

TEK-4000 is a solvent free, low VOC, high performance 2-part epoxy adhesive system recommended for the installation of Teknoflor, TUF STUF and barenaked flooring products. It is excellent for use in health care facilities and commercial installations where heavy fixtures or rolling stock will be used.

**SUITABLE SUBSTRATES:**

Properly prepared double layer exterior-grade plywood, Group 1, CC type or APA underlayment grade plywood, concrete (all grade levels), radiant heated floors (85°F and below), terrazzo, cement based self leveling underlayment's and single layer of well bonded VCT.

**SUBSTRATE PREPARATION:**

All substrates must be sound and clean, flat and smooth, dry and free of dust, dirt, grease and oil, marker and paint, wax, or any other contaminants that might interfere with the adhesive bond. Concrete, cement based underlayment's and patching compounds must be fully cured and free of any hydrostatic and or moisture problems. Moisture tests must be performed on all concrete substrates regardless of grade level or age of slab. Moisture testing must be performed by one of the two following methods: either the most current version of ASTM F1869 Calcium Chloride Test, with moisture levels not to exceed six (6) pounds MVER, or the most current version of ASTM F2170 In-Situ Relative Humidity Test, with moisture levels not to exceed eighty (85) percent. If the test results exceed the limitations noted, the installation should not proceed until the problem has been corrected. Follow current ASTM F710 guidelines. Always perform a bond test prior to installation. Do not use on chemically cleaned substrates. Moisture limitations on concrete substrates must be within product installation guidelines.

**APPLICATION and INSTALLATION:**

The installation site and materials must be acclimatized with HVAC in operation. The floor and room temperature, as well as flooring materials and adhesive, must be maintained at 65° to 85°F, and the ambient RH (relative humidity) must be maintained between 35% and 55% for 48 hours before, during, and continuously after the testing and installation. Mix entire contents of Part B into the Part A container using a low speed mixer and paddle for 3-5 minutes until uniform in color without streaking. Adhesive will not cure if not thoroughly mixed. After mixing, immediately apply the adhesive to the substrate and do not allow mixed product to sit in the container. Wash all tools with isopropanol or mineral spirits immediately after mixing. Trowel selection is based upon the condition of the substrate and material backing (see below). Spread the adhesive uniformly with appropriate trowel and place flooring into the adhesive immediately while wet. Under normal temperature and humidity conditions (70°F, 50% RH) the adhesive working time will be 50-60 minutes. Check for full adhesive transfer to the back of the floor covering. The amount of time in which you have to place the flooring will vary with temperature and humidity. The higher the temperature and the lower the humidity, the faster the adhesive will set. After placing the flooring into the adhesive, and prior to rolling with the 100lb. 3 section roller, a push board should be used to push out any air bubbles that might be trapped. The roller alone may not be adequate in removal of trapped air bubbles due to subfloor irregularities or setting of adhesive. Once placed, roll the flooring immediately in both directions using a minimum 100 lb. 3-section roller. Roll again before the adhesive sets, generally 1-2 hours. Direct sunlight or heat from an external source will speed up the set of the adhesive.

**RECOMMENDED TROWELS AND COVERAGE RATE:**

For flooring materials with a smooth or lightly textured back use a 1/32" x 1/16" x 1/32" U notch trowel.

For flooring materials with a textured back use a 1/16" x 1/16" x 1/16" V-notch trowel. Substrate conditions and material backing texture must be taken into consideration. The least amount of adhesive should be used to get full transfer to the backing. A simple bond test can be performed to help make this determination.





Coverage: 225 - 250 sq. ft. per gallon



Coverage: 165 - 200 sq. ft. per gallon

Floor Covering Backing	Trowel Size* and Notch	Coverage
Textured backing	1/16" x 1/16" x 1/16" V-notch. 1.6mm x 1.6mm x 1.6mm Sq.	165-200 sq. ft./gallon
Smooth or light texture backing	1/16" x 1/32" x 1/32" U 1.6mm x 0.8mm x 0.8mm U	225-250 sq. ft./gallon

\*Trowel dimensions are width x depth x spacing. Coverage is approximate and may vary depending on porosity of substrate and the angle at which the trowel is held. *IT IS THE INSTALLERS RESPONSIBILITY TO APPLY THE PROPER AMOUNT OF ADHESIVE FOR THE JOB CONDITION.*

#### CLEAN UP:

Remove excess adhesive before it cures with isopropanol or mineral spirits applied to a clean, lint-free cloth. Do not allow solvents to sit on the flooring or penetrate the joints. NEVER APPLY SOLVENT DIRECTLY TO FLOORING.

#### AFTER INSTALLATION:

Restrict foot traffic for 24 hours and the movement of heavy rolling loads and heavy objects for 48 hours to allow the adhesive to cure properly. Premature traffic can cause installation failure.

#### PHYSICAL CHARACTERISTICS (70°F, 50% RH):

Flash Time: 0 minutes

Working Time: 50-60 minutes at standard temperature and humidity

Product Type: 2 part Epoxy

Packaging: Part A & B provide 1 Gallon when mixed

Moisture Vapor Emissions: 85.0% RH or less (ASTM F2170) • 6.0lbs or less MVER (ASTM F1869)

Surface Alkalinity: pH must not exceed 10 (ASTM F710)

Storage: Maintain between 65°F - 95°F. Protect from freezing

Shelf Life: 1 year in unopened container at 70°F, 50% RH

VOC Content: <12 g/L when tested in accordance with SCAQMD Rule 1168.

#### LEED PROGRAM CERTIFICATIONS (where applicable)

IEQ Credit 4.1-Low Emitting Materials

IEQ Credit 4.3-Low VOC ratings help qualify installations for this credit as part of a flooring system.

MR Credit 5-Regional Materials-on jobsites within 500 miles from manufacturing location: Olive Branch, MS 38654.

Visit [www.shannonspecialtyfloors.com](http://www.shannonspecialtyfloors.com) to review the current version of the TEK 4000 Installation Instructions and flooring product installation guide.



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