

# APAC™

## 594

## Rubber-Flooring Adhesive



### DESCRIPTION

APAC 594 is an acrylic polymer-based adhesive with enhanced bonding characteristics specifically for rubber sheet and tile flooring. It can also be used to bond solid vinyl sheet, plank and tile; vinyl composition tile (VCT) and felt-backed vinyl sheet flooring. APAC 594 flashes quickly to its tacky phase and is suitable for use over porous and nonporous substrates. Its unique performance characteristics, non-hazardous components and low volatile organic content make it suitable for use when two-component urethane products cannot be recommended.

### FEATURES & BENEFITS

- Excellent bond strength to rubber flooring
- Resistant to indentation and heavy rolling loads
- Low-odor formula for use in occupied buildings

### USES

**RESILIENT FLOOR COVERINGS** – Rubber sheet and tile flooring; solid vinyl sheet, tile and plank flooring; felt-backed vinyl flooring; and VCT. Also used for flash coving solid vinyl, felt-backed vinyl and rubber sheet flooring.

### AREAS OF USE

- Interior residential (rental apartments, condominiums and houses)
- Interior commercial (office buildings and cafeterias)
- Interior heavy commercial (shopping malls, grocery stores and department stores)
- Interior institutional (hospitals, schools, universities, libraries and government buildings)

### RECOMMENDED SUBSTRATES

Exterior-grade plywood, Group 1, CC type; other approved wood underlayments (per flooring manufacturer's recommendations); concrete and properly prepared cement terrazzo; cement-based self-leveling underlayments and patching compounds; embossing levelers applied over existing, properly prepared and fully bonded ceramic tile or VCT; and properly prepared and primed gypsum underlayments that meet the requirements for compressive strength according to ASTM F2419. Also for flash coving; properly prepared gypsum wallboard with paper intact; clean, dry, well-bonded paint; and properly prepared wall-patching compounds that are hard, well-bonded and fully cured.

Note: Consult Technical Services for installation recommendations regarding substrates and conditions not listed.

### LIMITATIONS

Do not install over any substrates containing asbestos. For interior installations only. Do not apply over any adhesive residues including

cutback. Do not install when the moisture vapor emission rate (MVER) exceeds 5 lbs. per 1,000 sq. ft. per 24 hours, when using the anhydrous calcium chloride test (ASTM F1869). Do not install when the relative humidity (RH) of the concrete slab exceeds 80% (ASTM F2170). Use only when the substrate temperature is between 50°F and 90°F. Install only in areas recommended by the flooring manufacturer. Building owners should be advised of the flooring manufacturer's guidelines for climate control settings (temperature and humidity). These conditions must be monitored and kept constant in order to ensure the overall performance and long-term success of the installation. Do not use over nonporous paints, vinyl wall coverings, laminates and similar nonporous surfaces. These must be removed before application.

### SURFACE PREPARATION

All substrates must be structurally sound, dry, solid and stable. Substrate should be clean and free of dust, dirt, oil, grease, paint, curing agents, concrete sealers, loosely bonded toppings, loose particles, old adhesive residues, and any other substance or condition that may prevent or reduce adhesion. All surfaces must be level, even, flat and smooth. Refer to APAC's Surface Preparation Guidelines at [www.apacadhesives.com](http://www.apacadhesives.com).

### MIXING

Note: Choose all appropriate safety equipment before use. Refer to Material Safety Data Sheet (MSDS) for more information.

- Ready to use; no mixing is necessary.

### INSTALLATION

#### Direct Bonding Instructions

1. Select the appropriate notched trowel (see "Typical Trowel and Approximate Coverage" section).
2. Spread adhesive evenly over the subfloor, keeping the trowel at a 45° angle to the subfloor.
3. For working time and flash time, refer to "Application Conditions" tables.
4. Install flooring in strict accordance with flooring manufacturer's written instructions.
5. Roll the flooring with the recommended-weight roller across the width and length of the flooring surface.
6. Promptly clean any adhesive smudges from the flooring material's surface with water while the adhesive is still fresh/wet. Use mineral spirits once dried. Use caution with mineral spirits, which may be harmful to some materials.
7. Clean tools with water while the adhesive is still fresh/wet.
8. Protect from light traffic for 24 hours, and from heavy traffic for 72 hours.

## Flash Coving Instructions

1. Abrade glossy surfaces for proper bonding.
2. Apply APAC 594 with a 4" natural bristle brush on the floor as well as up the entire cove area.
3. Allow adhesive to remain open per instructions shown in Application Conditions chart below.
4. Install flooring in strict accordance with flooring manufacturer's written instructions.
5. Roll adhered areas with a hand roller and seal seams as recommended by flooring manufacturer.
6. Promptly clean any adhesive smudges from the flooring material's surface with water while the adhesive is still fresh/wet. Use mineral spirits once dried. Use caution with mineral spirits, which may be harmful to some materials.
7. Clean tools with water while the adhesive is still fresh/wet.
8. Protect from light traffic for 24 hours, and from heavy traffic for 72 hours.

## APPLICATION CONDITIONS

Application Characteristics over Porous Substrates		
	Flash Time*	Working Time**
Rubber sheet flooring, solid vinyl sheet, vinyl-backed carpet and felt-backed vinyl sheet flooring†	0 to 15 minutes	1 hour
Rubber tile, vinyl tile, vinyl plank and VCT	30 to 60 minutes, or until dry to touch	2 hours

† Sheet flooring must be installed into wet adhesive in order to facilitate flooring placement.

Application Characteristics over Nonporous Substrates		
	Flash Time*	Working Time**
Rubber tile, vinyl tile, vinyl plank and VCT	30 to 60 minutes, or until dry to touch	2 hours

\* Flash time: The amount of time recommended for the adhesive to remain exposed to the air following application before the installation of floor covering.

\*\* Working time: The maximum amount of time that an adhesive can remain exposed to the air and still effectively bond to the floor covering.

Note: Flash and working times vary based on temperature, humidity, substrate porosity, trowel size and jobsite conditions.

## TECHNICAL DATA

Polymer type	Vinyl acrylic
Percent solids	55% to 65%
VOCs (Rule #1168 California's SCAQMD)	0 g/L
Color	Off-white
Shelf life	2 years
Flash point	> 200°F
Storage conditions	50°F to 90°F

Note: Protect containers from freezing in transit and storage. Provide for heated storage on site and deliver all materials at least 24 hours before work begins.

## PACKAGING

Product Code	Size
96764221	4 U.S. gals. (15,1 L)

## TYPICAL TROWELS AND APPROXIMATE COVERAGES\*\*\*



Rubber sheet and tile, vinyl sheet, tile and plank, felt-backed sheet vinyl, vinyl-backed carpet

1/16" x 1/16" x 1/16" square-notch trowel  
125 to 185 sq. ft. per U.S. gal.

\*\*\* Coverages shown are for estimating purposes only. Actual jobsite coverage may vary according by application method, substrate, substrate conditions and actual thickness applied.

## INDUSTRY STANDARDS AND APPROVALS

- CRI Green Label Plus No. GLP59800

LEED Points Contribution	LEED Points
MR Credit 5, Regional Materials*	Up to 2 points
IEQ Credit 4.1, Low-Emitting Materials – Adhesives & Sealants	1 point

\*Using this product may help contribute to LEED certification of projects in the categories shown above. Points are awarded based on contributions of all project materials.

Before using, user shall determine the suitability of the product for its intended use and user alone assumes all risks and liability whatsoever in connection therewith. **ANY CLAIM SHALL BE DEEMED WAIVED UNLESS MADE IN WRITING TO US WITHIN FIFTEEN (15) DAYS FROM DATE IT WAS, OR REASONABLY SHOULD HAVE BEEN, DISCOVERED.**