

DUOTACK® 365 Application

DUOTACK 365 is a low rise, two component polyurethane adhesive. DUOTACK 365 is used to adhere insulation and cover boards to approved substrates. Insulation and cover boards include polyisocyanurate, polystyrene, mineral fiber, gypsum, wood fiber, cement, perlite and asphaltic roof boards. The foam is formed by the reaction of the part A (amber in color) and a part B (grey in color) mixed in equal parts in a static mixing tip. It is critical to ensure the two parts are mixed at a 1:1 ratio.

DUOTACK 365 packaging:

- Cartridges: 0.4-gal per cartridge; 4 cartridges/case
- Cubitainers: 10-gal per set; 5-gal Part A & 5-gal Part B
- Mini-Drums: 30-gal per set; 15-gal Part A & 15-gal Part B
- Drums: 100-gal per set; 50-gal Part A & 50-gal Part B

Application temperature and storage:

- Minimum application temperature: 14° F (0°C) without conditioning
- Storage: Store DUOTACK 365 in a clean, dry ventilated storage area protected from environmental exposures, and away from direct sunlight.
- Shelf life: When properly stored, DUOTACK 365 has a shelf life of 12 months from its manufacture date.

Installation:

- Refer to DUOTACK 365 Safety Data Sheet (SDS) and follow all applicable project requirements. Surfaces must be dry, clean and free of oil, grease, debris or dirt. Ensure substrates are properly prepared and made uniform at transitions and board joints for optimum adhesion to the substrate.
- If an application cart is being utilized, follow cart manufactures recommendations for initial set up before installing DUOTACK 365.
- If using cubitainers, simply open the flap on the box and remove the cap on the plastic bladder. Apply a quick connect fitting onto the plastic bladder and turn the boxes so that the quick connect fitting is facing down on the installation cart
- After the machine is set up allow the part A and B to run out of the manifold into a waste pail for approximately 30 seconds before closing the valves. Once the valves are closed, the static mixing tip can be applied, and the application of the adhesive can begin.
- The wet bead size through the static mixing tip should be ½ to ¾ in at the point of application. When the insulation or coverboard is applied into the adhesive the bead will spread to 2 ½ to 3 in or greater. Application rates will vary depending on substrate, the insulation product being adhered, and bead size being installed.
- Insulation and coverboards should be placed into “wet” DUOTACK 365 immediately after the adhesive is applied. Do not allow DUOTACK 365 to rise, cure or “skin-over” before placing the insulation materials into the wet adhesive. Once the boards are in place, immediately apply weight to ensure the boards are pressed firmly to the substrate and remain in position. Maintain weight as needed to ensure the boards remain in firm contact with the substrate until DUOTACK 365 has sufficiently cured. Cure time varies based upon conditions.
- If adhesive “skins-over” before boards can be set in place, remove and replace affected materials and re-apply material as needed.

- If DUOTACK 365 does not cure sufficiently, examine equipment to ensure Parts A and B are being dispensed equally. Remove and replace affected materials and re-apply as needed.
- Regularly check equipment to ensure part A and part B are being dispensed equally. Check boards to ensure insulation and coverboards are adequately being adhered in place.
- Follow cart manufacturer's instructions for proper shut down procedures.

Off-Ratio Visual Ques:

- Part A Rich (Too much Part A): Too much part A causes the foam to be very brittle. The adhesive will appear thin. Color will be light grey.



- Part B Rich (Too much part B): Too much part B will not allow the foam to fully cure. The foam will be soft and “puffy”. Color will be dark grey.

