

Joint Preparation

Joint surfaces should be clean, dry and free from all contamination including: dirt, oils, grease, tar, wax, rust and any other substance that may inhibit the sealant's performance.

Joint Design

Install all joint applications per ASTM and SWRI recommendations and guidelines. Joints shall be designed with a depth to width ratio of 1:2 (joint depth one-half the width). Control the depth of the sealant by using a polyethylene backer rod that is 25% larger than the joint opening at standard temperature. To prevent three-point adhesion use a backer rod or bond breaker tape to ensure proper joint movement and a long lasting weatherproof seal. Where the joint configuration will not permit a backer rod, CHEM LINK recommends that an alternative bond breaker be used.

Joint Width Inches (mm)	Joint Depth Inches (mm)
1/4 - 1/2 (6-13)	1/4 (6)
1/2 - 3/4 (13-19)	1/4 - 3/8 (6-10)
3/4 - 1 (19-25)	3/8 - 1/2 (10-13)
1 - 2 (25-50)	1/2 (13)

CHEM LINK recommends an appropriate substrate primer to be used on high moving joints or dissimilar substrates which require increased adhesion properties.

Compatible Substrates*	
Kynar 500® PVDF Coated Metal	Tedlar® PVF
Galvanized Metal	Glass
Aluminum	EPS Foam
Copper	Engineered Plastics, PVC
Stainless Steel	Fiberglass FRP

**Test and evaluate to ensure adequate adhesion.*

Typical Physical Properties		
Gun Grade	Zero Slump	
Viscosity	550,000 cp +/- 150,000 cp	Brookfield RVF TF Spindle, 4 RPM, 73°F (23°C)
Density	8.3 lbs per gallon	ASTM D1475
Tack Free Time	10 min +/- 5 min	45 +/- 5 % R.H.
Elongation at Break	600%	ASTM D412
Hardness Shore A	10 +/-3	ASTM C661
Shear Strength	75 +/-5 psi	ASTM D1002
Tensile Strength	135 psi	ASTM D412
Low temp. flex	Pass -10°F (-23°C) 1/4 inch mandrel	ASTM D816
Shrinkage	No visible shrinkage after 14 days	
Service Temperature	-80°F to 400°F (-62°C to 204°C)	

Basic Uses	
Window and door frames	Siding
Metal Flashing	Weather Sealing
Roofing	Cove Joints
Curtain Walls	Parapets
Expansion joints	Transportation

NOTES:



Contractor Hot Line

800-826-1681

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All properties described in this document are derived from testing conducted in laboratory conditions. Properties and performance will vary depending on environmental conditions and application technique. Test and evaluate to determine appropriate usage. Visit www.chemlink.com for the Safety Data Sheet, Technical Data Guides and full warranty for this product.

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