C-630

PRODUCT DESCRIPTION
C-630 is a VOC free, water-based contact adhesive used for the permanent installation of vinyl and rubber resilient flooring, stair treads, wall base, flash coving and accessories in horizontal or vertical installations. C-630 is highly aggressive and has a high resistance to moisture and plasticizers.

C-630 relies on a chemical bond between adhesive layers applied to both the material and the substrate. The resulting bond is extremely tenacious, offering superior initial grab and shear strength. Adhesive can also immediately be heat welded, improving installation completion times.

TECHNICAL INFORMATION
Unit Size: 1 Quart
VOC: 0.0 g/l
ASTM F2170 RH Limit: 85% RH
ASTM F1869 MVER Limit: 6 lbs.
ASTM F710 pH Limit: 7 - 10
Coverage Rates:
20 – 40 sq. ft. per unit
120 – 140 lin. ft. per unit
Flash Time:
30 – 60 Mins. (Dry to touch)
Substrate Working Time: 2 Hours
Pre-coated Working Time: 90 Minutes
Site-Applied Working Time: 90 Mins. – 24 Hours
Light Foot Traffic: Immediate
Heavy Rolling Loads: Immediate
Heat Welding: Immediate
Maintenance: >72 Hours
Shelf Life: 1 year from date of receipt
Storage Temperature: 50° - 85° F (10° - 29.5° C)

SUSTAINABILITY
FloorScore® Certificate Available
Qualifies for LEED Credits: www.excelsiorproducts.net
Technical Documentation visit: www.excelsiorproducts.net or send an e-mail to: solutions@rhctechnical.com
Technical Support: solutions@rhctechnical.com

1. PRODUCT LIMITATIONS
• Prior to acceptance of this document refer to website www.excelsiorproducts.net to confirm that you have the most current revision.
• All referenced times are subject to substrate porosity and texture, as well as ambient conditions, such as air temperature, relative humidity and substrate temperature – actual times may vary based on these conditions.
• Adhesive cannot resist dimensional instability of flooring products, which may cause gapping, cupping, buckling and/or edge lifting.
• Do not use in outdoor installations or over existing adhesives.

2. PRE-INSTALLATION CHECKLIST
• Consult all associated product literature concerning installation and warranty prior to installation.
**3. SUBSTRATE PREPARATION**

In regards to substrate preparation when mechanical sanding, grinding, shot blasting and vacuuming always follow the Resilient Floor Covering Institute's (RFCl) “Recommended Work Practice for Removal of Existing Floor Covering and Adhesives”, and all applicable local, state, federal and OSHA requirements in regards to Asbestos and Silica containment regulations.

All substrates must be prepared according to ASTM F710 or ASTM F1482, as well as applicable ACI and RFCl guidelines. Substrates must be clean, smooth, permanently dry, flat, and structurally sound.

Substrates must be free of visible water or moisture, dust, sealers, paint, sweeping compounds, curing compounds, residual adhesives and adhesive removers, concrete hardeners or densifiers, solvents, wax, oil, grease, asphalt, visible alkaline salts or excessive efflorescence, mold, mildew and any other extraneous coating, film, material or foreign matter.

All substrates must have any and all existing adhesives, materials, contaminants or bond-breakers mechanically removed via scraping, sanding, grinding or buffing with a 25 grit DiamaBrush Prep Plus tool prior to adhesive installation. In extreme situations, shot-blasting may be required.

Mechanical preparation must expose at least 90% of the original substrate.

Following cleaning and removal, all substrates must be vacuumed with a HEPA approved vacuum and flat vacuum attachment to remove all surface dust.

**Sweeping without vacuuming will not be acceptable.**

Do not use solvent/citrus based adhesive removers prior to installation.

**CONCRETE SUBSTRATES**

All concrete must have a minimum compressive strength of 3500 PSI and be prepared in accordance with ASTM F710. If the surface of the concrete is greater than a CSP of 3 then the Excelsior CP-300 may be needed to smooth the substrate.

**RESINOUS SUBSTRATES**

When installing directly over a resinous products, such as the Excelsior MM-100 or an epoxy coating, ensure that coating is dry to the touch and has cured for the prescribed length of time. Substrate must be clean, dry, sound and free of contaminates.

**GYPSUM BASED SUBSTRATES**

Gypsum-based substrates must have a minimum compressive strength of 3500 PSI. Gypsum substrates that do not meet this requirement may have one coat of the Excelsior MM-100 installed to improve the top layer bonding strength of the substrate. Substrate must be structurally sound and firmly bonded to the subfloor below. Any cracked or fractured areas must be removed and repaired with a compatible patch or repair product. New or existing gypsum substrates may require the substrate has a primer or sealer applied just prior to finished floor being installed.

**WOOD SUBSTRATES**

Wood substrates must be prepared in accordance with ASTM F1482. Avoid preservative treated and fire-retardant plywood, as some may be manufactured with resins or adhesives that may cause bonding issues. This also includes plywood sheathing designed for long lasting exposure to exterior climates. These also could contain resins/waxes that could be considered bond breakers. Always refer to those manufacturer recommendations. If the subfloor materials mentioned above are already installed or the wood substrate is old and not repairable, the use of multi-ply Underlayment Grade plywood at a minimum of ¾” thick with a fully sanded face will be required.

**METAL SUBSTRATES**

Metal substrates must be thoroughly sanded/grinded and cleaned of any residue, oil, rust and/or oxidation. Substrate must be smooth, flat and sound.
EXISTING FLOORING SUBSTRATES
Existing rubber flooring and LVT, as well as the adhesives used to install them, must be completely removed from the substrate prior to installation.
Existing VCT, VAT, quartz tile, solid vinyl tile, sheet goods, hardwood flooring, asphaltic materials and existing adhesives or adhesive residue must have a compatible cementitious patch or underlayment installed over them prior to installation. Existing hardwood flooring requires suitable underlayment grade plywood be installed over the substrate. Adhesive may be installed over existing stone flooring substrates, such as terrazzo, porcelain or ceramic tile.
Ensure existing flooring is a single layer of material and that all materials are clean, dry, sound, solid, well adhered and free of site-applied finishes, waxes and/or contaminants. Any and all loose tiles must be removed and repaired or replaced. All grout lines and irregularities must be filled and troweled flush with a suitable primer and patch such as the Excelsior NP-230 and CP-300 to prevent telegraphing of the existing floor. All existing flooring substrates that are outside of flatness tolerances that cannot be repaired with the Excelsior CP-300 patch should be leveled with the SU-310 self-leveling underlayment to achieve a smooth, flat substrate.
All existing flooring substrates must have any and all site-applied finishes and/or waxes completely removed prior to flooring installation in order to ensure a proper adhesive bond. For mechanical removal, use a low-speed buffer and 40-60 grit sandpaper. Properly prepared substrates should not have any remaining gloss or sheen. For chemical removal, ensure chemical treatments will not disrupt adhesion of the existing flooring to the substrate. Be sure to rinse the existing flooring adequately with clean, potable water to remove any and all chemicals from the surface of material. Do not install flooring until any moisture on, between or below existing flooring has completely dried. Ensure all dust; dirt and debris are removed prior to flooring installation.

RADIANT HEATING SUBSTRATES
Ensure the temperature of the radiant heating system does not exceed 85° F (29.5° C) and avoid making abrupt changes in radiant heating temperature.

EXTREMELY SMOOTH OR GLOSSY SUBSTRATES
When using the C-630 over real smooth or glossy substrates such as ceramic tile or FRP wall cladding, be sure to slightly abrade surface to improve bonding characteristics. The use of a medium grade sandpaper Even though Excelsior C-630 is designed for use over non-porous substrates, some of these substrates can be “too” smooth or glossy that can impede an aggressive bond.

4. CRACKS, JOINTS & VOIDS
All cracks, joints and voids, as well as the areas surrounding them, must be clean and free of dust, dirt, debris and contaminants and be repaired with a suitable cementitious patch. Due to the dynamic nature of concrete slabs, manufacturer cannot warranty installations over expansion joints, cracks or other voids such as control cuts saw joints and moving cracks. Do not use adhesives directly over any expansion joints.

5. PRODUCT INSTALLATION
Ensure substrate is suitably prepared prior to installation, as manufacturer is not responsible for substrates that have not been properly prepared and tested for moisture. Ensure adhesive is approved for use with flooring material or accessory.
Using a clean, damp mop or sponge, clean all substrates, especially concrete, prior to installation to remove dust, dirt and debris.
Allow area to dry prior to application. Any dust or contamination on the surface of a substrate could disrupt the bond of the contact adhesive. Use denatured alcohol to clean the backside of stair treads, risers and accessory materials. Failure to do so could result in bond failure. Sanding or abrading the back side of the treads can increase bonding characteristics. To ease installation on larger surfaces, pour adhesive into a clean paint tray or equivalent when using a 1/4”-3/8” short-nap micro-fiber roller or equivalent, apply adhesive directly to material and substrate thoroughly and evenly at prescribed spread rate. Pre-wetting the roller is recommended. When applying adhesive onto smaller surfaces, the use of a smaller paint brush or foam brush can be used. Materials may be coated up to 24 hours prior to installation. Do not allow adhesive to pool or puddle on material or substrate. Replace rollers at regular intervals and between applications to prevent accumulating dry adhesive. Pre-cut materials in place for size and fit prior to applying adhesive. Apply C-630 adhesive to both the substrate and the material to be installed. Allow adhesive to flash on both material and substrate prior to installation – adhesive should turn clear and not transfer to fingertips. Install material by pressing coated material firmly into coated substrate. Once full contact is made, material will be extremely difficult to reposition. Therefore, ensure material is placed properly prior to making full contact. Pay close attention to open times to avoid adhesion issues. Pre-coated materials must be installed within 90 minutes of coating substrate. Standard installations...
must be installed within 2 hours. If open times are exceeded, the adhesive can be reactivated with a hot-air blower or blow dryer. Immediately after installation ensure the material and substrate make full contact by using a soft rubber mallet or a hand roller. Visually inspect installation to ensure that material has not shifted and that adhesive residue has not been compressed onto surface of material.

6. CLEAN-UP
Wet adhesive can be cleaned with a clean towel or cloth and a solution of Excelsior NC-900 and clean, potable water. Tools and materials where adhesive has dried can be cleaned with denatured alcohol or equivalent solvent adhesive cleaner.

7. WARRANTY
Manufacturer provides a 1 year material & labor warranty for all installations where adhesive is properly installed. See Excelsior adhesive warranty for more information.

FOR PROFESSIONAL USE ONLY
PLEASE CONSULT ALL ASSOCIATED TECHNICAL DATA SHEETS, SAFETY DATA SHEETS AND WARRANTY INFORMATION PRIOR TO INSTALLATION.