

# INSTALLATION INSTRUCTIONS

## DUOTACK® SPF ADHESIVE INSTALLATION INSTRUCTIONS

### DUOTACK SPF ADHESIVE



DUOTACK SPF Adhesive is a low pressure, two component spray polyurethane foam adhesive specially formulated by SOPREMA for adhering SENTINEL HFB PVC membranes to approved substrates as well as a ribbon applied adhesive for adhering approved insulations and coverboards to approved substrates or together.

DUOTACK SPF is available as a complete kit containing both the A & B side components and a hose and nozzle kit, containing a 25" hose and an application gun with 10 replacement nozzles. Operating Instructions are also included in each kit.

Refer to the Operating Instructions for proper storage, conditioning, set-up and application instructions prior to use. All SDS information for both Part A and Part B components should also be reviewed and are available at [www.soprema.us](http://www.soprema.us).

Store product at 50°F - 80°F (10°C - 27°C) in a dry environment and in the original packaging. Do not store in direct sunlight or near heat sources. Prior to use, condition the product so it reaches a temperature between 70°F and 90°F (21°C - 32°C). Conditioning may take up to 24 hours to ensure the chemical has reached optimal application temperatures.

The temperature strip found on the B-side (white) tank indicates when tank surface has reached an appropriate temperature (Red indicates the product is too hot, green is ready to use and blue is too cold). Tanks should be conditioned 24 hours at appropriate temperature after temperature strip reaches green. Always monitor the temperature throughout the application.

### SUBSTRATE PREPARATION

When utilizing DUOTACK SPF Adhesive the bonding surfaces must be clean, dry and free of dirt and debris and other release agents that may affect adhesion.

### APPROVED SUBSTRATES

DUOTACK SPF Adhesive may be applied over the following prepared substrates:

#### Compatible Roof Decks & Substrates

- Structural concrete
- Lightweight insulating concrete
- Gypsum decks
- Steel - minimum 22 gauge
- Wood (plywood or OSB)
- SBS-modified base sheets
- Existing modified bitumen or smooth built-up roof (BUR)

#### Compatible Insulation/Coverboards

- Polyisocyanurate - paper face and coated glass
- High density woodfiber
- Approved gypsum boards
- Securrock®

### FIELD ADHESION TEST

For adhering to an existing modified bitumen or smooth surface BUR, an adhesion test must be performed. Contact your SOPREMA representative for further information and assistance.

### SET UP

#### Tank Set up

Each kit includes an A-side and B-side tank in separate boxes. Attach hose labeled 'A' to the blue A-side tank. Hand tighten to the tank and secure with a wrench. Do not over tighten. Repeat with the other hose on the B-side tank. **Shake both tanks for one minute prior to use.** Open valves slightly. Ensure there are no leaks and if there are, tighten the nut. Once there are no leaks, open the valves fully. Check the flow of chemical from both cylinders by disengaging the safety and pulling the trigger and dispensing into a waste container prior to attaching a nozzle.

### OPERATING THE SYSTEM

Apply a small amount of petroleum jelly to the ring surrounding the face of the gun before attaching the nozzle. Line up the arms of the nozzle with the slots in the gun and push firmly until you hear a click. To remove the nozzle, squeeze the arms and pull the nozzle free. If spraying is stopped for 30 seconds or more, remove and replace the used nozzle before continuing application. If cured foam clogs the nozzle, this can result in spraying off-ratio foam which can have a negative impact on product performance.

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### APPLYING SPF ADHESIVE FOR SENTINAL HFB PVC INSTALLATION

Holding the dispensing gun 3-4 feet above the approved substrate, spray adhesive in an even coverage pattern (approximately 55 - 65 % surface coverage). Applying too much adhesive can result in a decreased coverage rate and applying too little coverage may affect adhesion. Product cure time can range from one to eight minutes pending ambient and substrate temperatures. Do not apply more adhesive than the length of PVC that can be installed within the bonding time frame. Roll PVC membrane into place and immediately broom the membrane into the adhesive then roll the membrane with a 150 lb roller. Protect end laps and selvedge edges of the membrane from overspray during application. Should overspray onto the top (or non-fleece portion) of the membrane occur, clean immediately with approved cleaner..



TOO MUCH



NOT ENOUGH



RIGHT AMOUNT

### APPLYING SPF ADHESIVE FOR INSULATION ADHESIVE

Holding the dispensing gun no further than 2 feet above the approved deck or insulation (multiple layers possible) substrate, spray adhesive in a ribbon application. Ribbon shall be 2.5" wide and spacing will depend on wind up-lift requirement, consult manufacturers recommendations. Maximum spacing for these ribbons is 12 inches o.c., though 6 inches and 4 inches o.c. are used in perimeters and corners, respectively. Once applied, immediately place the insulation/coverboard into the wet adhesive and do not allow the adhesive to skin over. Maintain constant pressure/weight on the boards while DUOTACK SPF Adhesive cures, usually in minutes but may vary depending on environmental conditions.

RIBBON APPLIED APPLICATIONS		
BOARD SIZE	INSULATION	COVERBOARD
4 x 4	Yes	Yes
4 x 8	No	Yes



DUOTACK SPF Adhesive is designed to cover 30 squares as a membrane (spatter) and insulation (ribbon) adhesive. See chart below. Increasing the coverage of the substrate above 55 - 65%, ribbon widths or spacing will decrease coverage rates.

MEMBRANE ADHESIVE (SPATTER)	INSULATION ADHESIVE (RIBBON)
55 - 65% Coverage of Substrate	2.5" Wide Ribbons, 12" O.C.
30 Squares of Coverage	30 Squares of Coverage