



# Fusion Series 4323

## Non-Staining Vinyl Sheet Goods Adhesive

# FUSION SERIES

### DESCRIPTION:

Fusion Series 4323 Non-Staining Sheet Goods Adhesive is a latex based adhesive that has been specially formulated for the installation of mineral fibrous felt-backed floor covering. 4323 dries light in color and will not create any adhesive induced (below the surface) discoloration.

Fusion Series 4323 Adhesive, manufactured by Royal Adhesives and Sealants, is LEED compliant and is compliant with South Coast Air Quality Management District Rule 1168.

**E.Q. 4.1:** Low-Emitting Materials: Adhesives & Sealants

**E.Q. 4.3:** Low-Emitting Materials: Carpet Systems

**M.R. 5.1:** Regional Materials: 10% Extracted, Processed & Manufactured Regionally

**M.R. 5.2:** Regional Materials: 20% Extracted, Processed & Manufactured Regionally

Fusion Series 4323 also qualifies for the Carpet & Rug Institutes 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.

**\*LEED points are based on all materials used on a project.**

### SUB-FLOOR PREPARATION:

Follow all manufacturer's recommendations and industry standards regarding sub-floor preparation. Moisture tests are required on all concrete sub-floors regardless of grade level 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. Additional information with regard to these tests and results can be obtained through Royal's Technical Service Department.

### DIRECTIONS:

1. Sub-floor must be clean, dry, smooth and free of any contamination, which may interfere with the adhesive bond. Seal all chalky, very porous floors with PARABOND® M-620.
2. Follow floor covering manufacturer's recommendations regarding layout, cutting, seaming and maintenance.
3. Place floor covering into wet adhesive and roll in both directions with a minimum 75 lb. roller.
4. Refer to floor covering manufacturer's

recommendations regarding proper seaming (cutting), seam sealing and maintenance procedures.

5. Lift floor covering periodically to check adhesive transfer to the backing. A 100% adhesive transfer is required to promote maximum adhesion.

### 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 over adhesive residue including cutback.
4. Do not install when MVER is over 5 lbs. per 1,000 sf per 24 hours, per ASTM F1869.
5. Do not install when relative humidity is over 80%, per ASTM F2170.
6. Do not install when ambient temperature is not between 60°F & 95°F.
7. Do not install when ambient relative humidity is above 65%.
8. 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:

Fresh adhesive can be removed immediately with a damp cloth. If adhesive has dried, use waterless hand cleaner, Mineral Spirits, or PARABOND® M-315 Cleaner. Do not allow solvent to penetrate seams. Solvent will dissolve adhesive bond.

**CAUTION: Mineral Spirits are flammable. Read and follow all precautions on container label.**

### PACKAGING:

- One 4 Gallon Pail
- Four x 1 Gallon Case



863 SE Main Street • Simpsonville, SC 29681  
Phone: 1-800-763-7272 • ISO 9001 Certified

[www.parabond.com](http://www.parabond.com)

12/10/2013



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**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](http://www.parabond.com).

**FUSION SERIES**

FLOORING	TROWEL	ESTIMATED SPREAD RATE
Felt-Backed Sheet Flooring < 0.080"		33 sq/yards per gallon
Felt-Backed Sheet Flooring > 0.080"		20 sq/yards per gallon



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