



LUCAS *Coatings & Mastics for the Roofing Trade*

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PRODUCT DATA BULLETIN

#734 MOD-BIT ADHESIVE

PURPOSE

Lucas #734 is designed as a cold process inter-ply adhesive for SBS modified bitumen single-ply membranes. Cold process adhesives eliminate the need for hazardous torches and hot asphalt kettles. Lucas Modified Bitumen Adhesives are easy to apply with minimal equipment, effort, and cost. #734 may also be used to adhere polyisocyanurate, perlite and wood fiber insulation and fiberglass and organic base sheets.

PRODUCT DESCRIPTION

Lucas #734 Mod-Bit Adhesive is manufactured from refined modified asphalts, a special solvent blend, and non-asbestos reinforcing fibers. #734 is formulated to spread easily and evenly at the recommended rate of application.

APPLICATION

Lucas Mod-Bit Adhesive should only be applied to surfaces that are sound, clean, and dry. Temperatures should be a minimum of 40° F and there should be no threat of rain. The adhesives may thicken in cold weather. To improve cold weather applicability store the adhesives in a warm place prior to use. Apply directly from the can; do not thin. The SBS modified bitumen sheets should preferably be cut into sections less than 20 ft. in length and allowed to relax and flatten out before being installed. All laps should be a minimum of 4 inches wide. All laps should be rolled with a weighted roller and end laps should be weighted to insure a proper bond. A bead of adhesive should be evident at all seams. The adhesive may be left open for a short time before the modified roll is imbedded to allow some of the solvent to evaporate and improve the initial bond. This time period will vary significantly with weather conditions and the applicator should be careful not to allow the adhesive to set up or skin over before the membrane is installed. Equipment and foot traffic should not be permitted on the new roof until the adhesive has fully cured in order to prevent voids or blisters from forming at pressure points. Lucas #734 Brush Grade should be applied evenly at a rate of 1.5 to 2 gallons per 100 sq. ft., depending upon the absorbency of the substrate. It may be applied with either a brush, roller, suitable spray equipment or, the preferred method on smooth surfaces, a notched squeegee with notches 1/4 inch wide and 1/8 inch deep spaced 1 inch on center. Excessive rates of application may damage the membrane and prolong curing time. Consult the modified bitumen manufacturer if more than one coat of adhesive is to be used in any roof system. Cure time will be between 24 and 48 hours. The strength of the adhesive will continue to increase beyond this initial bonding period. Clean up with mineral spirits.

CAUTION

Combustible mixture, keep away from open flames. Do not heat or store above 100° F. Avoid prolonged contact with skin or inhalation of solvent fumes. Keep out of reach of children. Do not take internally. If swallowed, do not induce vomiting. Contact medical personnel immediately.

#734 SPECIFICATION

Applicable ASTM Specification	D-3019 Type III
Viscosity ASTM D-562	625g @ 77° F (25° C) (7,000 cps.)
Recommended Rate of Application	1.5 to 2 gal. per 100 sq. ft.
%Asphalt	60 min.
%Solids	65 min.
% Non-volatile ASTM D-6511	67 max.
% Mineral Filler Content.	10 min.
VOC	300 g/l max
Weight per gallon	8.2 lbs.
Flash Point +100° F (38.7° C)	
Container Sizes	5, 55

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