

PRODUCT DATA

Date: March 2001

Code: 95445/20

BOSTIK P5125

HOT MELT BUTYL INSULATING GLASS SEALANT

Bostik P5125 Hot Melt sealant has been specially developed for the edge sealing of factory produced insulating glass units. Bostik P5125 is a single part 100% solids compound. When applied at the correct temperature it sets quickly from its molten state, allowing units to be moved from their assembly location within 5 minutes of application. Units can therefore be sealed and glazed within the same day, enabling fast and efficient response to customers' needs and requirements. Bostik P5125 demonstrates exceptional technical performance with only a single seal required.

Features

- Compatible with most hot melt applicators designed for insulating glass.
- Rapid unit production - smooth flow, fast gunning.
- Zero waste - non slump.
- Very low Moisture Vapour Transmission Rate (MVTR) - for maximum unit life.
- Rapid unit handling - single part fast setting.
- Convenient pack size for easy storage.
- No cleaning or purging of dispensing equipment required.

Product Characteristics

Packaging	7kg block, 18kg pail
Constitution	Hot Melt Butyl rubber/polymer blend
Colour	Black
Form	Rubbery solid with a slightly tacky surface.
Specific Gravity	1.15 to 1.19

Typical Performance

Adhesion	Excellent adhesion to glass and aluminium spacer bar.
Application Temperature Range	+180° to +195°C ex nozzle.
Flexibility	Not brittle at -30°C
Shore A Hardness	60 to 65 instantaneous reading at 23°C
Water Absorption	Less than 1% by weight at 25°C.
Water Permeability	Extremely low.
Argon Permeability	Extremely low.
Solvent Resistance	Attacked by hydrocarbon based solvents e.g. White Spirit

Storage/Shelf Life

Bostik P5125 Hot Melt sealant should be stored under dry conditions between 5°C and 25°C. Prevent damage to the sealant containers (drums in particular) as denting may inhibit the function of application equipment. Under these conditions of storage the usable life will be at least 2 years.

Method of Use

IMPORTANT

Before embarking on any work involving Bostik P5125 Hot Melt sealant the Safety Data sheet should be carefully studied by those carrying out the work. Gloves and eye protection are recommended. Always ensure that the Hot Melt application equipment is properly maintained according to the manufacturer's instructions. The sealant temperature, ex nozzle, should be checked regularly (see Bostik Findley P5125 user guide) with a suitable, calibrated digital thermometer.

Surface Preparation

Place the sealed unit in a horizontal position ensuring that the cavity width and depth dimensions conform to those recommended by Bostik Findley (see Bostik Findley P5125 user guide). The cavity surfaces must be clean and dry and free from foreign matter. For small-scale usage, the glass can be cleaned by hand using Evo-Stik 6440 glass cleaner, which has been specifically formulated for glass cleaning. The safe usage of Evo-Stik 6440 is described in separate safety and product data sheets.

Application

Sealant application should be carried out at minimum workshop and glass temperatures of not less than 15°C.

Unit life can be adversely affected by any of the following errors during manufacture, which should be avoided.

- 1) Reducing the sealant depth to below the recommended levels (see Bostik Findley P5125 user guide).
- 2) Application of the sealant outside of the recommended temperature range.
- 3) Incomplete filling of desiccant into the spacer tubes. (For units with cavities below 12mm Bostik Findley recommend that all four sides of the spacer frame are filled with desiccant).
- 4) Dirty, wet or otherwise contaminated glass can reduce the adhesion of the sealant to the glass. This may allow moisture to pass into the unit cavity and cause early failure.
- 5) Reduction of the seal depth because of worn applicator sealing nozzle guide.
- 6) Gaps and holes left in the sealant such that it is not continuous without break around the entire unit.

This Product Data Sheet covers just one of a large range of products supplied by Bostik Findley Limited. Full information on these products and advice on application is freely available from our fully trained staff throughout the country. In addition, specialist technical advice is available from our Technical Services Department. This Product Data Sheet supersedes all previous technical information on this product, and users of it are cautioned to ensure that it is the current issue. Destroy all previous Product Data Sheets, and if any doubt, contact Bostik Findley Limited, quoting the code number in the top right hand corner on the front of this document. This leaflet is for general guidance only and may contain inappropriate information under particular conditions of use. The company cannot accept any responsibility for loss or damage that may result from the use of this information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm the suitability of this product by their own tests.

Bostik Findley Limited, Ulverscroft Road, Leicester, LE4 6BW, England. Tel: +44 (0)1785 272727 Fax: +44 (0)116 268 9299 www.Bostik-Findley.co.uk

Application Continued

The sealant should be applied by means of a suitable heated dispenser. It is very important that the sealant is applied within the recommended temperature range, therefore it is advisable that the application temperature be checked (according to Bostik Findley's recommended procedures) at the gun nozzle whilst gunning sealant into the machine hopper (see Bostik Findley P5125 user guide). Further advice can be gained from Bostik Findley's technical service department.

The sealant should be applied into the cavity of the unit in such a manner that complete wetting of the glass and spacer occurs. If an internal locating nozzle is used, the nozzle should be checked regularly to avoid excessive wear in order to ensure that the correct seal depth is maintained. Care should be taken on sealing each corner to ensure that a complete seal is made around the corner and that holes and hairline cracks (cold joins) are excluded. Ensure that the corners are properly filled and squared off so that there are no shortages of sealant. It is recommended that each corner should be pressed together (by means of proprietary silicone rubber pads) whilst still molten. If units are to be stored on a rack, ensure that there is adequate support under both panes of glass.

Glazing Method

Before Glazing, wooden frames should be allowed to dry completely after staining, preservative treatment or painting. Solvents should not be used to clean the unit.

Units manufactured with Bostik Findley's Bostik P5125 should be glazed in accordance with current GGF (Glass and Glazing Federation) methods or other current GGF recognised and approved methods.

Edge taping is not essential for sealed units made using Bostik P5125. If an edge tape is used, it must be dimensionally stable and incapable of causing damage to the sealed edge.

Drained and ventilated systems should be used wherever possible otherwise approved and current fully bedded glazing methods are necessary.

If units are to be glazed into a glazing compound that is likely to be in contact with the edge seal of the unit, then it is important to ensure its compatibility with the P5125 sealant before glazing.

Further detailed information can be gained from the Bostik Findley P5125 user guide and from the Bostik Findley Technical Service Department

Precautions in Use

For full precautions in use, first aid instructions and spillage and disposal instructions, see separate Safety Data Sheet.

This Product Data Sheet covers just one of a large range of products supplied by Bostik Findley Limited. Full information on these products and advice on application is freely available from our fully trained staff throughout the country. In addition, specialist technical advice is available from our Technical Services Department. This Product Data Sheet supersedes all previous technical information on this product, and users of it are cautioned to ensure that it is the current issue. Destroy all previous Product Data Sheets, and if any doubt, contact Bostik Findley Limited, quoting the code number in the top right hand corner on the front of this document. This leaflet is for general guidance only and may contain inappropriate information under particular conditions of use. The company cannot accept any responsibility for loss or damage that may result from the use of this information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm the suitability of this product by their own tests.

Bostik Findley Limited, Ulverscroft Road, Leicester, LE4 6BW, England. Tel: +44 (0)1785 272727 Fax: +44 (0)116 268 9299 www.Bostik-Findley.co.uk