



FULASEALPRO 660 HIGH PERFORMANCE SILICONE

Description

FulasealPRO 660 High Performance Silicone is a high performance neutral cure sealant specially formulated for use in situations where a high tensile strength silicone is required that skins quickly and provides long term performance. FulasealPRO 660 High Performance Silicone has a rheology that makes it ideal for applications where a high level of slump resistance is required. FulasealPRO 660 High Performance Silicone combines resistance to weathering with excellent adhesion and flexibility.

Benefits

- Permanently flexible
- Seals water tight
- Non slump (tested in applications at 80°C)
- Neutral cure
- Superior performance to that of standard silicones
- Approved for use in contact with potable water, complies with AS 4020
- UV and weather resistant
- One part, ready to use
- 25% dynamic movement capability
- 25 year guarantee against cracking and crumbling when used in standard conditions and applications.

Uses

- General glazing including colonial bars, butt joints and glass fins, partitions
- Bonding glass, plastics
- Filling channels
- Bonding of solar hot water collectors. Excellent slump resistance at high roof temperatures
- Water tank production

Compatible Substrates

Glass	Timber
Steel	Concrete
Aluminium	Some plastics (test)
Ceramic	Fiberglass

Coverage

300ml cartridge will give approximately 15 lineal meters of a 5mm bead

Performance Data

Property	Data
Specific Gravity	1.04g/ml
Sag	Nil
Tooling Time	5-10 minutes
Skinning Time	2-5 min, 25°C, 50% RH
Cure Rate	2-3 mm / day, generally
Joint Movement Capabilities	± 25%
Hardness	28 Shore A
Modulus – 50%	0.63MPa
Modulus – 100%	0.67MPa
Tensile Strength	1.9 MPa
Elongation	560%
Temperature range	-60°C to 170 °C*

Our Focus is Clear. Perfecting Adhesives.

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*Above stated service temperature is the constant in service temperature. FulasealPRO 660 High Performance Silicone is capable of transient temperatures up to 205°C, though constant exposure to temperatures in excess of 170°C will lead to an increase in the durometer hardness of the sealant and deterioration over time.

Limitations

- Powder coated metal surfaces may have high wax contents. Ensure that these surfaces are solvent cleaned before applying silicone.
- Not for structural/direct glazing.
- Not for permanent or continuous water immersion.
- Not recommended in situations where movement exceeds $\pm 25\%$ of the original joint dimensions.
- Not recommended for use on polycarbonate plastic sheeting.
- Not suitable for use where high abrasion, e.g. foot traffic is expected.
- Not paintable, do not use on freshly painted surfaces.
- Do not use on bituminous surfaces.
- Do not use on materials that bleed oils, plasticisers or solvents as this will affect adhesion.
- Will not cure in absence of atmospheric moisture

Surface Preparation

All surfaces must be clean, dry, sound and free of dust, oil, old sealant or other contamination.

Lightly contaminated surfaces should be wiped with Isopropyl Alcohol (IPA) using the 2-rag wipe method. Apply IPA to a clean lint-free cloth and wipe onto the surface to be cleaned to solubilise and remove the majority

of the contaminant. A clean dry cloth should then be applied to remove remaining contamination and dry the surface. Ensure wet cleaner is not allowed to dry on surface. For more heavily contaminated surfaces or where the IPA does not remove the contaminant, a generic wax and grease remover should be applied using the same 2-rag wipe method. Once this has been completed the surface should be given a final clean with IPA using the 2-rag wipe method to ensure the surface is adequately prepared. Adhesion to metals and some surface finishes can be further improved by light abrasion prior to cleaning with IPA using the 2-rag-wipe method. For glazing applications IPA should be used to clean and prepare the surface. Manufacturers of plastics should be consulted about suitable cleaning solvents. Adhesion to plastics should be pre-tested. Mask either side of joint to produce a neat finish. Use a suitable sized foam backing rod or polyethylene bond breaker tape to prevent three sided joint contact impeding the free and even deformation of the sealant in a cyclic joint.

Product Application

Cut seal on top of cartridge. Screw on nozzle and cut to desired bead size. Hold gun at 45° angle. Push forward, squeezing trigger to gently fill joint. Within 5 minutes of application tool the sealant, ensure the sealant wets the sides of the joint. If masking tape is used to produce a neat finish, remember to remove the masking tape before the sealant skins. Trim with a knife once cured, if needed

Painting

Mask all areas not requiring sealant.

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Paint will not adhere to silicone. Complete any painting and allow to thoroughly dry before applying sealant.

Chemical Resistance

Resistant to water, salt water, grease, oils, fuels, defrosting liquid, detergents, aliphatic fats, mildew, weak acids and bases (pre testing required).

Curing

The rate of cure depends on the air temperature and humidity, the cross sectional area of the bead of sealant and the surface area of sealant exposed to the air.

At 25°C and 50% relative humidity cure rate is 2-3 mm / 24 hours.

In general, low humidity and/or low temperature will result in longer cure times.

Thicker sections of sealant will have longer cure times. A small surface area in relation to the volume of sealant will also extend the cure time. Ensure that the depth of the sealant in a joint never exceeds its width.

Shelf Life

FulasealPRO 660 High Performance Silicone will remain suitable for use for 12 months from date of manufacture, if stored in original container, unopened, in cool dry place in temperatures less than 30°C.

Once opened, the contents should be used as soon as possible. The life of contents of an opened cartridge can be extended if the nozzle is left in place after use and the tip is wrapped in plastic film.

Clean Up

Best results are obtained by masking prior to sealing to avoid the necessity for clean up. If sealant is applied to areas where it is unwanted, clean up uncured sealant using toluene, xylene, methyl ethyl ketone, or mineral turpentine* and a cloth. Cured sealant should be removed by abrasion or trimmed with a sharp knife. Do not undercut seal.

Safety Information

This product is not considered to be hazardous according to criteria of NOHSC. Avoid contact with skin and eyes. Store in a dry place below 30°C. Keep out of reach of children. A MSDS is available from the H.B. Fuller representative your state, HB Fuller Australia customer service, or downloadable from the HB Fuller web site, www.hbfuller.com.au.

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