



# Heavy Duty

## CONSTRUCTION POLYURETHANE ADHESIVE - INTERIOR & EXTERIOR

### KEY FEATURES

- Adheres to wet and frozen lumber
- Reduce squeaks and nail pops in sub-floors, stair treads, with long repositioning time
- Foam compatible and ideal for dryscape construction

### DESCRIPTION

Bostik Heavy Duty Construction Adhesive (HDCA) is a one-component premium grade polyurethane, that is specifically formulated for subfloor and floor joist assemblies, from site erected structures to factory constructed modular and mobile homes.

### APPLICABLE STANDARDS

- ASTM D3498, APA AFG-01, ASTM C557 and HUD UM-60A
- VOC Compliant: CARB, OTC and SCAQMD Compliant

### SURFACE PREPARATION

Surface must be clean, dry and smooth; free of voids, projections, loose materials, oil, grease, sealers, curing compounds, waxes and all other surface contaminants that may inhibit proper bond.

### APPLICATIONS

- Bonding to wet, frozen, or treated lumber
- Adhesion to sub floor assemblies (plywood, OSB, engineered flooring), stair treads, furring strips, in tile board components.
- May eliminate squeaks and nail pop-ups when used in conjunction with mechanical fasteners
- Used in assembly of dryscape designs
- Installation of countertops and back splashes including marble and granite

### FEATURES AND BENEFITS

- Minimal odor
- Long open time for repositioning
- Quick full cure
- Easy gunning, requires less effort from user
- Low solvent formula, will not damage foam
- More product for your money
- Multi-environmental climate use



### LIMITATIONS

- Porous substrates may absorb components of adhesive. Test for satisfactory adhesion results. (see ASP)
- Lower relative humidity and temperature will extend curing time.
- Until the adhesive is fully cured, do not expose to mechanical stresses.
- Not recommended for immersion in water or other liquids.
- Not recommended for direct contact with traffic.

### INSTALLATION

- Apply sufficient adhesive for the specific application.
- Surfaces must be clean, dry and free of contamination.
- Re-position work prior to adhesive skinning, usually in 45 minutes.
- Generally, Bostik HDCA does not require primer.
- It is the responsibility of the end user to assess fitness for use.
- Bostik HDCA is ready to use. Puncture foil seal inside nozzle. Gun adhesive onto the properly prepared surface, avoiding air entrapment and gaps. Apply positive pressure to assure proper wetting of adhesive sealant to the adjoining building materials.

## MANDATORY ADHESION TO SUBSTRATES

### PRETEST - (ASP)

Construction substrates have become complex and diverse by nature and origin. Substrate chemistries and structures can interfere with adhesive performance. Therefore, an Adhesion to Substrate Pretest (ASP) is mandatory to assess adhesion and sealing characteristics. This must be performed prior to installation to avoid potential failures and warranty issues. Call Bostik Technical Service for more information about ASP, surface preparation, and possible priming.

### CLEAN UP

Dry wipe uncured material prior to the adhesive skinning. The use of Bostik Hand & Tool Towels can facilitate faster removal of uncured adhesive. Cured adhesive is extremely difficult to remove without destruction of the adherend.

### SHELF LIFE

The shelf life of Bostik Heavy Duty Construction Adhesive is one year from date of manufacture. Shelf life of Bostik Heavy Duty Construction Adhesive must be checked prior to using the product. Adhesive past its shelf life may not perform or adhere as described by this data sheet. High temperature and high relative humidity may reduce significantly the shelf life of the polyurethane adhesive.

### COLOR

Mustard

### PACKAGING

10.1 oz. Cartridges, 12 Cartridges/Case  
28 oz. Cartridges, 12 Cartridges/Case

### CAUTION

COMBUSTIBLE. HARMFUL IF SWALLOWED OR INHALED. CONTAINS POTENTIAL SENSITIZER. MAY CAUSE ALLERGIC SKIN OR LUNG REACTION. MAY IRRITATE EYES, SKIN AND RESPIRATORY TRACT. Do not breathe fumes. Do not get in eyes, on skin or on clothing. Do not swallow. Use only in a well-ventilated area or wear mask. Keep away from flames or sparks. Wash thoroughly after handling. Store container in a cool (60° - 80°F / 15° - 30°C), dry area with lid tightly sealed. Do not reuse container.

### WARNING

This product contains a chemical(s) known to the State of California to cause cancer and/or birth defects or other reproductive harm.

### LIMITED WARRANTY

Limited Warranty found at [www.bostik-us.com](http://www.bostik-us.com) or call 800.726.7845. TO THE MAXIMUM EXTENT ALLOWED BY LAW, BOSTIK DISCLAIMS ALL OTHER EXPRESS OR IMPLIED WARRANTIES, INCLUDING WITHOUT LIMITATION WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. UNLESS OTHERWISE STATED IN THE LIMITED WARRANTY, THE SOLE REMEDY FOR BREACH OF WARRANTY IS REPLACEMENT OF THE PRODUCT OR REFUND OF THE BUYER'S PURCHASE PRICE. BOSTIK DISCLAIMS ANY LIABILITY FOR DIRECT, INCIDENTAL, CONSEQUENTIAL, OR SPECIAL DAMAGES TO THE MAXIMUM EXTENT ALLOWED BY LAW. DISCLAIMERS OF IMPLIED WARRANTIES MAY NOT BE APPLICABLE TO CERTAIN CLASSES OF BUYERS AND SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATIONS MAY NOT APPLY TO YOU. It is the buyer's obligation to test the suitability of the product for an intended use prior to using it. The Limited Warranty extends only to the original purchaser and is not transferable or assignable. Any claim for a defective product must be filed within 30 days

of discovery of a problem, and must be submitted with written proof of purchase.

### TYPICAL UNCURED PROPERTIES (NOT FOR SPECIFICATION PROPERTIES)

Description	Results	Test Method, Notes
Skin Time (ambient conditions)	60 minutes	Bostik Test Method
Extrusion Rate (70° F, 50 psi)	185 g/min.	ASTM C603, Modified
Sag Test <sup>1</sup>	Pass	ASTM C639, Modified
Frozen Lumber Adhesion	Good	ASTM D3498
Shrinkage	Negligible	Bostik Test Method
Wetting on Lumber: Frozen	Good	ASTM D3498
VOC Content	48 g/l	EPA Method 24
Chemical Type	Polyurethane	Premium
Solids	95 ±2%	Mathematical Calculation
Weight/gallon	15 lbs.	ASTM D1475
Flash Point	135°F (57°C)	ASTM D3828

<sup>1</sup>1/4' x 1/4' square notched trowel configuration

### TYPICAL CURED PROPERTIES (NOT FOR SPECIFICATION PROPERTIES)

Description	Value	Test Method, Notes
Oxidation Resistance	Good	ASTM D3498
Tensile Strength	430 psi	ASTM D412
Lap Shear Strength <sup>3</sup>	440 psi	ASTM D3498
Out-gassing from Cure Process	Negligible	Bostik Test Method

<sup>2</sup>After 14 day cure at 77°F (25°C) and 50% Relative Humidity

<sup>3</sup>100% Cohesive Failure



Conforms to HUD UM60a

### BOSTIK HOTLINE

Smart help  
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