Construction

Sarnacol® T 770

Solvent free adhesive for Sarnafil® TG / TS roof waterproofing membranes

Product Description	Solvent free, polyolefin based hot melt adhesive
Uses	Sarnacol® T 770 is a hot melt adhesive to bond Sarnafil® TG 66 type and Sarnafil® TS 77 type membranes in perimeter and flashing areas.
Characteristics / Advantages	■ Solvent free ■ Adheres to solid, rough and clean surfaces ■ Suitable substrates: - Concrete, lightweight concrete, brick, cementitious plaster - Oriented strand fibre (OSB) boards, plywood panels - Fibre cement boards - PUR/PIR insulation boards with lamination (glass or mineral fibre fleece) - EPS/XPS insulation boards - Mineral fibre boards with sufficient compressive strengths and appropriate surfase for bonding - Galvanized steel and other sheet metal ■ Application: with Sarnafil® Spraytool 700

Tests

Approvals / Standards	■ Quality management system EN ISO 9001/14001

Product Data

Form		
Consistency	Solid	
Colour	Yellow	
Packaging	Plastic bag with: Packing unit:	20 sticks (1.0 kg) Box with 10 plastic bags or single plastic bag

Storage

Storage Conditions	Store in dry conditions at temperatures between +5 °C to +25 °C.
Shelf-Life	24 months from date of production if stored properly in original, unopened and undamaged plastic bag. Expiry date on bag.

Technical Data

Chemical Basis	Polyolefin copolymer
Density	~ 0.9 kg/l (+20 °C)
Melting point	110°C
Viscosity	5000 mPa•s at 180°C

System Information

Application Details

Consumption	Consumption depends on the roughness and absorbency of the substrate and ranges from 1.5 – 2 sticks / m^2 (75 – 100 g/m^2).
Substrate Quality	The substrate must offer sufficient strength and adhesion to resist the forces generated by wind suction.
Substrate Preparation	The substrate must be firm, clean, dry, free of stripping agents and free of oil and grease. Sheet metal and mineral fibre boards must be coated with Sarnafil® T Primer 770 before the adhesive is applied. It is also recommended to pretreat masonry and concrete with Sarnafil® T Primer 770.
Compatibility	■ Unsuitable substrates: - Bituminous substrates - Sarnafil® G/S (PVC) single ply waterproofing membranes

Installation Instructions

Application Guidline

Based on the valid installation instructions of the relevant roof waterproofing membrane.

Application Method

General information about the adhesive:
Sarnacol® T 770 can only be applied with the Sarnafil® Spraytool 700. The adhesive is heated and molten in the Sarnafil® Spraytool 700 and sprayed onto the substrate and membrane by compressed air. The application temperature of Sarnacol® T 770 is 180 – 200°C. Set the Sarnafil® Spraytool 700 to the according temperature. Refer to the Sarnafil® Spraytool 700 application instructions prior to the application of Sarnacol® T 770.

General principles for bonding (contact bonding):
Prepare the substrate and pretreat with Sarnafil® Primer 770 if required (see Substrate Preparation).

First spray Sarnacol® T 770 uniformly onto the substrate. The spray distance should be approximately 200 mm. Mask adjacent surfaces (including the membrane) as needed to protect them against overspray.

Position and straighten the Sarnafil® TG/TS roof membrane. Spray Sarnacol® T 770 uniformly onto the underside of the roof membrane. Spray distance should again be approximately 200 mm.

Welding seam overlap areas must be kept free of adhesive. Remove adhesive with Sarnafil® T Clean if necessary. If the mass of adhesive is large, warm up the adhesive first and scrape off with a putty knife.

To produce a long lasting bond, the applied Sarnacol® T 770 should be heated and molten briefly under direct flame with the Sarnafil® Heat Gun. Then immediately adhere the mating surfaces and press down using a pressure roller. Whenever possible, warm up the Sarnacol® T 770 on the side with the higher heat-resistance (usually the substrate). If the substrate is not heat-resistant (e.g. EPS/XPS) the Sarnacol® T 770 sprayed onto the Sarnafil® TG/TS strip can be heated. You can also use a combination of both options. Avoid overheating the adhesive. Keep the heat source in continuous motion back and forth along the length of the working area. Avoid any glossing on the roof membrane, particularly in the area of the welding seam overlap.

Long sections of membrane should be adhered in one section at a time.

Tool Cleaning

Tools and equipment must be cleaned with Sarnafil® T Clean immediately after use.

Notes on Installation / Limits

Installation works to be carried out only by Sika® instructed contractors for roofing.

Temperature limits for the installation of the adhesive:

Substrate temperature: At least +5 °C
Ambient temperature: At least +5 °C

Installation only to be carried out in dry weather conditions.

Installation of some ancillary products, e.g. contact adhesives / cleaners is limited to temperatures above +5 °C. Please observe information given by Product Data Sheets.

Special measures may be compulsory for installation below +5 °C ambient temperature due to safety requirements in accordance with national regulations.

Setting

Setting Time

The strength required for the intended stress is achieved immediately.
Final strength is achieved after approx. 1 week and depends on the temperature and humidity.

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Value Base	All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.
Local Restrictions	Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.
Health and Safety Information	For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data. REACH relevant information is available in the most recent SDS.

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