



ROP605 Two-Part ESD Epoxy

Description: ROP605 Two-Part ESD Epoxy is recommended for the interior installations of Roppe's ESD Static Control Solid Vinyl Tile. ROP605 is a non-flammable, high performance epoxy adhesive for installations over properly prepared concrete, wood underlayment, ceramic tile, metal and Cementitious Terrazzo on grade, below grade, or above grade. **Caution:** ROP605 Two-Part Epoxy must be used in areas subjected to rolling loads, lateral shear stress and over non-porous substrates including but not limited to metal.

Sizes: Available in quarts and gallon containers.

Installation Temperature Ranges: The installation area, substrate, flooring, associated material and adhesive are to be maintained between 65°F (19°C) and 85°F(30°C) for at least 48 hours before installation, during installation, and thereafter. Room temperature must be maintained between 65° F (19°C) and 85°F (30°C) thereafter to prevent adhesive failure and to prevent distortion or destruction of flooring. In addition, the subfloors temperature range must also be between 65°F (19°C) and 85°F (30°C) prior to installation, during installation and maintained thereafter.

Color: Black when mixed.

Shelf Life: Shelf life is one year stored at 70° F (21°C) in an unopened container stored at indoor room temperature.

Freeze Thaw Stability: The adhesive is freeze/thaw stable to 5 cycles at 0° F (-18°C); however, it is recommended to protect all adhesive products from freezing. If frozen, **DO NOT** stir until material has completely thawed.

Clean-Up: Any adhesive on the surface of the flooring or surrounding area must be removed immediately with a clean cloth dampened with denatured alcohol or mineral spirits. **DO NOT** allow the adhesive to cure on the surface of material.

Use: Interior installations of Roppe ESD Static Control Solid Vinyl Tile only.

Calculated VOC's: Roppe ROP605 Two-Part ESD Epoxy Calculated VOC's according to California SCAQMD Rule #1168: Part A: 9 grams per liter of coating. Roppe ROP605 Part B: 59 grams per liter of coating.

ROP605 Qualifications: Meets California SCAQMD Rule #1168.

Recommended Substrates: For indoor installations over properly prepared concrete, wood underlayment, ceramic tile, metal and Cementitious Terrazzo on grade, below grade, or above grade. **Caution:** ROP605 Two-Part Epoxy must be used in areas subjected to rolling loads, lateral shear stress and over non-porous substrates noted. See Individual Product 10-Part Specification Sheet for complete details, cautions and warnings.

Limitations: **Do not** use over flexing substrates. There is to be no foot traffic for 48 hours. There is to be no rolling loads nor maintenance performed on the floor for at least 72 hours after installation. **Do not** use outdoors. Recommended for Roppe's ESD Static Control Solid Vinyl Tile only. **DO NOT** mix partial units of this adhesive, the "A" & "B" parts are pre-weighed for proper mix ratio. **Do not** use over existing floor-covering. **Do not** heat weld until at least 24 hours after installation

Caution: There is to be no foot traffic for 48 hours, and no rolling loads or maintenance performed for at least 72 hours after installation. Immediately remove excessive wet adhesive with a soft, clean cloth dampened with denatured alcohol or mineral spirits. **Do not** allow adhesive to dry on flooring, tools or surrounding areas, since it can not be removed. **Cautions:** When installing flooring, either use a kneeling board, or for best results, work off the flooring to avoid shifting, adhesive displacement & adhesive telegraphing. Remove wet adhesive immediately. **Do not** allow adhesive to dry on the flooring, tools or surrounding areas since it may be impossible to remove. **Do not** allow adhesive to dry or skin-over which will result in either none or inadequate adhesive transfer resulting in an installation failure. All flooring must be properly rolled and re-rolled to ensure proper adhesive transfer.

Subfloor/Substrate Inspection and Preparation: All subfloors/substrates must be inspected prior to installation. All substrates must be clean, smooth, permanently dry, flat, and structurally sound. The substrate must be free of moisture, dust, sealers, primers, paint, oxidation, curing compounds, parting agents, residual adhesives, adhesive removers, hardeners, resinous compounds, solvents, wax, oil, grease, asphalt, gypsum compounds, alkaline salts, excessive carbonation or laitance, mold, mildew, any other extraneous coatings, films, materials and all other foreign matter which might interfere/restrict proper adhesive bonding. **DO NOT** use sweeping compounds, solvents, citrus adhesive removers, or acid etching to clean the substrate. **DO NOT** install flooring over gypsum-based or plaster based leveling or patching compounds. **DO NOT** install new floor covering over old floor covering, as the old floor covering may not be adequately bonded, hide possible structural defects, or cause plasticizer migration into the new flooring. In renovation or remodel work, remove all existing* adhesive residue so that 100% of the overall area of the original subfloor/substrate is exposed. Follow The Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesive, and all applicable industry, local, state, and federal standards. Care must be taken to analyze the conditions and correct any problems prior to installation. Follow the manufacturer's recommendations for any patching or underlayment materials, excluding gypsum based or plaster based levelers or patching compounds.

*Some previous manufactured asphaltic "cutback" contained asbestos. For removal instructions, refer to the Resilient Floor Covering Institute's publication "Recommended Work Practices for Removal of Resilient Floor Covering".

Concrete Substrates: Concrete substrates on all Grade Levels must be tested in accordance with ASTM F 1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride or ASTM F 2170 Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs using *in situ* Probes to quantitatively determine the amount of moisture vapor emission at least one week prior to the installation. **Caution:** ASTM F 1869 or ASTM F 2170 tests cannot predict long-term moisture conditions of concrete slabs. Moisture testing only indicates moisture conditions at the time the tests are performed. Before conducting ASTM F 1869 or ASTM F 2170 test, the installation area must be maintained between for 65° F (19°C) and 85° F (30°C) or at least 48 hours prior to testing, during testing and thereafter. In addition, the concrete's temperature range must also be identical to that of the installation area. Conduct three tests for the first 1,000 sq. ft. and one additional test for each 1,000 sq. ft. or fraction thereof per grade level (on, below or above grade). The Vapor Emission Rate shall not exceed 5.0 lbs and Relative Humidity Test shall not exceed 75% when using ROP605. A pH test must be performed to test for excessive alkalinity using a pH pencil or litmus paper and deionized water. A scaly, sandy, or powdery surface is an indication of some form of contaminant, usually excessive alkalis or an alkali-silica residue. A pH reading higher than 8 is an indication of a potential problem and the concrete must be neutralized by rinsing with clear water. Apply clear water with a mop and allow to dry. Re-rinse with clear water, allow to dry and retest to ensure pH level is within acceptable range of 5 to 8 on the pH scale. Continue to neutralize until the pH level is acceptable.

Metal Floors: Metal floors to be used as subfloors/substrates must be thoroughly cleaned of any residue, oil, paint, sealer, rust, and oxidation and properly sanded/ground to provide a smooth, level, clean substrate to receive stair treads and flooring. Care must be taken to remove all residue resulting from the sanding/grinding operation prior to application of the adhesive. Metal floors and other substrates can only be slightly flexing. **Do not** install over extremely flexing

substrates. The flooring must be installed within 12 hours after sanding/grinding to prevent the metal from re-oxidizing. The metal subfloor shall be structurally sound. Deflection of the metal can cause a bond failure between the adhesive and metal substrate. It is the contractor's responsibility to decide the feasibility of the application, and Roppe Corporation will not be held liable for failures caused by flexing or deterioration of metal substrates. **Caution:** The installation of flooring material will not prevent deterioration of metal substrates from occurring.

Wood Subfloors: Wood subfloors to be used as subfloors/substrates are to follow the procedures recommended for Subfloor/Substrate Inspection and Preparation (see above). Wood subfloors should be of double layer construction with a minimum thickness of 1". Crawl spaces underneath wood subfloors shall be in compliance with local building code ventilation practices and have clearance of at least 18" of cross-ventilated space between the ground level and joists. Wood joists should be spaced on no more than 16" centers. Place a moisture retarder; having a maximum rating of 1.0 perm, on the top of the ground under the wood subfloor overlapped at least 8". APA, The Engineered Wood Association, Underlayment Grade plywood, minimum 3/8" thick, with a fully sanded face is to be used. Use APA approved exterior grade plywood if finished floors are subjected to moisture. OSB, lauan, maranti, solid-core mahogany, waferboard, particleboard, chipboard, flakeboard, tempered hardboard, glass mesh mortar units or cementitious tile backer boards, sheathing-grade plywood, preservative-treated plywood, or fire-retardant treated plywood are not recommended as some manufacturers may use resins or other adhesives in the manufacturing of the product that may cause discoloration or staining of the flooring. Wood subfloor movement, flexing or instability will cause the flooring installed to release, buckle or become distorted. **Do not** proceed with the installation until corrective measures have been made. The warranties, performance, installation, and use are the responsibility of the manufacturer and/or contractor. **DO NOT** use plastic or resin filler to patch cracks. **DO NOT** use cement or rosin coated nails or staples or solvent-based construction adhesive to adhere the plywood. Installation on a sleeper, a wood subfloor system constructed over the top of concrete, is not recommended. Installation directly over Sturd-I-Floor panels is not recommended. All wood subfloors, single construction plywood floors, single and/or double tongue-and-groove strip floors, and wood plank floors must be prepared to receive resilient flooring in accordance with federal and industry standards. Follow the recommendations of the APA, The Engineered Wood Association, *Design/Construction Guide, Residential and Commercial*, and ASTM F 1482, *Standard Guide to Wood Underlayment Products Available for Use Under Resilient Flooring*, for the installation and proper construction of the panels to receive resilient flooring. It is the contractor's responsibility to determine if the subfloor is acceptable to receive the flooring.

Cementitious Terrazzo and Ceramic Floors: Cementitious Terrazzo and ceramic floors to be used as subfloors/substrates are to follow the procedures recommended for concrete (see above). Ceramic tile must be solidly adhered and all loose tiles must be removed and repaired or replaced. Ensure all glazed, sealed, smooth, and/or shiny surfaces are properly sanded and cleaned. Fill all grout lines and other irregularities with a manufacturer's recommended Portland cement-based underlayment with a minimum compressive strength of 3500 psi. The subfloor must be structurally sound. Inspect and ensure there is an adequate bond of the old flooring to the original substrate. Do not install over epoxy based terrazzo. Cementitious terrazzo must first be sanded to remove all finishes, and then cleaned. Conduct a bond test with adhesive to ensure a successful bond can be achieved before installing. Roppe **will not** warranty the product if there is a bond failure caused by problems relating to the old flooring.

Mixing: Mixing Required. DO NOT mix partial units of this adhesive, because the ratio of Part A to Part B is not 1:1. Roppe ROP605 Two-Part ESD Epoxy Adhesive is packaged in two separate containers marked Part A (epoxy resin) and Part B (polyamide resin, hardener). Remove the lids and add all of **Part B into Part A**. Then Turn Part "B" upside down and fully drain adhesive into Part A. Mix the combined parts using a rotary motion while at the same time lifting from the bottom. A slow speed, 200 RPM maximum, drill with an attached mixing paddle may also be used. **Mix 3 minutes**. After mixing, there must be no streaking of adhesive which must be one consistent solid color. **DO NOT** pour the Parts A&B onto the subfloor and attempt to mix on the floor. **Caution:** Higher mixing speeds and/or longer mixing time will reduce the open time and can cause premature curing of the adhesive; however, if not mixed long enough, the

adhesive will not properly cure. **DO NOT** allow the mixed epoxy adhesive to stand in the container. **Immediately** after mixing, pour the contents onto the substrate.

Application: Spread coverage using the 1/32" deep x 1/16" open x 1/32" square notch trowel provided is approximately 150 square feet on smooth, steel troweled concrete or a non-porous substrate. Over porous or rough substrates, a 1/16" x 1/16" x 1/16" flat "V" notch trowel is required. The spread rate for this trowel is approximately 125 square feet. Coverage will vary according to the type of surface, surface texture, spreading angle, and adhesive temperature. At least 90% transfer to the products backing is required. Starting at the center, slowly roll and cross roll with a 100-pound 3-section roller. Re-roll flooring 30 minutes after initial rolling. The rolling time may need to be adjusted to climatic conditions. Use a hand roller in areas that cannot be reached with the larger roller.

Warning: Follow all local, state, and federal standards and practices for the proper removal and disposal of flooring, adhesives, or other materials. Follow all local, state, federal, and manufacturer's safety standards for the use of all products and equipment.

* **Notice:** This document is intended as a general guide only. Therefore, refer to Individual Product 10-Part Specification Sheet for complete details, cautions and warnings.

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