

## TECHNICAL INFORMATION SHEET

### Splice Adhesive SA-1065 (for flashing)



**Item Description**

1-Gallon Pail  
3-Gallon Pail

**Item Number**

W563587058  
W563587059

### Product Information

#### Description:

Firestone Splice Adhesive (SA-1065) is designed for splicing RubberGard™ membrane flashing, FormFlash™ flashing, and the attachment of field membrane panels to Reinforced Perimeter Fastening Strips, and to metal surfaces as specified in the Firestone RubberGard Specifications. It is also used as a primer at seam edges for Lap Sealant application.

#### Method of Application:

1. Position the membrane to overlap the distance specified along the entire length of the flashing splice. Fold the top sheet back to allow for cleaning of both splicing surfaces that will receive Splice Adhesive.
2. Clean the surfaces to receive SA-1065 using clean cotton cloths soaked with Firestone Splice Wash. Allow to dry. Additional cleaning may be required to assure that the membrane is completely cleaned (*More attention should be given to cleaning the areas at factory seams*). Discard soiled cotton cloths and replace with clean ones to assure proper cleaning. Proper cleaning is achieved when the membrane surface is dark gray in color and no streaking is evident. Alternatively, seam areas may be prepared with Single-Ply QuickPrime™ primer, Single-Ply LVOC Primer, QuickPrime Plus LVOC or QuickPrime Plus primer using QuickScrubber™ or QuickScrubber Plus pads per Firestone Specifications.
3. Thoroughly stir Firestone Splice Adhesive SA-1065 to achieve a uniform mix with no sediment on the bottom and no marbling evident before and during use.
4. Apply the Splice Adhesive using Firestone Splice Adhesive Brush (Item #W563582040) 3" (76 mm) or 4" (102 mm) wide by ½" (12.7 mm) thick, solvent-resistant paint brush in a heavy, even, smooth coat with long painting type strokes such that brush marks bleed out, yielding a smooth, glossy adhesive surface.
  - **DO NOT USE CIRCULAR MOTIONS FOR APPLYING SPLICE ADHESIVE.**
  - **DO NOT USE PAINT ROLLERS, SPRAY EQUIPMENT, OR MECHANICAL EQUIPMENT FOR THE APPLICATION OF SPLICE ADHESIVE.**
  - **DO NOT APPLY SPLICE ADHESIVE WITH A BRUSH ATTACHED TO A LONG HANDLE.**
5. Both mating surfaces should have Splice Adhesive applied at about the same time to allow approximately the same flash-off time. (Make one short backstroke at each field and factory cross seam to deposit extra adhesive at the step-off.)
6. Allow the solvents in the Splice Adhesive to flash off. Touch the adhesive surface in the middle of the area to be spliced with a clean, dry finger to be certain that the adhesive does not stick or string. As you touch the adhesive, push straight down to check for stringing; also push forward on the adhesive at an angle to ensure that the adhesive is ready throughout its thickness. If either motion exposes wet or stringy adhesive when the finger is lifted, then it is not ready for mating and the seam should not be closed. Flash-off time will vary depending on ambient air conditions.
7. Once the adhesive has dried per the "touch-push" test, roll the top sheet toward the lap area until the adhesive-coated area nearly touches the adhesive on the bottom sheet along the entire length of the lap. Allow the top sheet to fall freely onto the bottom sheet so as not to stretch or wrinkle the membrane.

# TECHNICAL INFORMATION SHEET

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### Method of Application Continued:

8. Apply pressure to completely mate the two surfaces. Roll the entire lap splice using a Firestone QuickSeam™ Silicone Roller 1⅜" (35 mm) diameter x 1¼" (44.5 mm) wide (Item #W563582023) with positive pressure towards the outside edge of the lap, then along the entire length of the lap, being careful not to damage the flashing.
9. Apply Seam Edge Treatment in accordance with Firestone Specification and Details.
10. Contact your Firestone Building Systems Advisor at 1-800-428-4511 for specific application information.

### Storage:

- Store in original unopened cartons at temperatures between 60 °F (15.6 °C) and 80 °F (26.7 °C) until ready for use.
- During hot weather, do not expose to sunlight/elevated temperatures until use.
- For optimum results, rotate stock to ensure stored material will not go beyond the shelf life of one year.

### Shelf Life:

- Shelf life of twelve (12) months can be expected if stored in original sealed container at temperatures between 60 °F (15.6 °C) and 80 °F (26.7 °C).
- Shelf life will be shortened if exposed to elevated temperatures.

### Coverage Rate:

Width of Finished Splice	Approx Width of Actual Adhesive Application, One Substrate	Completed Flashing Seam per Gallon, Both Substrates Included
3" (76 mm)	4" (102 mm)	150' (45.7 m)
4" (102 mm)	5" (127 mm)	120' (36.6 m)

### Packaging:

- 3-gal (11.4 L) pail; about 24 lb (10.9 kg)
- 1-gal (3.8 L) pail; about 8 lb (3.6 kg); 4 1-gal pails per carton

### Precautions:

- Review Safety Data Sheet prior to use.
- Flammable. Keep away from fire and open flames. Do not smoke when using.
- Avoid prolonged contact with skin. Gloves should be worn (OSHA approved).
- Use only in well ventilated areas.
- Do not contaminate with foreign materials.
- After can has been opened once and closed, use remainder of adhesive within one week.
- Cover can when not in use. When applying adhesive, work out of small pails with a cover to minimize skimming of adhesive.
- When exposed to lower temperatures, restore to room temperature prior to use.
- Thinning is not allowed.
- Recommended cleaner is Firestone Splice Wash (while the Splice Adhesive is fluid).

# TECHNICAL INFORMATION SHEET

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### LEED® Information:

Post-Consumer Recycled Content: 0%  
 Post Industrial Recycled Content: 0%  
 Manufacturing Location: South Bend, IN  
 \*NOTE: LEED® is a registered trademark of the U.S. Green Building Council.



### Typical Properties

<u>Property</u>	<u>Typical Property</u>
Base:	Synthetic Polymers
Color:	Black
Solvents:	Hexane, Toluene, Xylene
Solids:	26% Minimum
Viscosity:	2900-3700 Centipoise, R.V.F. #3 Spindle @ 10RPM
Weight:	7.35 ± .37 lb/gal (.88 ± 40 g/L)
Specified Gravity:	0.876 ± 5%
V.O.C. Content:	5.13 lb/gal (615 g/L)

Please contact Firestone Technical Services Department at 1-800-428-4511 for further information.

*This sheet is meant to highlight Firestone products and specifications and is subject to change without notice. Firestone takes responsibility for furnishing quality materials which meet published Firestone product specifications. Neither Firestone nor its representatives practice architecture. Firestone offers no opinion on and expressly disclaims any responsibility for the soundness of any structure. Firestone accepts no liability for structural failure or resultant damages. Consult a competent structural engineer prior to installation if the structural soundness or structural ability to properly support a planned installation is in question. No Firestone representative is authorized to vary this disclaimer.*