



Fusion Series 4600 Vinyl Back Floor Covering Adhesive

FUSION SERIES

DESCRIPTION:

Fusion Series 4600 Vinyl Back Floor Covering Adhesive is a premium (non-staining) latex adhesive, designed to permanently install dimensionally stable vinyl backed resilient sheet goods, homogenous commercial grade PVC sheet flooring, PVC backed carpet, PVC backed carpet tiles, PVC sheet vinyl (vinyl backed), vinyl tile, vinyl plank, linoleum, and linoleum tile.

Fusion Series 4600 Vinyl Back Floor Covering Adhesive, manufactured by Royal Adhesives and Sealants, is LEED compliant and is compliant with South Coast Air Quality Management District Rule 1168.

E.Q. 4.1: Low-Emitting Materials: Adhesives & Sealants

E.Q. 4.3: Low-Emitting Materials: Carpet Systems

M.R. 5.1: Regional Materials: 10% Extracted, Processed & Manufactured Regionally

M.R. 5.2: Regional Materials: 20% Extracted, Processed & Manufactured Regionally

Fusion Series 4600 also qualifies for the Carpet & Rug Institutes Green Label Plus Program. This is a third party certification with the most stringent VOC regulations in the country. 100% of all raw materials used to manufacture this adhesive are extracted, processed and manufactured regionally.

***LEED points are based on all materials used on a project.**

SUB-FLOOR PREPARATION:

Follow all manufacturer's recommendations and industry standards regarding sub-floor preparation. Moisture tests are required on all concrete sub-floors regardless of grade level or if the concrete is freshly poured or is classified as an older slab. Moisture testing should be performed by ASTM F1869 Calcium Chloride Tests with moisture levels not to exceed five (5) pounds per twenty-four (24) hours per one thousand (1000) square feet, or ASTM F2170 In Situ Relative Humidity Test with readings not to exceed eighty (80) percent. Additional information with regard to these tests and results can be obtained through Royal's Technical Service Department.

DIRECTIONS:

Refer to all manufacturer's recommendations and approvals prior to installation. **For Indoor Use Only.** For best results install at 70°F (+/- 5°) and 50% R.H. (+/- 5%).

DIRECTIONS:

1. Store flooring and adhesive at 65°-70°F for 24 hours prior to and during installation.

2. All sub-floors must be clean, dry, free of dust, dirt, wax, paint, grease or any other contaminants that might interfere with the adhesive bond.
3. Follow manufacturer's recommendations as to seaming and sealing. Roll flooring with a 75-100 pound roller.
4. Cracks and uneven surfaces must be filled with a cement based patching compound such as Parabond® Micro Finish or PP-Plus. Parabond® M-600 may be used if there is no evidence of moisture.

PVC backed carpet and carpet tiles and PVC sheet vinyl (with vinyl backing).

1. Follow trowel recommendations listed on 4600 trowel chart.
2. For PVC backed carpet, carpet tile, and homogeneous sheet vinyl (vinyl backed), the adhesive must be allowed to dry to the touch so that there is little or no transfer of adhesive to the finger.
3. Once the adhesive reaches the dry-to-the-touch state, it is ready to accept flooring.
4. Rolling with a three-section floor roller should take place immediately after the material has been placed into the adhesive.
5. For carpet and carpet tile, a 50-75 pound roller should be utilized.
6. For homogenous sheet vinyl, a 100-pound roller is recommended.
7. The time from when the adhesive is allowed to dry to the touch to the time it must be covered is approximately 45 minutes.
8. If the adhesive is allowed to remain uncovered after initially drying to touch for periods longer than the recommended 45 minutes, a loss in adhesion strength will result. Care must be taken by the installer not to spread more than can be worked appropriately within the 45 minute time frame.
9. Installation of this product on non-porous sub-floors utilizing a wet application of adhesive is **NOT** recommended or warranted.



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Vinyl tile, vinyl plank, linoleum and linoleum tiles.

1. Follow trowel recommendations listed on 4600 trowel chart.
2. 4600 is recommended for porous and non-porous applications of vinyl tile, vinyl plank, linoleum, and linoleum tile.
3. For porous applications, once troweled the adhesive should be allowed to remain open (flash-off) for approximately 5-10 minutes before placement of the flooring material. Once placed, the material should be rolled immediately utilizing a 100 pound three-section roller.
4. **Note:** It is the responsibility of the user to determine whether or not the sub-floor to be covered is porous. To determine if a sub-floor is porous, place two droplets of water in various areas. If the sub-floor is porous, the water will be absorbed within a few seconds.
5. For non-porous applications follow trowel recommendations as listed in 4600 trowel chart.
6. Non-porous installations require that the adhesive be allowed to dry to the touch, so that there is little or no transfer of adhesive to the finger.
7. Once the adhesive dries to the touch, it is ready to accept flooring material.
8. Rolling should take place immediately after the flooring material has been placed into the adhesive.
9. The time from when the adhesive is allowed to dry to the touch to the time it must be covered is approximately 45 minutes.
10. If the adhesive is allowed to remain uncovered, after initially drying to touch, for periods longer than the recommended 45 minutes, a loss in adhesion strength will result. Care must be taken by the installer not to spread more adhesive than can be worked appropriately within the 45 minute time frame.

RECOMMENDED SUBSTRATES:

- Concrete
- Portland Based Underlayments



- Properly Prepared Gypsum
- APA Approved Plywood
- Terrazzo
- Fiber Cement Underlayment
- Radiant Heated Sub-floors
- Properly Prepared VCT (Single Layer)
- Properly Prepared Sheet Vinyl (Single Layer, fully adhered)

RESTRICTIONS:

1. For Interior installations only.
2. Do not install when MVER is over 5 lbs. per 1,000 sf per 24 hours, per ASTM F1869.
3. Do not install when relative humidity is over 80%, per ASTM F2170.
4. Do not install when ambient temperature is not between 60°F & 95°F.
5. Do not install when ambient relative humidity is above 65%.
6. It is the sole responsibility of the installer to determine the suitability and compatibility of the adhesive for the user's intended use.

CLEAN-UP:

Remove wet adhesive immediately with a damp cloth. Use Mineral Spirits or Parabond® M-315 Cleaner to remove dried adhesive. **CAUTION: Mineral Spirits are flammable. Read and follow all precautions on container label.**

PACKAGING:

- One 4 Gallon Pail
- Four x 1 Gallon Case

WARRANTY:

Royal Adhesives and Sealants offers a limited warranty for this product when used in accordance with printed specifications. A copy of the limited warranty can be obtained by calling technical service at 800-763-7272 or visiting www.parabond.com.



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FLOORING	TROWEL	ESTIMATED SPREAD RATE
0.050" or Less	<p>1/32" = 1/16" x 1/32" x 1/32" U-Notch</p>	200-300 sf/gallon or 22-33 sq/yards per gallon
Between 0.050" - 0.080"	<p>1/16" 1/16" x 1/16" x 1/16" V</p>	125-175 sf/gallon or 23 sq/yards per gallon
Greater than .080"	<p>1/16" 1/16" x 1/16" x 1/16" SQ</p>	125-175 sf/gallon or 20 sq/yards per gallon

Technical Data	
Base Polymer	Acrylic Polymer
Color	White
Solids	60-65%
VOC Content	<1 gram per liter
pH	8.8
Consistency	Creamy Paste
Trowelability	Light, Easy
Shelf Life	One Year in Unopened Container
Storage	40 ^o -95 ^o F
Application Temperature	65 ^o -95 ^o F (18 ^o -35 ^o C)
Traffic Restrictions	Foot Traffic after 12 hours, Heavy Traffic after 24
Open Time	30-45 minutes Depending on ambient conditions
Freeze Thaw Stability	5 cycles @ 0 ^o F



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