

Low-VOC Bonding Adhesive 1168

Use with EPDM & TPO Systems

Overview

Henry Low-VOC Bonding Adhesive 1168 is a high-strength, solvent-based contact adhesive that allows bonding of Henry EPDM and TPO Membranes to various porous and non-porous substrates. Low-VOC Bonding Adhesive 1168 meets the < 250 gpl VOC content requirements of the OTC Model Rule for Single-Ply Roofing Adhesives. Low-VOC Bonding Adhesive 1168 is compatible with polyisocyanurate insulation, structural and lightweight concrete, plywood, oriented strand board, wood fiberboard, SECUROCK®, gypsum, masonry, smooth BUR, mineral cap sheet, smooth modified bitumen and various metal finishes. Low-VOC Bonding Adhesive 1168 is easily applied with a 9" (73 mm) medium nap roller to create a strong adhesive bond between the membrane and substrate.

Low-VOC Bonding Adhesive 1168 complies with the following California counties' VOC regulations: Alameda, Contra Costa, El Dorado, Los Angeles, Marin, Napa, Orange, Riverside, Sacramento, San Bernardino, San Diego, San Francisco, San Mateo, Santa Clara, Solano, Sonoma and Tehama.

Features and Benefits

- High-strength adhesive that enables quick bonding
- Easily applied with a medium nap roller
- Excellent adhesion between various substrates and membranes

Mixing

Stir thoroughly until all settled pigments are dispersed and Low-VOC Bonding Adhesive 1168 is uniform in color. Minimum 5 minutes stirring is recommended.

Coverage Rate

60 ft² (5.6 m²) per gallon of finished surface. Coverage rate may vary due to conditions on the jobsite. Porous surfaces, especially walls, and substrates may require more Low-VOC Bonding Adhesive 1168.

Application

1. The surface on or against which Low-VOC Bonding Adhesive 1168 is to be applied shall be clean, smooth, dry and free of fins, sharp edges, loose and foreign materials, oil and grease. Depressions greater than ¼" (6 mm) should be feathered using epoxy, mortar or other approved patching material. All sharp projections shall be removed by sweeping, blowing or vacuum cleaning.
2. [After thorough stirring (minimum 5 minutes)], apply Low-VOC Bonding Adhesive 1168 to substrate and membrane using a 9" (228 mm) medium nap roller. Application shall be continuous and uniform, avoiding globs or puddles. An open time of 5 to 90 minutes, based on drying conditions, is recommended before assembly. Low-VOC Bonding Adhesive 1168 must be allowed to dry until it does not string or stick to a dry finger touch. Any coated area, which has been exposed to rain, should be allowed to dry and then recoated. Do not apply Low-VOC Bonding Adhesive 1168 to splice areas or use in conjunction with Henry pressure sensitive tape products.
3. Roll the membrane onto the adhesive-coated substrate while avoiding wrinkles. Immediately brush down the bonded portion of the sheet with a soft bristle push broom to achieve maximum contact. In some applications, swelling of the membrane may occur initially, but this will disappear after several days of exposure. Do not re-broom membrane in an attempt to remove swelling.

Low-VOC Bonding Adhesive 1168 may be slightly thicker than standard adhesives and may require longer drying time.

Precautions

1. Review the applicable Safety Data Sheet for complete safety information prior to use.
2. Low-VOC Bonding Adhesive 1168 must be stored in original unopened containers at temperatures between 60°F (15°C) and 90°F (32°C). Jobsite storage in excess of 90°F (32°C) may affect product shelf life. Prolonged exposure to below freezing temperatures will cause Low-VOC Bonding Adhesive 1168 to thicken and solidify in the can. Should Low-VOC Bonding

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Adhesive 1168 be stored at temperatures lower than 25°F (-4°C), restore to room temperature for a minimum of 24 hours prior to use. Low-VOC Bonding Adhesive 1168 will perform as intended once it is returned to a liquid state. When temperatures are expected to be consistently below 40°F, a heated enclosure or hot box is required for storage.

- Low-VOC Bonding Adhesive 1168 is EXTREMELY FLAMMABLE. It contains solvents that are dangerous fire and explosion hazards when exposed to heat, flame or sparks. Do not smoke while applying. Do not use in a confined or unventilated area. Vapors are heavier than air and may travel along ground or may be moved by ventilation and ignited by pilot lights, other flames, sparks, heaters, smoking, electrical motors, static discharge, or other ignition sources at locations distant from material handling point and flashback. All containers should be grounded when material is transferred from one container to another. A red caution label is required when shipping. A fire extinguisher should be available. In case of fire, use water spray, foam, dry chemical or carbon dioxide. Do not use a solid stream of water because it can scatter and spread the fire.
- Avoid breathing vapors. Keep container closed when not in use. Use with adequate ventilation. If inhaled, remove to fresh air. If not breathing, perform artificial respiration. If breathing is difficult, give oxygen. Call a physician immediately. During application, efforts must be made to prevent fumes from entering the building via air ventilation ducts. Do not place open containers or mix adhesive near fresh-air intake units. When possible, shut down or seal off the closest units.
- If swallowed, DO NOT INDUCE VOMITING. Call a physician immediately.
- Avoid contact with eyes. Safety glasses or goggles are recommended. If splashed in eyes, immediately flush eyes with plenty of clean water for at least 15 minutes. Contact a physician immediately.
- Avoid contact with skin. Wash hands thoroughly after handling. In case of contact with skin, thoroughly wash affected area with soap and water. Contact physician if irritation persists.

Note: Permeation-resistant gloves (that meet ANSI/ISEA 105-2005) are recommended to be worn when using this product to protect hands from irritating ingredients.

- Do not thin Low-VOC Bonding Adhesive 1168. Thinning will affect performance. Excessively thick or gelled material should be discarded.
- Opened containers of Low-VOC Bonding Adhesive 1168 should be used within 48 hours. Low-VOC Bonding Adhesive 1168 will begin to thicken after this point, making it difficult, and eventually impossible, to control applied thickness. In hot weather, do not leave sealed containers on roof for prolonged periods of time. In cold weather, keep material at room temperature until ready to use. Stir Low-VOC Bonding Adhesive 1168 occasionally while using.
- Low-VOC Bonding Adhesive 1168 must be allowed to dry thoroughly. If membrane is mated with the substrate prior to Low-VOC Bonding Adhesive 1168 being dry, blistering will occur.
- KEEP OUT OF THE REACH OF CHILDREN.

Typical Properties and Characteristics

Property	Results
Size	5-gal (18.93 L) pail
Base	Synthetic rubber
Color	Yellow
Solids	21%
Flash Point	0°F (-17°C) closed cup
Brookfield Viscosity	5,000 centipoises
Average Net Weight	10.5 lbs/gal (1.3 Kg/L)
Shelf Life	12 months

Typical properties and characteristics are based on samples tested and are not guaranteed for all samples of this product. This data and information is intended as a guide and does not reflect the specification range for any particular property of this product.

For more information, visit www.henry.com or for technical assistance call us at 800-486-1278. Refer to the Safety Data Sheet prior to using this product. The Safety Data Sheet is available at www.henry.com or by emailing Henry Product Support at productsupport@henry.com or by calling 800-486-1278.

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336 Cold Stream Rd • Kimberton, PA 19460 • productsupport@henry.com • 800-486-1278

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