

# STA'-PUT®

## S400

### LOW VOC PVC MEMBRANE ADHESIVE

## TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION:

ITW STA'-PUT® S400 is a Low VOC PVC Membrane Adhesive.

### ADVANTAGE:

- Quick dry time
- Aggressive grab tack
- High green strength
- Excellent adhesion to many substrates
- High strength bonds
- Long open time

### TYPICAL PROPERTIES:

Property	Typical Value
Base:	Synthetic Polymer
Solvent:	Organic Solvent*
Shelf Life:	1 year from Date of Manufacture**
Color:	Amber
Flash Point:	1.4 F (-17 C)
Percent Solids	25% ± 4.0%
Weight / Gallon	7.08 lbs./ gallon
VOC Content	199.4 g/L (EPA Method 24)
Open Time	60 minutes
Dry Time	5 - 10 minutes
Viscosity	1,800 – 2,400 cps
Formaldehyde	No urea formaldehyde added during adhesive manufacturing
* Reports have associated repeated and prolonged occupational exposure to solvents with permanent brain and nervous system damage	
** The shelf life for an unopened container of this adhesive stored at temperatures between 60°F (15.6°C) and 95°F (35°C) is 1 year from date of manufacture. Store out of direct sunlight in a cool, well-ventilated area. Avoid storing container directly on the floor or against an outside wall	

### DIRECTIONS FOR USE:

- Use only after careful consideration of the warnings, directions, and first aid instructions given.
- Apply adhesive to the membrane and substrate which are clean, dry and free of debris. Apply at the rate of approximately 120 square feet per gallon per surface, sufficient to bond 60 square feet of membrane in place. The coverage rate will vary according to the porosity of the substrate.
- Apply adhesive using a 3/8" medium nap solvent resistant roller.
- Allow adhesive to partially dry (approximately 5 – 10 minutes) to a tacky feel when touched with the back side of a dry finger before bonding membrane to substrate.
- Mate the membrane to the substrate avoiding any air entrapment, and apply pressure by means of a roller or push broom to assure complete bonding.
- Replace the lid after each use and secure tightly for storage. Do not use on some vinyl membranes or polystyrene foam. Some membranes contain plasticizers, which can, over time, soften.
- Apply only when temperature is at least 50°F (10°C) and rising.

**ATTENTION:**

- Empty container remains hazardous until all flammable vapors, which may explode upon ignition, are gone from residue and container. Observe all labeled hazard precautions. Do not cut, puncture, or weld while hazard exists.
- Do not reuse empty container. Recycle, or dispose of, according to all federal, state, and local regulations. Follow solvent manufacturer's recommendations and instructions for safe handling.

**KEEP OUT OF REACH OF CHILDREN  
FOR PROFESSIONAL OR INDUSTRIAL USE ONLY**

**NOTICE TO PURCHASER:**

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Complete technical information is available from  
ITW Polymers Sealants North America, Inc.