

## FORBO 660 ADHESIVE TECHNICAL DATA

### RECOMMENDED FOR THE USE WITH:

- Coral® Entrance Flooring
- Eternal Step Aqua
- All Forbo flooring products, as specified.

### SPECIFICATIONS:

- FloorScore Certified by SCS Global Services
- Two-part polyurethane
- Excellent topical moisture resistance when cured
- Non-flammable
- Storage: Store at minimum temperature of 41° F (5° C); Optimum temperature is 68° F (20° C). Do **NOT** Freeze.
- Frost resistance: Not affected after fully cured.
- Shelf Life: 1 year in unopened container.
- Working Time: ± 30 minutes
- Pot Life: ± 30-40 minutes; shorter at higher temperatures.
- Tack: Low initial tack which increases during curing. Has a very strong bond when fully cured.
- VOC Emissions: <12 grams per liter (calculated per CA South Coast Rule 1168)
- Appearance and Odor: Grey with low odor
- Spread Rate: Approximately 110-120 square feet per gallon when using a 1/16" x 1/16" x 1/16" square notch trowel OR approximately 150-160 square feet per gallon when using a 1/32" x 1/16" x 1/32" fine notch trowel.
- Available in one-half, one or two gallon units.



### SUBSTRATE & TESTING REQUIREMENTS:

- Forbo 660 can be used on all grade levels of concrete, approved suspended wood floors and approved existing resilient floors. All concrete substrates must be prepared in strict accordance with the conditions set forth in the latest version of ASTM F 710. The substrate must be dry, clean, smooth, and structurally sound.
- The surface pH of the concrete must not exceed a pH of 9.0. Concrete surfaces with pH readings less than 7.0 or above 9.0 will require remediation prior to installation.
- The internal relative humidity must not exceed 80% as determined by testing conducted in strict accordance with the latest version of ASTM F 2170.
- The moisture vapor emission rate must not exceed 6.0 lbs. per 1,000 square feet in 24 hours as determined by testing conducted in strict accordance with the latest version of ASTM F 1869.
- Conduct adhesive mat bond testing before beginning the installation. Bond testing will aid in identifying both the working characteristics of the adhesive, such as the appropriate open and working times for the site conditions, and also any potential bonding problems to the substrate.  
NOTE: Polyurethane adhesives have little or no initial tack and are sensitive to substrate porosity. Curing time is directly affected by temperature and humidity. The installer's skill and professionalism are important when working with this type of adhesive. If unfamiliar with this type of adhesive, small test installations should be done before proceeding with larger areas. Always follow directions carefully.

### INSTALLATION RECOMMENDATIONS:

1. Areas to receive material should be clean, fully enclosed and weather tight. The permanent HVAC should be fully operational and controlled and set at a minimum temperature 65° F (18.3° C). If this is not possible, the areas should be acclimated and controlled by means of temporary HVAC to the service level conditions expected during occupancy. The temperature and humidity should range from 75° F ± 10° F (23.9° C ± 5.5° C) with a 50% ± 10% ambient relative humidity. These conditions **MUST** be established at least seven days prior to beginning the installation, maintained during the installation, and continued for at least seven days following the installation.
2. The substrate must be free of all foreign materials including, but not limited to, dust, solvent, paint, wax, oil, grease, residual adhesive, adhesive removers, film-forming curing compounds, silicate penetrating curing compounds, sealing, hardening, or parting compounds, alkaline salts, excessive carbonation or laitance, mold, mildew, and other foreign materials that might affect the rate of moisture dissipation from the concrete, the adhesion of resilient flooring to the concrete or cause a discoloration of the flooring from below.
3. Before beginning the installation, all testing requirements should be conducted: pH, internal relative humidity, moisture vapor emissions and bond testing. Refer to the Substrate Evaluation & Preparation section of the Forbo Installation Guide for additional information.

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4. It is recommended that all appropriate personal protective equipment be worn during mixing and application. If adhesive contacts skin, wash thoroughly with soap and water. For additional information, refer to the Safety Data Sheet (SDS).
5. **IMPORTANT! Add entire contents of Part B to Part A. Do not mix partial units.**
6. Mix thoroughly with an electric drill and mixing paddle to a consistent color. After mixing, remove contents from container. Leaving the mixed material in the container will shorten the working time of the adhesive.
7. Trowel recommendations: For Forbo Coral®, Marmoleum®, Flotex®, ColoRex® (Non-ESD applications) and Allura products, use a 1/16" x 1/16" x 1/16" square notch trowel. For Forbo Eternal products, use a 1/32" x 1/16" x 1/32" fine notch trowel. Replace the trowel when proper coverage is no longer attainable.
8. The open time and working time of adhesives will vary depending on site conditions.  
NOTE: Site conditions can dramatically affect the performance of the adhesive. Temperature, ambient relative humidity, substrate porosity and air circulation will determine the open, working and curing time of the adhesive.
9. When using Forbo 660 adhesive, it is recommended that all material be pre-cut before spreading any adhesive. Allow an appropriate open time before placing the material into the adhesive. A general indication of proper open time is when a light touch produces transfer of adhesive to the finger, but a firm touch will flatten and "smear" the adhesive.
10. Immediately roll the flooring in all directions using a 100 pound roller to ensure proper adhesive transfer. Additional rolling is required during adhesive setup to ensure that the material is flat and fully adhered.
11. Because of the low initial tack, it is recommended that corners, edges, flashcoving, etc. be rolled repeatedly and/or weighed down until the adhesive has cured.
12. Remove fresh adhesive residue immediately with a clean white cloth. The area must then be rinsed with clean, cool water to remove all residue from the floor. Refer to the Forbo Commercial Floor Care Guide for further information.  
**NOTE: FORBO 660 ADHESIVE IS IMPOSSIBLE TO REMOVE FROM THE SURFACE ONCE CURED.**
13. After 8 hours, the adhesive is sufficiently strong for light traffic. Do not allow heavy traffic for a minimum of 24 hours.
14. Do not wash floor for a minimum of 72 hours following installation to allow the adhesive to properly bond and cure. Additional time may be necessary if the installation is over a non-porous substrate.

For additional information, Forbo's Installation and Floor Care Guidelines are available for download at [www.forboflooringNA.com](http://www.forboflooringNA.com), or contact Forbo Product Support & Education Services at 1-800-842-7839.