

ADHESIVE

85-20



Description

ROCKAL Adhesive 85-20 is a high tack, rapid setting water-base adhesive designed for bonding low density & high-density duct liner, duct wrap and fibrous glass insulations to painted or unpainted steel, galvanized or aluminum surfaces. ROCKAL Adhesive is a solvent free, very low VOC synthetic elastomer emulsion. It is non-flammable when wet and fire-resistive when dry. It can be applied to either the metal or the insulation. ROCKAL Adhesive is ideal for bonding fibrous glass insulation to concrete, block and other masonry surfaces in building construction.

Properties

Color:
Off White

Application Consistency:
Brush, Spray & Roller

Average Weight/ US Gallon (ASTM D 1475):
10.8 lbs. (1.29 kg/l)

Average Non- Volatile (ASTM D 2369):
44% by weight

Coverage Range:
(Subject to type of surface and nature of material being bonded.)

For Insulation Attachment:
200 sq. ft./gal. (9 m²/l)
0.008 in. wet film thickness (0.2mm)

For Lap Sealing:

75 sq. ft./gal. (1.8 m²/l)
0.021 in. wet film thickness (0.5mm)
Averages 500 lineal feet (152 m) of 2 in. (5 cm) wide band of adhesive.

Bond Time Range:

For lap sealing:
10 minutes

Service Temperature Limits:
(Temperature at coated surface)
-20°F to 180°F (-29°C to 82°C)

Wet Flammability (ASTM D 93):
No flash to boiling, 98°F (37°C)

Surface Burning Characteristics (ASTM E 84):

Flame Spread: 15
Smoke Developed: 0
Tested at coverage rate of 200 sq. ft./gal. (9 m²/l). Applied to 1/4 inch (6.4 mm) inorganic reinforced cement board. The flame spread may vary at different product thicknesses and/or when applied over other surfaces.

Key Features:

- High Tack
- Quick Setting
- Adhesive is Solvent Free Synthetic Emulsion
Excellent
- Adhesion and Peel Off Strength.
- HVAC High Performance Adhesive
- Non-flammable
- Fire-resistant
- Well adhere insulation to wood and concrete.
- Gives superior service when it is used as
a contact adhesive to cement the laps
of aluminum foil, FSK, ASJ, and FRK
facings.

ROCKAL® Adhesive 85-20 Standards:

- ASTM C 916, Type I (ASC-A- 7001, Type. I)
- MIL-A-3316C, Class 2 grade A test
- meets NFPA 90A and 90B 25/50

Limitations:

Store and apply between 40°F (4°C) and 100°F (38°C). Always test plastic and painted materials for compatibility when using a solvent base product. Do not use with flexible PVC.

Make certain this product is completely dry and the area free from solvent odor if food is involved.

Dilution

Up to 1:1 with water

Application Guide:

Material Preparation:

- Stir well, DO NOT THIN.
- No need to prime aluminum or galvanized metal.
- Apply only to clean, dry, dust-free surfaces.
- Keep container closed when not in use to prevent solvent evaporation.
- Do not use pumps or equipment that have aluminum parts in contact with the adhesive.

Application:

Insulation Attachment:

The metal surface shall be coated by brush with ROCKAL® Adhesive 85-20 at a coverage of 200 sq. ft./gal. (9 m²/l). Allow an open time of 0 to 15 minutes to develop full tack. Install insulation, apply pressure to assure complete and uniform contact to the metal surface.

The above application suggestions do not preclude the use of additional mechanical fastening as recommended by insulation manufacturer or required by design engineer.

Lap, Butt Strip & Pin Patch Sealing:

All longitudinal and butt joint laps of facing shall overlap a minimum of two inches (5 cm). Apply a brush coat of Foster ROCKAL Adhesive at the rate of 75 sq. ft./gal. (1.8 m²/l). Allow an open time of 2 to 10 minutes to develop full tack.

Alternate – Apply a brush coat of Foster ROCKAL Adhesive at the rate of 150 sq. ft./gal. (3.7 m²/l) to each surface. Allow an open time of 2 to 10 minutes to become tacky.

Bond laps by applying uniform pressure, smoothing out to avoid wrinkles and gaps.

Brush:

Use a good brush (suitable for chlorinated solvents), making strokes as long as possible. Do not overwork.

Clean-Up:

Use a chlorinated solvent (non-flammable) or xylol (flammable) to clean brushes and equipment.

**For professional use only. Keep out of reach of children.
Consult Safety Data Sheet and container label for further information.**