surfaces, avoiding puddles and light areas. Do not apply bonding adhesive over areas that will be used to create field or flashing seams.
5. Allow the adhesive to fully dry and become tacky. Use the finger-push method to check the adhesive by applying pressure with a finger while pushing across the adhesive.
6. After adequate drying time, roll the membrane onto the adhesive-coated substrate and immediately brush the membrane with a stiff bristle broom to ensure maximum contact.
7. Bonded material can be reworked or adjusted using a heat gun.

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