

DUOTACK® 365

Two-Component Polyurethane Adhesive

PRODUCT DATA SHEET PD10318 - REV.220721



APPLICATIONS

ROOFS

QUICK FACTS:

CARTRIDGES (Product 30225)		CUBITAINERS (Product 30150)	
CASE QUANTITY	COVERAGE (ft ²)	QUANTITY (gal)	COVERAGE (ft ²)
4 cartridges	100-150 per cartridge	10 per set (A&B)	2,500-3,800 per set (A&B)

MINI DRUMS (Product 30250)		DRUMS (Product 30151)	
QUANTITY (gal)	COVERAGE (ft ²)	QUANTITY (gal)	COVERAGE (ft ²)
30 per set (A&B)	7,500-11,400 per set (A&B)	100 per set (A&B)	25,000-38,000 per set (A&B)

DESCRIPTION & FEATURES:

DUOTACK 365 is a low rise, two component polyurethane adhesive. **DUOTACK 365** is used to adhere insulation and cover boards to approved substrates. Insulation and cover boards may include polyisocyanurate, polystyrene, mineral fiber, gypsum, wood fiber, cement, perlite and asphaltic roof boards. **DUOTACK 365**'s unique chemistry provides for a versatile quick setting adhesive that is not susceptible to low relative humidity or temperature.

STORAGE:

DUOTACK 365 should be stored in a clean, dry location and protected from environmental exposure and out of direct sunlight. **DUOTACK 365** can be stored without temperature restrictions. When used during cold weather, **DUOTACK 365** should be conditioned to a minimum temperature of 14°F (-10°C) for 24 hours before application. **CARTRIDGES:** The adhesive should be conditioned to a minimum temperature of 50°F (10°C) for 12 hours before the application. When stored properly, **DUOTACK 365** has a shelf life of 12 months from its manufacture date.

APPLICATION:

DUOTACK 365 is applied to approved substrates free of oil, grease, dirt and other contaminants in ½" to ¾" ribbons. Maximum spacing for these ribbons is 12 inches on-center, though 6 inches and 4 inches on center are used in perimeters and corners. Apply enough adhesive to install one insulation/coverboard at a time. Once applied, immediately place the insulation/coverboard into the wet adhesive and do not allow the adhesive time to skin over. Insulation adhesives cure quickly during hot weather, and when applied to hot substrates. Monitor conditions closely and adjust the application as needed to ensure the adhesive has not skinned over or cured before setting the insulation boards into the wet adhesive.

Maintain constant pressure/weight on the boards while **DUOTACK 365** cures, usually in minutes but variable depending on environmental conditions. The published application rates may vary based on substrate type and other project conditions. Additional **DUOTACK 365** is required for rough, uneven and porous substrates.

Please reference the SOPREMA Low-Slope Roofing Insulation Technical Manual for project-specific application of **DUOTACK 365** polyurethane adhesive.

TESTING & APPROVALS:



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TECHNICAL INFORMATION & TESTING:

PHYSICAL PROPERTIES		
PROPERTY	VALUE	TEST METHOD
Color	Amber (Part A) Gray (Part B)	-
Cleaning tools and uncured adhesive	Solvents (mineral spirits, Xylene, etc.)	-
Viscosity, Brookfield @ 77°F (25°C), 5 rpm, sp #4, cP	400-600 (Part A) 4,000-7,000 (Part B)	ASTM D2556
Rise time, seconds*	Approx. 90	Internal/industry
Curing time, minutes*	30	Internal/industry
Tack-free time @ 70°F (21°C), minutes	10-12	-
Shelf life, months	12	-
VOC, g/L	0 (Part A) 0 (Part B)	-

* Curing time and rise time were determined under ideal application conditions: 25°C (77°F) and 50% relative humidity. Curing time and rise time will be longer at lower temperatures and shorter at higher temperatures (all values are nominal).

Data is represented by average values, unless noted otherwise.