



Fusion Series 4500 Clear Thin Spread Adhesive

Fusion Series

DESCRIPTION:

Fusion Series 4500 Clear Thin Spread VCT Adhesive is a solvent-free adhesive designed for the installation of Vinyl Composition Tile. 4500 provides quick dry times and extended working time with up to 16 hours of aggressive tack.

Fusion Series 4500 Clear Thin Spread VCT Adhesive, manufactured by Royal Adhesives and Sealants, is LEED compliant and is compliant with South Coast Air Quality Management District Rule 1168.

Fusion Series 4500 qualifies for the Carpet & Rug Institute's 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.

SUBFLOOR PREPARATION:

Follow all manufacturer's recommendations and industry standards regarding subfloor preparation. Moisture tests are required on all concrete subfloors 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 on existing slabs. New Construction Projects, or Green slabs can have a Moisture Vapor Emission Rate of up to eight (8) pounds per twenty-four (24) hours per one thousand (1000) square feet when tested in accordance to ASTM F1869 or 90% when tested in accordance with ASTM F2170. 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%).

1. Floor must be clean, dry and free from paint, dust or concrete curing compounds, etc.
2. Cracks and uneven surfaces must be filled with an approved cementitious underlayment compounds such as Parabond® Micro Finish or PP-Plus.
3. Adhesive and floor must be 65°F or higher.
4. Apply adhesive to the floor with the approved notched trowel in a thin uniform coat.
5. Allow adhesive to dry until it loses its milky appearance and does not transfer to finger when touched. This will take thirty minutes to one hour, depending on temperature and humidity. When dry, the adhesive is tacky.
6. Tile may be installed once adhesive has dried and becomes tacky. Tile can be safely installed up to 16 hours later. Dry time and working time can be greatly

affected by ambient temperature, humidity, porosity and other job-site conditions.

7. Install tile, carefully positioning material since tile will be difficult to slide once placed in adhesive. Rolling with a 50-100 lb. 3 section floor roller will help achieve better initial adhesion.
 8. Remove any excess adhesive from tile with fine steel wool and soapy water. Tools may be cleaned with Mineral Spirits or Parabond® M-315.
 9. Keep container tightly covered when not in use.
- 4500 can be used over old cutback adhesive residue. Residue being defined as no trowel ridges and smooth to the touch**

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. Do not use to install any vinyl or PVC flooring.
2. For Interior installations only.
3. Do not install when MVER is over 8 lbs per 1,000 sf per 24 hours, per ASTM F1869.
4. Do not install when relative humidity is over 90%, per ASTM F2170.
5. Do not install when ambient temperature is not between 60°F & 95°F.
6. Do not install when ambient relative humidity is above 65%.
7. 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 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.



863 SE Main Street • Simpsonville, SC 29681
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FLOORING	TROWEL	ESTIMATED SPREAD RATE
Non-Porous Substrate	<p>1/32" 1/16" 1/32"</p> <p>1/16" x 1/32" x 1/32" U-Notch</p>	200-300 sf/gallon
Porous Substrate	<p>1/16" 1/16" 1/16"</p> <p>1/16" x 1/16" x 1/16" SQ</p>	125-175 sf/gallon

Technical Data	
Base Polymer	Acrylic Polymer
Color	Light Straw
Solids	55-65%
VOC Content	<1 gram per liter
pH	9.5 - 10
Consistency	Creamy Paste
Trowelability	Light, Easy
Shelf Life	One Year in Unopened Container
Storage	40°-95°F
Application Temperature	65°-95°F (18°-35°C)
Traffic Restrictions	Immediate Foot Traffic 24 hours Heavy loads
Dry Time	30-45 minutes Depending on ambient conditions
Working Time	Up to 16 Hours (depending on ambient temperature, humidity, porosity of substrate and other jobsite conditions)
Freeze Thaw Stability	5 cycles @ 0°F
Cleaning	After 7 Days



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