



# Flexera® 2K PSA Hybrid Adhesive

Updated November 2023

## 1. PRODUCT NAME

TEC® Flexera® 2K PSA Hybrid Adhesive

## 2. MANUFACTURER

H.B. Fuller Construction Products Inc.  
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## 3. DESCRIPTION

Flexera 2K PSA Hybrid Adhesive is an ultra-high-performance, two-part, waterbased adhesive designed for installation of homogeneous and heterogeneous sheet flooring, sports flooring, LVT, rubber, and linoleum in demanding interior environments. This user-friendly adhesive combines easy PSA-method flooring installation with the proven durability and robust adhesion of epoxy adhesives. With its resistance to rolling and static loads and 100% RH capability it is ideal for commercial and institutional flooring applications. Unlike traditional wet set adhesives, Flexera 2K PSA offers long pot life and long open time as well as aggressive initial tack for fast-track flooring installation. Its low volatile organic content makes it ideal for use in occupied buildings such as hospitals, medical centers, offices, and schools.

### Key Features and Benefits

- PSA-method flooring installation with aggressive initial tack
- Open time up to 4 hours
- Pot life up to 10+ hours
- Up to 100% Relative Humidity per ASTM F 2170
- Up to 25 lbs MVER per ASTM F 1869
- Maximum pH limit of 14
- Recommended for Flashcoving
- Low odor waterbased formula
- Non-Corrosive
- CRI Green Label Plus Certified
- SCAQMD Rule 1168 – VOC Compliant
- SCAQMD Rule 443.1 – Less than 12 g/L

### Packaging

2.5 gallon pail (9.46 L)

Product #10013203

### Coverage

Flooring Type	Typical Trowel	Coverage
Commercial & Smooth Backed Flooring	$\frac{1}{32}'' \times \frac{1}{16}'' \times \frac{1}{32}''$ (0.8 x 1.6 x 0.8 mm) U-notch trowel	170-220 ft <sup>2</sup> /gal. (4.17-5.39 m <sup>2</sup> /L)
Textured/rough backing Sport rubber, Linoleum	$\frac{1}{16}'' \times \frac{1}{16}'' \times \frac{1}{16}''$ (1.6 x 1.6 x 1.6 mm) Square-notch trowel	80-105 ft <sup>2</sup> /gal. (1.96-2.58 m <sup>2</sup> /L)

### Recommended Applications

- Commercial: Light and heavy including heavy rolling and static loads
- Healthcare
- Education
- Hospitality
- Retail
- Institutions / Offices
- Sports flooring
- Washdown areas

### Recommended Substrates

- Concrete
- Cement-based Underlayments and Patching Compounds
- Properly prepared and primed gypsum underlayments that meet the ASTM F2419 requirements for compressive strength
- Terrazzo
- Fiber Cement Underlayment
- Radiant Heated Subfloors with 85°F (29°C) maximum surface temperature
- Properly Prepared VCT (Single Layer)
- APA Grade Trademarked Exposure 1 Plywood (exterior grade)

### Substrate Preparation

1. Follow flooring manufacturer's guidelines for allowable levels of concrete moisture content.
2. Refer to ASTM F710 Standard Practice for Preparing Concrete Floors for Resilient Flooring.
3. Approved subfloor must be clean, dry, smooth and dust free.
4. All surfaces must be even, flat and smooth.
5. HVAC must be continuously operating at a temperature of no less than 65°F (18°C) prior to installation.
6. Sweep and damp mop / use shop vac to remove dust.
7. Do not use sweeping compounds.

### Storage

Store at a moderate room temperature. Protect adhesive from freezing. Refer to the Technical Data section of this PDS, for more information.

### Shelf Life

Maximum of 1 year from date of manufacture in unopened container.

### Limitations

- Flooring must be acclimated per manufacturer's instructions.
- Do not install into wet adhesive over nonporous substrates.
- Although Flexera 2K PSA is a moisture tolerant adhesive, it does not form a moisture vapor barrier and will not protect flooring from moisture damage. Use of a moisture mitigation product such as TEC LiquiDam™ or LiquiDam EZ™ may be required for higher moisture content concrete.
- For interior installations only.
- Do not apply over any adhesive residues including cutback adhesive.
- Protect containers from freezing in transit and storage. If frozen, material should not be stirred until it has completely thawed. Provide for heated storage on-site and deliver all materials at least 24 hours before work begins.
- Use only when the substrate temperature is between 65°F and 90°F (18°C and 32°C).
- Do not install over any substrates containing asbestos or mercury.

### Cautions

Read complete cautionary information printed on product container prior to use. For medical emergency information, call 1-888-853-1758.

This Product Data Sheet has been prepared in good faith on the basis of information available at the time of publication. It is intended to provide users with information about and guidelines for the proper use and application of the covered TEC brand product(s) under normal environmental and working conditions. Because each project is different, H.B. Fuller Construction Products Inc. cannot be responsible for the consequences of variations in such conditions, or for unforeseen conditions.

## Product Data

## 4. TECHNICAL DATA

### Physical Properties

TEC Flexera 2K PSA Hybrid Adhesive	
Description	
Adhesive Type	Acrylic Polymer (Part B) with Epoxy Resin (Part A)
Color	Part A: Blue Part B: Cream Mixed: Blue-Green
SCAQMD Rule 443.1 VOC Content	12 grams per liter
VOCs (Rule 1168 SCAQMD)	VOC Compliant
Flash Point	>212°F (100°C)
Adhesive pH	9.5-10.5
Consistency	Light Paste
Shelf Life	One year in unopened container.
Storage	40°-95°F (4°-35°C)
Application Temperature	65°-90°F (18°-32°C)
Traffic Restrictions	12 hours for light traffic 24 hours for heavy rolling loads 72 hours for heavy static loads
Open Time	Up to 4 hours for flooring installation. For flash covering installation, cover the pail and allow mixed adhesive to thicken overnight to allow vertical installation.
Freeze/Thaw Stability	5 cycles at 20°F (-7°C). Protect container from freezing in transit and storage. If frozen, material should not be stirred until completely thawed. Provide for heated storage on site and deliver all materials at least 24 hours before work begins.

## 5. INSTALLATION INSTRUCTIONS

### Mixing

Squeeze and empty entire contents of Part A epoxy into Part B acrylic polymer while mixing. Mix using a variable speed drill set at low speed (300-350 rpm) until a uniform blue-green color is achieved. Mix for 2 minutes, scrape the container sides, then mix an additional 30-60 seconds.

### Application

1. Read flooring product related installation instructions thoroughly before installation.
2. Spread the adhesive using the floor coverings' recommended notch size trowel\*.
3. Allow the adhesive to become clear and tack-up (no transfer to fingers, when lightly touched), typically 20-30 minutes, depending on humidity, absorbency, and temperature of the substrate.
4. The adhesive open time (to accept floor coverings) is 1-4 hours (substrate porosity, floor backing composition and ambient conditions will all affect open time).
5. For difficult to bond flooring materials such as non-PVC, it is recommended that flooring be installed within 1.5 hours after adhesive has become clear and is dry when lightly touched. This will ensure adequate transfer of adhesive to the back of the flooring.
6. Roll and cross-roll the entire installation with a 100 lb. roller after the flooring is installed. Make sure to adequately roll the seams, wall edges and under toe kicks.

\*For some flooring types such as thin or glossy, best practice to prevent telegraphing is to knock down trowel ridges with a saturated roller applicator.

### Clean-up

1. Promptly clean any adhesive smudges from the flooring material's surface with a wet rag while the adhesive is still fresh/wet.
2. Clean cured adhesive on tools with mineral spirits. Use caution with mineral spirits, which may be harmful to some materials.

## 6. AVAILABILITY

TEC premium surface preparation, tile, stone, carpet, wood and resilient floor covering installation products are available nationwide. To locate TEC products in your area, please contact:

Phone: 800-832-9002

Website: [tecspecialty.com](http://tecspecialty.com)

## 7. LIMITED WARRANTY

The product(s) covered by this Product Data Sheet are sold subject to a Limited Warranty and related terms. **H.B. Fuller Construction Products disclaims the implied warranties of merchantability and fitness for a particular purpose and all incidental and consequential damages arising out of the sale, purchase or use of this product.** For Limited Warranty details visit [tecspecialty.com](http://tecspecialty.com). To obtain a hard copy of the Limited Warranty call H.B. Fuller Construction Products at 800-832-9023 or mail a written request to the address in Section 2 of this Product Data Sheet.

## 8. MAINTENANCE

Not applicable

## 9. TECHNICAL SERVICES

### Technical and safety literature

To acquire technical and safety literature, please visit our website at [tecspecialty.com](http://tecspecialty.com).

## 10. FILING SYSTEM

Division 9



Conforms with LEED v4 low emitting interiors.  
Compliant with (CDPH) Standard Method v1.2 VOC Emissions.



To learn more, visit [TECspecialty.com](http://TECspecialty.com)



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