



996 Two-Part Epoxy Adhesive

Product Specification

1. PROPRIETARY PRODUCT/MANUFACTURER

1.1 Proprietary Product: Tarkett 996 Two-Part Epoxy Adhesive formulated for installing Tarkett Rubber Floor Tile, Defiant Oil & Grease Resistant Rubber Tile, Rubber & Vinyl Stair Treads and Nosings, Vinyl Feature Strips, Vinyl Moldings, and Tactile Warning Strips.

1.2 Manufacturer:

Tarkett North America Phone (800) 899-8916
30000 Aurora Rd.
Solon, Ohio 44139
Web: www.tarkettna.com
E-mail: info@tarkett.com

1.3 Proprietary Product Description

- Tarkett #996 Two-Part Epoxy Adhesive is an OSHA Flammability Class IIIB, solvent free, epoxy-polyamide resin adhesive.
- High strength adhesive made for installations over porous and non-porous substrates.
- Contains no hazardous or carcinogenic ingredients as defined by OSHA chemicals and meets all federal, state and local air quality regulations.
- Contributes to LEED Certification (E.Q. 4.1: Low-Emitting Materials: Adhesives and Sealants).
- Parts A & B:
SCAQMD Rule 1168 – VOC compliant
SCAQMD Rule 443.1 – Less than 12 gram VOC per liter of materials

1.4 Sustainability

- Floor Score Certified (SCS-FS-03550)

2. PRODUCT PERFORMANCE and TECHNICAL DATA:

- Base – Epoxy
- Color – Beige (Both Parts A & B)
- Consistency – Thick Paste
- Open Time – 15 minutes (time will vary with temperature)
- Working Time – 40-50 minutes
- Shelf Life – 18 months in an unopened container
- Freeze/thaw – Stable up to 5 cycles at 0°F (-18°C)

2.1 Application:

- Porous and Non Porous
- Concrete
- Do not install Tarkett Flooring over expansion joints, or other moving joints in the substrate.
- Coverage:
 - **Porous and Non-Porous** –
1/16"x1/16"x1/16" V-notch – 150-175 sf/gal

3. AVAILABILITY and COST

For availability and cost contact authorized Tarkett distributors nationwide.

4. INSTALLATION

4.1 General Installation Requirements:

- Tarkett flooring and adhesives must be site conditioned at room temperature for a minimum of 48 hours prior to, during, and after installation.
- The interior air temperature must be maintained by operational HVAC between 65°F (18.3°C) and 85°F (29.4°C) with a relative humidity between 40% and 60%. Substrate should be a minimum of 5°F higher than the dew point temperature.
- We strongly recommend the permanent HVAC system be fully operating. **NOTE:** If a system other than the permanent HVAC source is utilized, it must provide proper control of both temperature and humidity to recommended or specific levels for the appropriate time duration as stated above.
- Surfaces and substrates shall be smooth, flat, permanently dry, clean and free of all foreign material such as dust, paint, grease, oils, and solvents, curing and hardening compounds, sealers, asphalt, and old adhesive residue.
- Moisture testing:
 - ASTM F1869 – not to exceed 8lbs
 - ASTM F2170 – not to exceed 90%.
- The pH of concrete must be between 7 & 9.
- Do not install on exterior surfaces subject to weather.

4.2 Installation Instructions

- Refer to adhesive label for full installation instructions.
- Open containers of Part A & B. Scrape all of Part B into Part A can. Mix thoroughly using a ½ horsepower drill with a "jiffy mixer" or equivalent paddle. Mix until smooth and uniform in color. Adhesive will not cure if not thoroughly mixed. The adhesive must be spread immediately after mixing.

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- Mixed adhesive has approximately 40-50 minutes working time. After thorough mixing, pour entire contents of can onto floor and spread with the appropriate trowel. Do not let the mixed adhesive stand in the can. Do not thin the adhesive. Open time will vary with temperature.
- After spreading, allow the adhesive to set on the substrate for 15 minutes prior to installing the flooring. The flooring must be installed into wet adhesive. Adhesive transfer to the flooring is critical to a successful installation. Do not slide flooring into place, this will force adhesive through seams. Work off flooring to prevent adhesive displacement and shifting of tile. If you must work on the flooring material, kneeling boards must be used.
- Place the flooring into adhesive, roll in both directions with a 100lbs. three-section roller. Use a small hand roller to roll stair treads and nosings or in areas which cannot be reached by a large roller. Inspect 2.5 hours after installation and roll again if necessary. Walk on kneeling boards to prevent adhesive displacement.
- Wait a minimum of 24 hours before heat welding.

4.3. Cleanup

- Before the adhesive sets, remove excess adhesive from flooring and clean tools with denatured alcohol applied to a clean white cloth (Follow manufacturer's precautions when using denatured alcohol).
- Do not allow adhesive to dry on the flooring surface.
- Removing dried adhesive may cause irreparable damage to the flooring surface.

4.4. Traffic:

- All traffic must be restricted for 24 hours after installation.
- No heavy traffic, rolling loads or furniture placement for 72 hours after installation.
- Avoid cold or excessive heat, including direct sunlight during the curing period.
- Wait 72 hours after installation before performing initial cleaning

5. TECHNICAL SERVICES

Visit us on the web at www.tarkettna.com
Contact Technical Support at (800) 899-8916 or E-mail:
Resilient.TechnicalSupport@Tarkett.com

6. LIMITED WARRANTY

Adhesive warranty is a "system warranty" covered under the product that is recommended to be installed in conjunction with this adhesive. Refer to Tarkett limited warranty for complete details.

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