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# illbruck OT015

## Paste Adhesive for EPDM Membranes

### KEY BENEFITS

- Ideal for bonding of illbruck FF220 EPDM membranes in facade installations
- Cured adhesive has excellent resistance to weathering and the ageing effects of UV exposure
- Adhesive accommodates a wide fluctuation in temperature from -20 °C up to +80 °C
- Easy, clean, fast and precise application

### PRODUCT INFORMATION

#### Description

illbruck OT015 Paste Adhesive is a specially formulated high tack adhesive.

#### Usage/Purpose

illbruck OT015 is used for bonding illbruck FF220 EPDM Membrane to itself and to typical construction substrates such as aluminium, metal, zinc plated metal, wood, PVC-U, and other non-porous materials. The resultant connection provides excellent resistance to ageing, temperature changes and is waterproof.

#### LIMITATIONS

Solvents contained within the adhesive may damage sensitive surfaces. The adhesive is not suitable for direct application onto polystyrene, PVC, asphalt or bitumen.

#### Colour

Black

#### Packaging

600 ml sausage

#### Availability

Direct from Tremco illbruck (see back of leaflet for address and telephone details).

### USAGE GUIDELINES

#### Necessary Tools

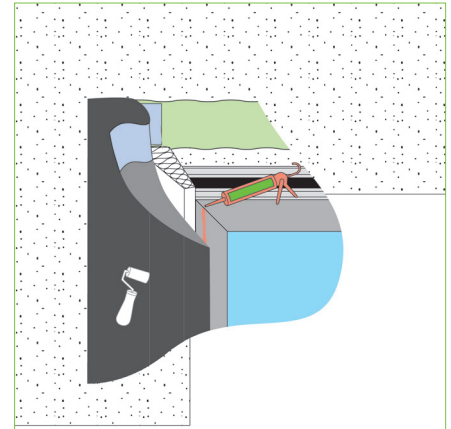
Installation requires the use of an application gun and cutter or scraper.

#### Preparation

- Always carry out a test to confirm compatibility prior to use.
- All surfaces must be dry, clean and sound, free from dirt, grease and other contamination.
- It is recommended to degrease the substrate (and membrane if necessary) by using isopropanol.
- Porous substrates should be sealed by priming with illbruck CT113, or bonded directly using illbruck CT113.

#### Application

- A 10 mm bead of adhesive should be applied to the substrate at a suitable distance, such that the compressed bead width is retained behind the membrane and close to the leading edge (see Fig).
- Use a seam roller to ensure a good bond between the two materials. Final width of the bond should be between 30 – 35 mm x 2 mm deep.
- When bonding wider or longer sections of the membrane, temporary fixing may be required until sufficient adhesive loading capacity is achieved.



Application of illbruck OT015 High Tack Adhesive

- Bonding strength is dependant on solvent evaporation from the system. Drying can be accelerated by lifting the membrane after initial contact of the bond and allowing the solvent to flash off for a few seconds before remaking the bond.
- Connections of membranes to asphalt or PVC hydro - insulation foils must be made with a metal cover plate. In the case of bonding between membrane and styrene foam, use solvent free paste adhesive illbruck MS020.

#### Coverage

A 600 ml sausage will produce 7 to 8 linear meters of adhesive (based on a bead width of approx. 10 mm).

#### Cleaning

Clean tools and any uncured adhesive with Tremco AW421 Heavy Duty Cleaner. Cured adhesive can only be removed mechanically.

#### Storage

Store in dry shaded conditions between +5 °C and +30 °C.

## TECHNICAL INFORMATION

	Test Method	Result
Composition		synthetic rubber-based polymer
Curing System		physical drying
Volume density	at 20 °C	1 g/cm <sup>3</sup>
Tack-free time		approx. 10 minutes
Drying time	+20 °C and 60 % RH	2 – 4 mm / 24 hours
Temperature resistance		-20 °C to +80 °C
Peel strength to FF220 EPDM Membrane		> 75 N / 25 mm
Application temperature		+5 °C to +30 °C

### Shelf Life

12 months when stored as recommended in original unopened packaging.

### Health and Safety Precautions

Keep out of the reach of children. Avoid any contact with the eyes and skin. Refer to the Safety Data Sheet for further details. Do not smoke when using the adhesive, and use only in well ventilated areas.

### Technical Service

Tremco illbruck has a team of experienced Technical Sales Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please call Customer Services on 0191 419 0505.

### Guarantee / Warranty

Tremco illbruck products are manufactured to rigid standards of quality. Any product which has been applied (a) in accordance with Tremco illbruck written instructions and (b) in any application recommended by Tremco illbruck, but which is proved to be defective, will be replaced free of charge.

No liability can be accepted for the information provided in this leaflet although it is published in good faith and believed to be correct.

Tremco illbruck Limited reserves the right to alter product specifications without prior notice, in line with Company policy of continuous development and improvement.