

FORSPEC PROTECTIVE COATINGS

ACTFLEX 301 R.

Technical Data Sheet | **Solvent-Based Polychloroprene Contact Adhesive for Sheet Membrane Bonding** | **Issue date: 12 November 2026**

Description

ACTFLEX 301 R is a solvent-based polychloroprene contact adhesive formulated for bonding sheet waterproofing membranes to prepared substrates. Its rubber and resin system develops high early green strength the moment the two coated faces are brought together, so sheets hold position immediately without props, weights or mechanical restraint while the bond builds.

The formulation is non-stringing and brush, roller and scraper grade, laying down an even film on vertical and horizontal faces without the cobwebbing that fouls the sheet face. It dries quickly to a tack-dry film, and the bonded film holds its strength continuously to 100°C, which suits it to dark sheet membranes and roof-level substrates where surface temperatures climb well above ambient.

Advantages

- High early green strength - sheets hold position immediately on contact, with no props or weights.
- Heat resistant to 100°C - holds bond strength on dark membranes and hot roof-level substrates.
- Quick drying - tack dry in approximately 7 to 12 minutes, with an open window of approximately 30 minutes to place the sheet.
- Non-stringing - no cobwebbing onto the exposed membrane face during application.
- Brush, roller and scraper grade - one product for horizontal and vertical work.
- Wide service range - -40°C to +100°C once bonded.
- Reactivates with a fresh thin coat where the open time is exceeded, without stripping back.
- One component, ready to use - no mixing, no dilution.

Uses

- Bonding ACTFLEX 1300R butyl rubber sheet membrane to prepared substrates.
- Bonding ACTFLEX 900R butyl rubber sheet membrane, as the approved solvent-based alternative to ACTFLEX 302 ADHESIVE in well-ventilated areas.
- Bonding sheet membrane at laps, perimeters, upstands and terminations, other than lap zones that will be heat-welded.
- Bonding sheet membrane to concrete, masonry, render, sand and cement screed, fibre cement and timber-based substrates.
- Detail bonding at changes of plane and around penetrations where the sheet must hold position immediately.

Limitations

- Not a waterproofing product. It is a bonding adhesive for drained and protected construction.
- Not for continuous immersion. Do not use in tanks, ponds, pools, planter boxes retaining water, or anywhere the bond line will stand in water. Not for potable water contact.
- Not for prolonged immersion in oil, fuel or solvent, notwithstanding its short-term resistance to both.
- Not for use on copper or copper-bearing alloys, expanded polystyrene foam (the solvent attacks it), unsupported vinyl (PVC), polyethylene or polypropylene.
- Not for PVC, TPO, polyethylene or polypropylene sheet membranes. Use the adhesive specified by that membrane's manufacturer.
- May stain light-coloured PVC and vinyl stock. Trial before use on any visible surface.
- Never apply into a lap zone that will be heat-welded. Welded joints require clean, adhesive-free mating faces.
- Where ACTFLEX EP250 is used as a primer, it must be fully cured before adhesive is applied. The adhesive solvents attack uncured epoxy, and the primer must then be removed and reinstated.
- Will not bond to a damp substrate. Bond directly only where substrate moisture is 4.5% or below; above 4.5%, prime with two coats of ACTFLEX EP250 first (refer to Surface Preparation).

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Limitations (continued)

- Highly flammable in the wet state. Not for confined or unventilated spaces, or anywhere ignition sources cannot be eliminated.
- Dilution is prohibited unless approved in writing by an authorised FORSPEC representative.
- Complete a trial bond where the substrate, sheet or service condition is unfamiliar.

Compliance Status

No Australian Standard prescribes performance requirements for solvent-based contact adhesives of this type. Where a sheet membrane system must demonstrate compliance with AS 4654.1 or AS/NZS 4858, compliance is carried by the certified sheet membrane system, not by the adhesive. Refer to the current Technical Data Sheet for the sheet membrane being installed.

The performance values stated in this document are typical characteristic values determined by FORSPEC R&D on standard production material. Hazard classification: HAZARDOUS CHEMICAL, DANGEROUS GOODS per the current Safety Data Sheet (Chemwatch 9041-96).

Technical Data

PROPERTY	VALUE	BASIS
Product type	Polychloroprene rubber and resin contact adhesive, solvent based	—
Form	One component, ready to use	—
Colour and appearance	Light yellow to clear viscous liquid, solvent odour	SDS Chemwatch 9041-96, Section 9
Relative density	0.83 (water = 1)	SDS Chemwatch 9041-96, Section 9
Viscosity	Approx. 1,080-1,450 mm^2/s	SDS Chemwatch 9041-96, Section 9
Flash point	-20°C	SDS Chemwatch 9041-96, Section 9
Solids content	Approx. 20%	FORSPEC R&D to EN 827 *
Tack-up time (at 25°C, 50% RH)	Approx. 7-12 minutes	FORSPEC R&D, touch-tack method *
Open time (at 25°C, 50% RH)	Approx. 30 minutes	FORSPEC R&D, touch-tack method *
Bonding pressure	Minimum 276 kPa (40 psi), roller or press	—
Service temperature, bonded	-40°C to +100°C; continuous service to 100°C	FORSPEC R&D, bonded specimens held at temperature *
Water resistance	Good; not for continuous immersion	FORSPEC R&D to ASTM D896 *
Oil and petrol resistance	Good short-term resistance; not for prolonged immersion	FORSPEC R&D to ASTM D896 *
Coverage	4-6 m^2/L per coated face - refer to Coverage and Yield	FORSPEC R&D, site trial method *
Flammability, wet product	Highly flammable liquid and vapour (Flammable Liquid Category 2)	SDS Chemwatch 9041-96, Section 2
Dangerous goods	Class 3, UN 1133, Packing Group II, HAZCHEM •3YE	SDS Chemwatch 9041-96, Section 14
Application method	Brush, roller or scraper	—
Storage temperature	5-20°C for maximum shelf life	—
Packaging	4 L and 20 L	—
Shelf life	12 months, unopened, stored as specified	—

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Technical Data (continued)

* Typical characteristic values determined by FORSPEC R&D on standard production material at 25°C and 50% relative humidity. Not to be relied upon for engineering design without written confirmation from FORSPEC Technical Services. Tack-up and open times shorten as temperature and air movement rise - confirm both on a trial area before committing to a bay size.

Coverage and Yield

ACTFLEX 301 R is a contact adhesive: both faces to be joined are coated, so the quantity per square metre of bonded area is twice the single-surface rate. Practical yield is at a 10% wastage allowance.

MEASURE	VALUE	BASIS
Coverage per litre - single coated face	4-6 m^2 *	Porosity dependent
Consumption per coated face	0.17-0.25 L/m^2 *	1 ÷ 4-6 m^2/L
Coverage per litre - bonded area, both faces coated	2-3 m^2 *	Half the single-face rate
Consumption per m^2 of bonded area	0.33-0.50 L/m^2 *	Twice the single-face rate
Theoretical yield - 4 L pack	8-12 m^2 of bonded area	4 L ÷ 0.33-0.50 L/m^2
Practical yield - 4 L pack	7-10 m^2 of bonded area	10% wastage allowance
Theoretical yield - 20 L pack	40-60 m^2 of bonded area	20 L ÷ 0.33-0.50 L/m^2
Practical yield - 20 L pack	36-54 m^2 of bonded area	10% wastage allowance
Wet film	Thin, continuous, even film on each face	Closed film, not a heavy build

Porous, open-textured substrates such as unprimed masonry and timber-based sheeting absorb more adhesive than dense primed concrete or metal, and may exceed the range above. Where the sheet membrane TDS specifies a two-coat method, allow for the extra coat. A continuous film on both faces and full contact pressure are the acceptance criteria, not a nominal spread rate - establish the rate on a trial area.

Substrates and Compatibility

SUBSTRATE	REQUIREMENT
Concrete, masonry, render, screed and fibre cement sheet	Cured, sound and dry; primed where the sheet membrane TDS requires it
Timber, plywood, MDF and particleboard	Structural grades, rigid and securely fixed
Hardboard and wallboard	Clean, dry and securely fixed
Steel and aluminium	Abraded to clean bright metal and solvent-wiped immediately before bonding
Rubber and butyl rubber products	Clean, dry and free of release agents
Ceramic tile and linoleum	Clean, dry and free of polish and wax
Acoustic tiles	Other than expanded polystyrene grades

Not compatible: copper and copper-bearing alloys, expanded polystyrene, unsupported PVC, polyethylene and polypropylene.

Surface Preparation

Prepare both faces to be joined before any adhesive is applied - once the first face is coated, the open time is running.

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Surface Preparation (continued)

- Substrates must be clean, dry and structurally sound, free of oil, grease, dust, laitance, curing compounds, release agents and loose particles.
- Concrete must be a minimum of 28 days old and mechanically prepared to the sheet membrane system TDS.
- Substrate moisture 4.5% or below - bond directly, or prime where the sheet membrane TDS requires it.
- Substrate moisture above 4.5% - prime with two coats of ACTFLEX EP250 per its TDS, and allow full cure before adhesive.
- Abrade metals to a clean bright surface and wipe with a solvent cleaner permitted by the current SDS immediately before bonding.
- Reinstate damaged or spalled concrete with a FORSPEC concrete repair system such as FORBUILD 100 or FORCRETE 100, fully cured.
- Vacuum all dust immediately before adhesive application.

Mixing

ACTFLEX 301 R is supplied ready to use. Stir thoroughly with a flat paddle at low speed to redisperse settled solids, without whipping air into the adhesive. Do not thin or dilute. Reseal the container immediately after decanting - solvent loss thickens the remaining product and shortens its usable life.

Application

Apply ACTFLEX 301 R to both faces, allow both to tack up, then join and roll to full contact pressure.

- Apply an even, thin coat to BOTH faces by brush, roller or scraper. A single-sided coat will not develop the bond.
- Allow both faces to become touch dry - approximately 7 to 12 minutes at 25°C and 50% RH.
- Test tack with the knuckles: the film should feel tacky but leave nothing on the skin.
- Join within approximately 30 minutes. If exceeded, apply a fresh thin coat to one face and let it tack up again.
- Align the sheet before contact. The bond forms on contact and the sheet cannot be repositioned.
- Roll the full bonded area to a minimum of 276 kPa (40 psi), working from the centre outwards to expel trapped air.
- Roll laps, perimeters, upstands and terminations a second time - bond failure begins at these locations.
- Checks: both faces coated and tack dry; sheet aligned; full area rolled; no trapped air, blisters or lifted edges.

One-Way Stick Method

Where one or both faces are confirmed porous, adhesive may be applied to one face only and the bond made immediately, without waiting for tack-up. The porous face absorbs solvent and allows the bond to develop. Between two non-porous faces this method will not develop bond strength, and the failure will not show until the sheet lifts in service. Where there is any doubt, coat both faces.

Drying, Curing and Service Times

Times run from application at 25°C and 50% RH. Cold, humidity and poor ventilation extend every stage; heat and air movement shorten tack-up and open time. Keep enclosed spaces ventilated throughout.

STAGE (AT 25°C, 50% RH)	TIME
Tack dry - ready to join	Approx. 7-12 minutes *
Open time - maximum before joining	Approx. 30 minutes *
Green strength	Immediate on contact
Full bond, service loads, heat and water contact	After 24 hours * - protect from movement until then

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Clean Up

Clean tools and remove excess adhesive immediately while wet, using a solvent cleaner permitted by the current Safety Data Sheet, handled in accordance with the WHS Regulations with ignition sources controlled. Solvent cleaners may stain vinyl, lacquered and light-coloured PVC surfaces. Cured adhesive can only be removed mechanically. Never discharge product, solvent or wash water to sewer, stormwater, soil or waterways.

Container and Waste Disposal

Uncured (liquid) product is classified waste - deliver to an authorised hazardous or special waste collection point in accordance with local regulation. Small residues may be dried out in a ventilated area well away from ignition sources and, once the solvent has fully released, disposed of as solid waste where permitted. Empty containers retain flammable vapour - do not cut, weld, drill, burn or reuse them. Store solvent-contaminated rags in a sealed metal container pending disposal. Dispose of containers in accordance with State or Territory EPA requirements and local council regulations. Refer to Section 13 of the SDS.

Quality Records

Record the batch numbers of adhesive and sheet membrane, the substrate, its moisture reading and preparation, the primer used, the trial spread rate and actual consumption, ambient and substrate temperature, tack-up and joining times, the contact pressure method, and inspection of laps, perimeters and terminations, as part of the project quality assurance records.

Storage

Store in original, sealed containers in a cool, dry, well-ventilated place, out of direct sunlight and away from all ignition sources, in a flammable liquids store that complies with local, State and Federal requirements. Store locked up. Store between 5°C and 20°C for maximum shelf life. Do not store in pits, basements or unventilated spaces where vapour can collect. Reseal containers immediately after use. Shelf life is 12 months from the date of manufacture, unopened, when stored as specified.

Safety Precautions and First Aid

ACTFLEX 301 R is classified as a HAZARDOUS CHEMICAL and DANGEROUS GOODS (Class 3, UN 1133) under its current Safety Data Sheet (Chemwatch 9041-96). Signal word: DANGER. It contains toluene, 2-methylpentane, acetone, rosin and zinc oxide. Highly flammable liquid and vapour. Harmful if swallowed. Causes skin irritation. May cause an allergic skin reaction. Causes serious eye irritation. May cause drowsiness or dizziness. Suspected of damaging the unborn child. May cause damage to organs through prolonged or repeated exposure. Toxic to aquatic life with long lasting effects.

Vapour is heavier than air, collects in pits, basements and enclosed wet areas, and can travel to a distant ignition source and flash back. Eliminate all ignition sources - no smoking, naked flame, hot works or spark-producing tools - and never weld membrane laps while adhesive solvent is still flashing off. Ground and bond containers, use non-sparking tools and explosion-proof equipment, and provide continuous mechanical ventilation, particularly at floor level. Do not use in a confined space without a confined-space assessment. Pregnant workers should not handle this product.

Wear laminate (PE/EVAL/PE) chemical-resistant gloves, overalls, a PVC apron, safety footwear and sealed eye protection. Where vapour approaches the exposure standard, wear a respirator with a Type AX-P filter to AS/NZS 1715 and AS/NZS 1716. Do not eat, drink or smoke when using this product. Contaminated work clothing must not leave the workplace. Prevent release to drains, soil and waterways.

First aid - Eyes: rinse immediately with fresh running water, holding the eyelids apart, and seek medical attention without delay. Skin: remove contaminated clothing and wash with plenty of soap and water; seek medical advice if irritation or rash occurs. Inhaled: move to fresh air, lay the person down and keep warm and rested; seek medical attention without delay if drowsiness, dizziness or breathing difficulty occurs. Swallowed: do not induce vomiting - aspiration of solvent into the lungs is the principal danger; rinse mouth and seek medical advice immediately. POISONS INFORMATION CENTRE: 13 11 26 (Australia-wide, 24 hours). In an emergency, dial 000. KEEP OUT OF REACH OF CHILDREN. Read the Safety Data Sheet (SDS) before use - available at www.forspec.com.au.

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Warranty

Standard Product and Performance Warranty: Forspec Protective Coatings Pty Ltd as Trustee for Forspec Protective Coatings (ABN 11 204 033 631) warrants that ACTFLEX 301 R will be free from manufacturing defects and will not fail under normal usage for a period of ten (10) years from the date of purchase, when installed and used strictly in accordance with this Technical Data Sheet and Forspec's written instructions. This warranty covers the supply of the product only; it does not cover installation, application or workmanship. Remedies are limited, at Forspec's discretion, to replacement of the defective product (or defective portion) or a refund of the purchase price. The full terms, conditions and exclusions are set out in the Forspec Standard Product and Performance Warranty, available at www.forspec.com.au - key conditions include application by a suitably qualified and, where required by law, licensed applicator; use within shelf life; and installation as part of a Forspec approved system without non-approved third-party products.

Project and system warranties: extended project-specific warranties are available at the request of the applicator and must be applied for using the Forspec Warranty Request Form prior to commencement of works. Issue is subject to Forspec approval and is conditional on the use of the complete specified FORSPEC system, application in strict accordance with the current TDS by suitably qualified applicators, and completion of the project quality records described above. The warranty period and terms are as stated in the issued warranty certificate.

Claims: notify Forspec in writing within thirty (30) days of discovery of the alleged defect and within the warranty period, by post to 22/872 Canterbury Road, Roselands NSW 2196 or by email to info@forspec.com.au, including proof of purchase, installation details (date, location, installer), a description of the defect with supporting evidence, and your contact details. Forspec may inspect the site, perform testing and collect samples before determining a claim.

Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Data Sheet Currency

This Technical Data Sheet (TDS) and the corresponding Safety Data Sheet (SDS) are subject to revision as necessary to ensure compliance with relevant Australian Standards and to incorporate technological advancement. Read the most current versions before use, as application and performance data may be updated. For the latest technical information, contact Forspec Protective Coatings on (02) 8021 3517 or info@forspec.com.au. The information provided is representative and does not serve as a comprehensive specification. For specific projects, consult directly with Forspec Protective Coatings for tailored specifications. This data sheet was issued on 12/11/2026 and is valid for three years from the date of issue unless superseded by a later revision - always confirm the current version at www.forspec.com.au before use.

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