



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS



DC – 13674

TECHNICAL SALES BULLETIN

Hydra FAST-EN® Bond Plus™ DC-13674

DESCRIPTION

DC 13674 is a water-based adhesive for bonding EPDM and TPO membranes for use in RV Roofing and Flooring applications.

GENERAL INFORMATION

- **Solventless** -- No VOC's
- **Water-based** -- Non toxic, easy clean up
- **Nonflammable** in wet state
- Excellent for bonding EPDM, TPO Fleece Back, and TPO membranes to RV Roof decking and flooring
- Excellent resistance to heat and moisture
- Flexible to temperatures as low as -40°F
- Good adhesion to metal, plywood, and concrete

TYPICAL PROPERTIES

(Specification values available upon request)

| | |
|----------------------|---|
| BASE | SYNTHETIC POLYMER EMULSION |
| SOLIDS | 45% |
| SOLVENTS | WATER |
| COLOR | CREAMY WHITE (WHEN WET) |
| TEMPERATURE RANGE | -40 TO 200°F |
| VISCOSITY | 12,500 cPs |
| APPROX. WEIGHT | 8.5 LBS./GAL. |
| STORAGE | STORE IN CLOSED CONTAINER UNDER 80°F. KEEP FROM FREEZING. |
| PH | 7 |
| DISPOSAL INFORMATION | DO NOT REUSE CONTAINER OR REMOVE LABEL. SAFELY DISPOSE OF CONTAINER AND CONTENTS IN ACCORDANCE WITH LAW |

SURFACE PREPARATION

Clean, dry, dust-free surfaces are required for optimum bond strength. Surface temperatures should be maintained at temperatures above 40° F. A solvent wipe and/or abrading the surface are recommended to improve adhesion

PRECAUTIONARY DATA

- * This product is nonflammable when wet
- * For professional or industrial use only
- * Use with adequate ventilation
- * Read the container label and the Safety Data Sheet carefully before use
- * Keep away from children
- * Keep container closed when not in use
- * Keep from freezing

DISPOSAL INFORMATION

Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and Local regulations.

2/27/15

Royal Adhesives & Sealants, LLC an H.B. Fuller Company • 2001 W. Washington Street, South Bend, IN 46628 • Phone: 800-999-GLUE • Fax: 574-246-5425

This product is warranted to the original purchaser to meet published specifications, if any, and, in the absence of published specifications, to be merchantable quality. Such warranty may not be assigned or otherwise transferred by purchaser. No other warranty, expressed or implied, of fitness for a particular purpose or any other thing is made. Purchaser's exclusive remedy for breach of this warranty shall be a refund of the price paid for the products by the purchaser. Except as stated above, Royal Adhesives & Sealants, LLC, shall not be liable for any defect in, or breach of obligation relating to the defects in these products, regardless of the theory that may be asserted, including, without limitation, negligence, contract, absolute liability in tort or misrepresentation. If the purchaser does not accept goods on these terms, they are to be returned at once, unopened.