Method Statement

ROCKFIX CRP-15

(One Component, High Performance, Synthetic Rubber Based Contact Adhesive, Especially Designed for Carpet Application)

Rev.: A, Date: 25.06.2025

Method Statement

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Section A: General Considerations

Tools & Equipment

It is suggested that the following list of equipment is adopted as a minimum requirement.

Equipment Type	Equipment Description
Protective clothing	▪ Protective overalls ▪ Good quality gloves and face mask ▪ Eye Protection
Mixing equipment	▪ Paddle Mixer ▪ Manual Mixing Tools
Surface Preparation Equipment	▪ Industrial vacuum cleaner ▪ Clean lint-free cloths ▪ STAR Solvent or approved degreasing solvent ▪ Abrasive pad or sandpaper (if required)
Application Equipment	▪ Brush, Trowel ▪ Spatula ▪ Rollers

High temperature working

It is suggested that, for temperatures above 35^{0}C, the following guidelines are adopted as good working practice:

1. Store unmixed materials in a cool environment, avoiding exposure to direct sunlight.

2. Keep equipment cool, it is especially important to keep cool those surfaces of the equipment which will come into direct contact with the material itself.

3. Try to avoid application during the hottest times of the day, arrange temporary shading as necessary.

4. Make sufficient material, plant and labour available to ensure that application is a continuous process.

Application - points of note

STAR operates a policy to encourage the use, where possible, of approved or licensed applicators. This ensures that applications are completed satisfactorily so that the long term performance of the materials is assured.
For contractors who wish to apply the materials themselves STAR is also able to offer technical assistance and training. Either on-site or at its Training Centre in the Kingdom of Saudi Arabia.

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Section B: Application Instructions

1. Surface Preparation

1.1 Surfaces be dry, clean, solid, free from loose materials, oil grease, paints and free from contamination such as oil, grease, loose particles, decayed matter, moss algal growth, laitance, and all traces of mold that could interfere with bonding.

1.2 STAR solvent can be used to clean and degrease surfaces.

1.3 Abrasion may be involved, as lightly sanding surfaces to improve adhesion, especially on smooth or glossy materials.

1.4 Surfaces should be dry and within the recommended temperature range specified by the manufacturer (typically 10°C to 40°C).

2. Priming

2.1 Priming is not required on most non porous surfaces.

2.2 When used on porous or highly absorbent substrates, apply the adhesive thicker and if required 2 coats.

3. Application

3.1. **Mixing**:
Mix **ROCKFIX CRP-15** thoroughly by appropriate Tool – Paddle Mixer (Don't use Sticks or Boards, where splinters could contaminate the product) to assure uniform consistency.

3.2. **Application**:
Brush/Roller/Trowel:
Use clean equipment. Uniformly, apply to both surfaces at approx.. 3 – 5 m2/l = 0.1 to 0.2 mm wet film. Press assembly into place, making sure complete contact is made with applied adhesive. Bond may be made within 10 to 15 minutes after observing the Tack Time.
Spray:
May be spray applied with conventional air atomizing equipment or airless spray equipment. For spray equipment information, please consult spray recommendations or contact your spray equipment supplier. Average viscosity range: 200 – 500 cps.

3.3. Contact adhesive should be applied thinly and evenly to both surfaces being bonded.

3.4. Adhesive should be applied to both sides if required – Using a 150mm brush width in 300mm intervals.

3.5. Observe Drying Time – 10 to 30 min for the Adhesive to be in the correct condition to start bonding (Tacky to the Touch – But still slightly wet).

3.4 Within the open time of the Adhesive, bring components together carefully and adjust to correct position - To avoid the introduction of air bubbles. Clamp, Roller or apply weights to ensure proper contact and bonding pressure.

3.5 Maintain the assembly undisturbed during the curing period using tie cords or bands until adhesive sets – 1h to touch. Dry through approx.. after 24h in standard conditions.

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4. Notes & Safety Precautions

4.1 Due to the products formulation, certain materials (e.g. copper, lead) can be affected.

4.2 Check suitability before use on PVC and other surfaces.

4.3 Keep container closed when not in use to prevent solvent evaporation.

4.4 **Personal Protective Equipment (PPE):** Specifies the use of gloves, safety glasses, and potentially a respirator depending on the adhesive and application environment.

4.5 **Ventilation:** Emphasizes the need for adequate ventilation due to potential fumes from the adhesive.

4.6 **Flammability:** Addresses the potential flammability of some contact adhesives and the need to avoid open flames or sparks during application.

4.7 **Material Safety Data Sheet (MSDS**): It is recommended to consult the MSDS for specific safety information related to the chosen adhesive.

5. Cleaning

5.1 **ROCKFIX CRP-15** should be removed from tools, equipment and mixers with Solvent (Starclean 110) prior to the initial set. Cured material can only be removed mechanically.

Section C: Approval and Variations

This method statement is offered by STAR Technology as a 'standard proposal' for the application of **ROCKFIX CRP-15**. It remains the responsibility of the Engineer to determine the correct method for any given application.

Where alternative methods are to be used, these must be submitted to STAR Technology for approval, in writing, prior to commencement of any work. STAR Technology will not accept responsibility or liability for variations to the above method statement under any other condition