



TRI-BUILT® Waterborne EPDM/TPO Bonding Adhesive

TRI-BUILT® Waterborne EPDM/TPO Bonding Adhesive is a water-based adhesive formulated to adhere smooth or fleece back EPDM and TPO. It can be applied as a one-side wet installation on roofing surfaces or as a two-side contact application for flashing details.



Features	Benefits
High-strength adhesive	Maintains integrity of installed membrane for years
Excellent adhesive performance	Compatible with a wide range of substrates
Fast application	Labor savings for contractor
Water-based	Easy cleanup and VOC-free

Surface Preparation

All surfaces to be adhered should be thoroughly dry, clean, and free of dust and loose debris. Membranes and substrates should be free of oil, grease, and other contaminants.

Storage

Store in original unopened containers at temperatures between 40°F and 80°F. When stored in cooler temperatures, allow material to warm to room temperature before using. Do not allow material to freeze or be stored in direct sunlight. Rotate stock. Do not use product past 12 month shelf life. Shelf life can be shortened if product is stored in temperatures exceeding recommended storage levels

Equipment

Paint roller or brush

Shelf Life

12 months in unopened packaging and stored at temperatures of 40°F to 80°F

Color

White

Approved Substrates

Wood, brick or block masonry, insulation, cover boards.

Approved Membranes

Smooth or fleece back EPDM and TPO for wet lay in, smooth back only for 2 side applications.

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Application

1. Thoroughly stir the adhesive before and during use. Do not use electric drills to mix the adhesive.
2. Do not thin adhesive. Thinning will affect adhesive performance. The color should be consistent with no solids remaining on the bottom.

Horizontal Surfaces – 1 side wet lay-in

- A. Fold the membrane back on itself so that half of the sheet is exposed.
- B. Apply 1 gallon per 115-125 sq ft of adhesive to the substrate only with a roller. Immediately lay the membrane onto the adhesive while wet. If the adhesive has turned transparent, a thin coat of adhesive must be applied to the membrane before application.
- C. Immediately broom or roll the membrane after it is laid onto the adhesive to ensure intimate contact with the adhesive.

Vertical Surfaces – 2 side dry application

- A. Fold the membrane back on itself so that half of the sheet is exposed.
- B. Apply 1 gallon per 230-250 sq ft of adhesive to each surface for a total applied coverage of 115-125 sq ft of roof per gallon of adhesive.
- C. Wait for the adhesive to turn approximately 50%-75% translucent on both surfaces.
- D. The membrane can then be rolled up the wall. Broom or roll the membrane surface to ensure intimate contact of the membrane to the substrate.

Limitations

Do not apply to wet or damp surfaces. This includes primers. Allow solvent based primers to completely dry before using the adhesive. Do not apply when surface temperatures or membranes are below 40°F (4°C).

Safety

Do not use in a confined spaces. Wear safety glasses or goggles to prevent contact with eyes. Wear gloves that meet ANSI/ISEA 105- 2005 to protect when applying adhesive. Keep out of the reach of children. Read Safety Data Sheet for complete safety information before use.

Packaging & Coverage

Millennium Waterborne EPDM/TPO Bonding Adhesive is available in the following package:

Item	Part #	Pails/Pallet
5 Gallon (18.9 L)		45

- A coverage rate of 115-125 sq ft of finished roof, per gallon, should be expected. For 1-side wet applications this is applied to the substrate only, for 2-side dry application this is split between the substrate and back of the membrane.
- Coverage rates will vary depending upon the type of substrate and substrate surface. Some substrates are more porous and will absorb more adhesive resulting in a lower coverage rate. Other substrates have smooth dense facers resulting in a higher coverage rate. Coverage rates are based on applications using a 3/8 inch paint roller cover.