

# Product Data Sheet

## SPRAY ADHESIVE

### **Moisture Curing Polyurethane (MCPU) canister adhesive for bonding fleece-backed waterproofing membranes to a wide range of roof substrates**

Axter's high performance Spray Adhesive (supplied in 18.5 kg canisters) provides a secure and professional bond between fleece-backed membranes and the roof substrate, including tissue- and foil-faced insulation board\*.

Spray Adhesive is ideal for both large-scale field work and detailing and the application process is quick and simple, with aesthetically pleasing results. This is a non-foaming adhesive which allows for flat lamination of the membrane, without creasing and wrinkling. Its spray application ensures even coverage and a smooth, consistent finish.

\*Due to the solvent in the adhesive, this product is not suitable for use with EPS insulation however other adhesives suitable for this application are available from Axter.



## Key benefits of Spray Adhesive

- Application four times faster than a standard roller-applied MCPU adhesive.
- Strong bond, resistant to wind uplift
- Economical coverage rate – up to 180m<sup>2</sup> with one canister
- Faster curing time than standard roller-applied MCPU adhesive.
- Excellent temperature resistance (-30 to 150°C) and ageing properties
- Easier, more precise application and reduced wastage due to 3m hose

Minimal Spray Adhesive is required to ensure a strong bond because this is a one-way stick system (adhesive is applied to insulation only). The product has passed rigorous and independent testing at BRE for resistance to wind uplift, using BSI EN 1991-1-4 guidelines (further details are available from Axter Ltd).

## Packaging

Spray Adhesive is supplied in a 18.5kg canister (450mm x 330mm) in a cardboard carry box. Other components required and supplied separately include:

- Applicator (gun and 3m hose)
- Spray tip
- Solvent
- Canister flushing system

A short nose gun suitable for detailing work is also available.

## Coverage rate

Each canister will cover up to 180m<sup>2</sup>. Porous/uneven substrates may require a primer before applying adhesive. Coverage rates will reduce on uneven surfaces.

## Technical Data

<b>Appearance</b>	Pink	<b>Cure time (20°C)</b>	60 minutes
<b>Temperature resistance</b>	-30 to 150°C	<b>Application time</b>	5 to 30°C
<b>Coverage rate</b>	Up to 180m <sup>2</sup> per canister	<b>Storage</b>	5 to 30°C
<b>Open time</b>	10 minutes at 20°C	<b>Health and Safety</b>	Solvent/Flammable/Hazardous See MSDS available from Axter

## Open time and cure time

All information is given as a guideline only. Cure time and open time depend on varying conditions such as temperature, substrate being bonded, application method and weight of product applied. Axter recommends that a test is conducted prior to application.

## Temperature and timings

All information relating to temperatures and timings represent normal working conditions and is provided as a guideline only. However please contact Axter for advice if you wish to operate outside of these parameters.

## Spray Adhesive Canister – Set-up Guide

It is important to set up the Spray Adhesive MCPU canister adhesive (the spray system) correctly before use to ensure the best possible performance and to avoid leakage or system failure.

- 1 Remove the black cap from the canister valve.
- 2 Attach the braided-hose to the canister valve (using the small nut). Tighten with a spanner (image 1).
- 3 Attach the other end of the braided-hose to the spray-gun (using the large nut). Tighten with a spanner (image 2).
- 4 Using the locking-nut provided, attach the spray-tip to the end of the spray gun (image 3). Carefully tighten the spray-tip using a spanner.
- 5 Fully open the valve on the canister.
- 6 Pull the trigger on the spray gun to apply the adhesive.
- 7 Adjust the spray pattern by turning the black valve on the spray gun anti-clockwise until you have a spray pattern approximately 300mm in width (image 4).



Image 1:  
Canister with the braided-hose attached properly.



Image 2:  
Braided-hose and spray gun.



Image 3:  
Attach the spray-tip



Image 4:  
Black valve to adjust spray pattern.

## Spray Adhesive – Guidelines for use

Ensure the insulation board or other roof substrate is dry and clean from grease, dirt and other contaminants before applying the adhesive.

Set up the canister as described in Set-up Guide above.

Mark out the area to be bonded, ensure the fleece-backed membrane is cut to size and in position.

Protect the edge/seam to be welded to prevent it becoming contaminated with adhesive.

Remove any overspray from the surface of the membrane with a dry cloth or Axter Membrane Cleaner.

Ensure the canister spray system is spraying correctly and the spray pattern is 300mm wide. Axter recommends using a test surface prior to application.

Secure the Spray Adhesive canister in a suitable position and apply to the insulation board.

Apply a minimum of two coats of adhesive to the insulation board, ensuring each two metre pass takes a minimum of 10 seconds.

Walk backwards ensuring an even coat of adhesive is applied.

Allow the solvents to evaporate from the adhesive layer for a minimum of five minutes at 20°C (this time will vary depending on climatic conditions).

Roll the fleece-backed membrane into the adhesive layer.

Consolidate the bond using a 20kg water-filled roller.

### Spray Adhesive - Maintenance guide

**Once work is complete, ensure the valve on the canister remains open** (Image 5).

**Failure to do this may cause the adhesive to block the hose.**

Turn the spray gun off by turning the black valve clockwise until it is fully closed.

Unscrew the spray tip and locking nut from the spray gun.

Clean the spray tip and the end of the spray gun with Solvent using a soft nylon brush to ensure that the aperture is clear (image 6). This is essential.

**Failure to clean the spray tip and the end of the spray gun may result in damage to the aperture and prevent the system from working.**

Place the spray tip and locking nut in a container with a small amount of solvent until it is needed again (image 7). Ensure that this container with solvent is closed and airtight.

The canister and gun will remain usable for 2 weeks after opening. If you do not intend to use the system within this time the adhesive in the hose and gun should be renewed by purging approx. 250ml of adhesive through the system every 2 weeks. If the system is not going to be used for longer than 2 weeks, we recommend flushing the gun and hose with the canister Flushing System.

Once the canister is empty the gun/hose can be transferred to a new canister.



Image 5:  
Leave the valve open

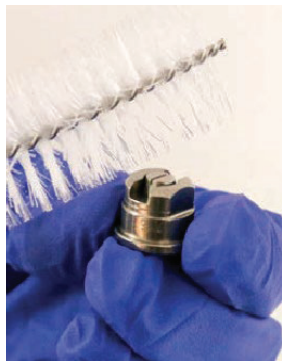


Image 6  
Cleaning the spray tip



Image 7:  
Spray tip in solvent

## Spray Adhesive - Canister Flushing System

Axter supplies the easy-to-use Canister Flushing System which ensures the canister gun and hose remain free from blockages. It consists of the Cleaning Aerosol and the canister assembly (image 8).

Ensure the valve on the canister is completely turned off before attaching the assembly. Unscrew the hose from the canister valve.

Attach the assembly to the valve. Ensure the assembly remains upright whilst you tighten the nut on it (image 9).

Attach the hose to the assembly. Ensure the assembly remains upright whilst you tighten the hose.

Check the tap on the assembly is off before applying the Cleaning Aerosol.

Screw the Cleaning Aerosol into the adaptor (image 10). Turn the tap on the assembly to the 'on' position to release the Cleaning Aerosol into the hose (image 11).

Aiming the gun into a waste container, apply pressure to the trigger on the gun to push the Cleaning Aerosol through the hose and gun until the adhesive starts to dispense. Keep pressure on the trigger until the hose and gun are thoroughly cleaned (image 12).



Image 8:  
Canister assembly



Image 9:  
Tighten the nut



Image 10:  
Screw Cleaning Aerosol  
into the adaptor



Image 11  
Turn the tap on



Image 12:  
Dispense the adhesive

## Emptying, Depressuring and Disposing of your Canister Safely

When depressurised and empty, canisters can be disposed of as scrap metal, in accordance with the European Waste Directive. Please see instructions below on how to empty, depressurise and dispose of your canister safely.

### How to safely empty and depressurise your canister:

Transfer the hose and gun onto a new canister (if you are not using a new canister flush the hose and gun using the flushing system and aerosol) (image 13). Refer to the Set-Up and Maintenance guides above.

Open the valve on the new canister and purge the adhesive/primer through the hose and gun (image 14).

Open the valve at the top of the used canister and empty any remaining adhesive/primer and propellant into a suitable container (image 15).

Ensure the valve remains open. Leave for at least 1 hour.

Locate the bursting disk at the top of the empty canister (image 16).

Use a non-ferrous rod and mallet to strike the bursting disk at its perimeter (see image 17).

Remove the disk, which will reveal an aperture. This will ensure that the canister remains depressurised (image 18).

Leave for 24 hours to allow any residue adhesive/primer to dry and/or cure.



Image 13:  
Connect hose and gun



Image 14:  
Purge the adhesive/primer.



Image 15:  
Open the valve



Image 16:  
Bursting disk



Image 17:  
Pierce disk at perimeter

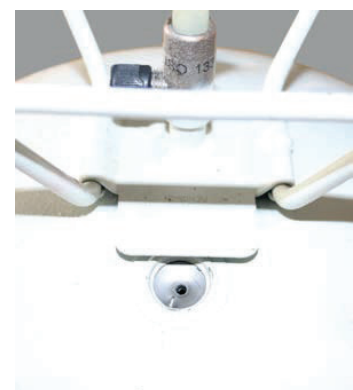


Image 18:  
Aperture

The following information contains the codes you will need to provide to the national or local waste company when disposing of empty depressurised canisters and canisters containing adhesive/primer and compressed gas.

**Disposing of your canister safely and in accordance with national regulations**

After the instructions for emptying and depressurising your canister have been followed, the canister will be empty of any hazardous materials and depressurised.

Therefore, it can be considered as scrap metal in accordance with the national or local waste company, under code **EWC 150104** (empty aerosol, no hazardous residues).

Canisters that are still pressurised and contain adhesive/primer should be disposed of in accordance with the national or local waste company under code **EWC 160504** (full or partially empty aerosol).

**The hazard labels and Material Safety Data Sheet (MSDS) for this product must also be read prior to use. Please contact Axter Ltd for further information.**

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