



*a new age in moldings....*

## **SpecTrim® XT-2000™ Adhesive for Ven4ma® Rigid Plastic Wallcovering**

For installing SpecTrim® Ven4ma® Rigid Wall Protection- Available in 1 or 5 gallon containers

XT-2000™ is a superior high strength adhesive specifically formulated to provide a permanently flexible bond with high initial tack for adhering Ven4ma® rigid plastic wallcovering to a variety of substrates. With thousands of trouble free, time proven installations to its credit, it is the wall protection industry's adhesive of choice.

### Key Benefits and Features

- One coat application reduces labor cost
- Wallcovering can be repositioned during installation
- Water-based with no offensive odor
- Heat resistant to 150 degrees F
- Spreads easily
- Non-flammable Class A & Low "VOC" content
- Easy water clean-up

### Technical Information

- Base.....Synthetic Latex
- Solvents.....Water
- Solids.....62-63%
- Application Temperature Limits.....65° to 80° F  
(After adhesive cures)
- Lifetime Job-site Temperature Limits.....33 Approved Substrates
- Sealed drywall to 150° F (after curing)
- Flammability.....Non-Flammable
- Consistency.....Trowelable Mastic
- Application.....Notched Trowel
- Coverage.....Approximately 100 Square Feet per Gallon with recommended 1/8" notched trowel
- U.L. Listed.....Meets/exceeds Class I/A fire code requirements
- Volatile Organic Compounds.....Zero (0.00%) as tested to EPA Method #24

### Approved Substrates

- Sealed Drywall and Concrete Block
- Stainless Steel and existing non- porous surfaces (see special installation instructions)
- Existing vinyl wallcovering (see special installation instructions)

### Surface Preparation

Surfaces must be clean and free of dust, grease, sealants, and foreign matter. Wipe wallcovering and substrate with a damp cloth immediately before installation to remove any dust or foreign material. Allow to dry before installation.

### Sealing/Priming

Porous substrates such as drywall, joint compound, and concrete block must be painted or sealed using a sealer that will not soften or re-emulsify. Priming prevents wallboard from tearing during installation. This process is also needed because most joint compounds, low cost paints and sealers are now made with PVA's (Polyvinyl Acetate) which may react with the adhesive causing bonding failure. Newly sealed walls must be allowed to dry a minimum of 24 hours before installation of wallcovering.

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### Acclimation

Allow wallcovering material, XT-2000™, and the jobsite to regulate temperature range between 65° F and 80° F, with humidity no greater than 80% for 24 hours prior to installation. These conditions must be maintained during the installation and for at least 48 hours following it. Significant temperature changes cause the wallcovering to expand/contract thereby causing adhesive failure. Do not install wallcovering with XT-2000™ over cold exterior walls. Failure to comply with these requirements may result in significant installation problems.

### Flat Material

Pre-cut pieces from any rolled or wavy material should be flattened with weight or reverse roll for at least 24 hours prior to installation to remove "roll set".

### Installation:

#### Application

Do not thin out XT-2000™ with water or solvents. Spread adhesive evenly with an 1/8" notched trowel only. Cover 100% of the surface. Do not apply adhesive with a roller or brush. Insufficient adhesive is the cause of most installation problems. Apply XT-2000™ to the wall surface only. Do not apply to the wallcovering. Keep trowel grooves clean while working. Wash trowel frequently. Do not vary the pitch of the trowel during application. Varying the angle of the trowel will result in varying the cure time and amount of adhesive applied, resulting in dry spots that cause adhesion issues.

#### Spread Rates for Trowel

Wallcovering thicker than .030", smooth or rough walls, and using a 1/8" x 1/8" "V" notched trowel uses approximately 100 sf/gallon.

#### Flash Off

After spreading XT-200™ it must dry for 20-30 minutes and be firm to the touch before setting wall panels. The wall panels should be set into the adhesive within 1 ½ hours after spreading. This will ensure a solid bond. If the adhesive dries too long, its bond strength will weaken.

#### Expansion Allowance

Rigid plastic wallcovering materials expand with increases in temperature, approximately 1/64" per foot for 30°F increase for .040" thickness. For example: An expansion space of 1/16" must be provided at each end of an 8-foot long sheet of .040" thick wallcovering if the temperature is expected to vary in a 30°F range from the initial installation temperature. Don't force wallcovering against door jambs, ceilings, or baseboards. Leave a 1/16" expansion gap all around. Do not force butt joints together. Wallcovering tends to push away from points of compression and buckle away from the adhesive during the critical curing period. Remove baseboards during installation if possible. Expansion gaps may be filled with matching colored silicone caulk. Also allow a 1/16" expansion gap at all Ven4ma® trim components. *Note: Larger clearance (preferably 1/8") should be left on all edges of the wallcovering when installing near heaters or underlying hot water pipes.*

#### Rolling

Roll Wallcovering with a laminate roller (similar to the Crain Cutter #333) after installation. Roll from the center of the material towards the edges, to remove any trapped air and ensure complete adhesion. Apply extra pressure to finished edges.

#### Corner Guards and Ven4ma Trims:

Do not use XT-2000™ for installing corner guards and Trims. Use Special 3M double face adhesive tape or solvent based contact adhesive.

### Clean Up:

Remove wet adhesive with water. Do not allow to dry on tools or materials. Dry adhesive requires solvent such as mineral spirits for clean-up.

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### Precautions:

Synthetic Latex can be irritating. Avoid contact with skin. In case of contact, wash thoroughly with water. For eyes, get prompt medical attention. Provide adequate ventilation. Keep out of reach of children.

### Removal:

Damaged wallcovering may be replaced by mechanically removing cured adhesive. Re-apply adhesive to new wall covering in normal manner.

### Odor:

Minimal acrylic paint-like odor.

### Precautions:

KEEP FROM FREEZING. When stored in original, tightly sealed container, adhesive is usable for one year.

### Special Advisories:

- Using XT-2000™ adhesive over non-porous substrates.  
Non-Porous surfaces prevent or slow evaporation, lengthening the cure time and reducing the initial bond strength. On Installations over non-porous substrates such as painted metal, stainless steel, high pressure laminate or other rigid plastic, glazed block, etc. make the following adjustments to standard installation instructions:
  1. Adhesive drying time will vary with job-site temperature and humidity conditions. Drying will take at least one hour, usually no longer than three hours.
  2. The adhesive must be firm and not transfer to fingers when touched and will change from white to clear indicating the optimum time for installation. The edges of the installed wallcovering will adhere before the center does.
  3. Keep wallcovering material flat and properly aligned as when using a contact adhesive. DO NOT allow wallcovering to touch the adhesive unless it is perfectly aligned. Readjusting the sheets may be difficult or impossible.
- How to prevent the telegraphing of adhesive trowel grooves through thin guage wallcovering.  
Some installations using thin guage (.028" and less) wallcovering can have an unsatisfactory appearance because of adhesive trowel marks telegraphing through from the back of the wallcovering to its face. This is caused by using a V-notch trowel and allowing the adhesive to become excessively firm before applying the wallcovering. The grooves of the adhesive can become too stiff to flatten out even when a pressure roller is used.  
Follow these procedures to prevent telegraphing:
  1. On smooth walls use a 1/16" square notch trowel.
  2. On rough walls use a 1/8" v-notch trowel having flat areas between the grooves.
  3. Apply wallcovering when the high points of the adhesive have changed from white to clear, but most of the groove is still white.  
*Important: Adhesive grooves must be flattened immediately by rolling the wallcovering with a laminate roller.*
- Adhering Rigid Plastic Wallcovering over Ceramic Tile or Glazed Block using XT-2000.
  1. 0.060 or thicker wallcovering is effective in hiding uneven wall surfaces such as ceramic tile and glazed block. Thinner gauges may only be used if the wall surface is properly prepared to be smooth and flat.
  2. Wall flatness is very important. Level the wall with a premium ceramic tile adhesive. Use a wide flat edged leveling trowel to fill grout line depressions. Leave tile faces uncovered. Allow to dry for a minimum 24 hours.
  3. Wet sand high points to smooth walls and keep dust to a minimum.
  4. Sponge down walls with water to remove dust and loose particles. Allow walls to dry, and then apply the XT-2000 in accordance with the special advisory on using XT-2000 adhesive over non-porous substrates.