

LEXCAN

HI-FLEX EPDM

SA-747 Splice Adhesive

DESCRIPTION & USE

Lexcan Hi-Flex EPDM SA-747 Splice Adhesive is a butyl based adhesive used in the seaming of EPDM membranes and the adhering of EPDM flashing products to EPDM membrane and metal surfaces. Hi-Flex EPDM SA-747 may be used to adhere all of the following seaming and flashing products:

- Hi-Flex EPDM T-325 Seam Tape
- Hi-Flex EPDM T-610 Overlay Tape
- Hi-Flex EPDM LexFlash II Flashings, including pre-cut T-Joint Covers & Corners
- Hi-Flex EPDM Pipe Boots
- Hi-Flex EPDM Molded Sealant Pockets
- Lexcan B.U.R. Tie-In Flashing

FEATURES & BENEFITS

- **Super Strong Bond** - Using Hi-Flex EPDM SA-747 in conjunction with a seam tape or pressure sensitive flashing provides the strongest EPDM bond available. Peel strengths are up to 66% higher and shear strengths are up to 32% higher than some 'primer and tape' systems.
- **Superior Performance in Cold Temperatures** - Hi-Flex EPDM SA-747 provides superior initial tack strength in seams and flashing joints. This is particularly important in cold temperature applications.
- **Proven Performance** - Lexcan's "LexSeam" adhesive and tape seaming system has been in use since Lexcan invented EPDM roofing back in the early 1960's. Thousands of kilometers of LexSeam seams continue to perform flawlessly, year after year.

TECHNICAL DATA

Physical Properties	
Base:	Butyl
Colour:	Black
Solids:	22.5%, ±2%
Brookfield Viscosity:	2750 Centipoises ±1250
Flash Point:	< -17°C (0°F)
Shelf Life:	9 months
Weight:	7.1 lbs / gallon
Packaging:	3.8 litre (one gallon) cans; 6 / case



Coverage Rates

All coverage rates are approximate and dependent on job-site conditions. Rates are net coverage rates based on application to both mating surfaces.

General (Flashing) 150 - 200 Linear Feet,
3" Wide Splice

CAUTIONS & LIMITATIONS

- Hi-Flex EPDM SA-747 is flammable and must be kept away from heat, flame, sparks and other ignition sources during storage and use.
- Hi-Flex EPDM SA-747 is not compatible with polystyrene, bitumen or coal tar pitch based products or surfaces.
- Do not use in high humidity environments. High humidity will prevent the solvent in the adhesive from evaporating, making an effective bond impossible.
- Use in well ventilated areas. Avoid breathing vapours.
- Use solvent resistant gloves to avoid skin contact.
- Be familiar with the Safety Data Sheet for this product.
- Do not thin Hi-Flex EPDM SA-747. Stir often.
- Ideal storage temperature is room temperature. Storage at temperatures greater than 32 °C (90 °F) may reduce the shelf life of the product. If stored below 15°C (60°F), restore to room temperature prior to use.
- Opened containers of Hi-Flex EPDM SA-747 should be used within 48 hours. The cement will begin to thicken after that.

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- Condensation may form on freshly applied adhesive if the ambient temperature is near the dew point. If condensation develops, the application of the adhesive must cease because proper adhesion will not be achieved. Once condensation ceases to occur, the application may continue. Apply a thin re-coat of adhesive to previously coated areas before continuing.
- If swallowed, do not induce vomiting. Call a physician immediately.
- Hi-Flex EPDM SA-747 Splice Adhesive will discolour white EPDM membrane. Substituting Hi-Flex EPDM PA-100 Primer Adhesive in lieu of SA-747 adhesive will minimize this problem.

APPLICATION INSTRUCTIONS

1. Membrane and surfaces to receive seam adhesive must be clean and free of dirt, debris, dust, greases and oils. Remove heavy dirt and foreign matter by brooming and washing with water.
2. Clean areas to receive adhesive by wiping with clean rags soaked in Lexcan Weathered Membrane Cleaner. Replace rags frequently as they become soiled. The properly cleaned area will be uniform in colour without streaks, globs or puddles. Let completely dry before proceeding.
3. Solids suspended in SA-747 tend to settle; stir thoroughly for at least 5 minutes prior to and during use. Scrape sides and bottom of can to ensure all solids are in full suspension.
4. SA-747 should be used full strength. Do not dilute.
5. Apply SA-747 with a paint brush to the areas of the membrane to receive seam tape or pressure sensitive flashing. Lexcan requires seam tapes and pressure sensitive flashings to be used in all projects requiring a warranty. If not working with a seam tape or pressure sensitive flashing product, a heavier coat must be applied using a 12 mm (1/2") medium nap paint roller.
6. Allow SA-747 to dry until it does not string when touched with a dry finger. Drying time will depend on temperature and humidity. Apply tape / flashing product quickly thereafter to minimize potential dust contamination. Refer to the application instructions for these products for further information.

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