

**PRODUCT DATA**

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# EVO-STIK HIFLO

## HOT MELT INSULATING GLASS SEALANT

Evo-Stik Hiflo Hot Melt Sealant has been specifically formulated for use in the production of insulating glass units. Evo-Stik Hiflo is a single part butyl rubber based sealant which, when applied at the correct temperature, sets quickly from its molten state allowing units to be moved from their assembly location between two and five minutes after application. Units can therefore be sealed and glazed within the same day. Evo-Stik Hiflo has a high output and fast heat loss enabling optimum turn round of unit production. The combination of these properties also means that corner defects can be easily avoided thereby ensuring a complete seal around the unit.

### Features

- Compatible with all types of dispensing equipment currently available.
- Quick-setting from the molten state.
- Clean application with no wastage.
- No cleaning or purging of dispensing equipment required.
- Can be used as a secondary seal in conjunction with a P.I.B. primary Sealant such as Hiflo 2900. Consult Bostik Findley Technical Services.
- Convenient pack sizes for easy storage.

### Certification

Sealed units made using Evo-Stik Hiflo have been fully tested to the following industry standards:

United Kingdom	BS 5713.
Holland	NEN 3567 including 2000 hour Weatherometer Test and gas rate loss.
Germany	DIN 1286.
Proposed CEN	prEN 1279.

### Product Characteristics

Packaging	Evo-Stik Hiflo Hot Melt Sealant is supplied in: 18 kg pail. 6 litre block. 14 litre block.
Constitution	A blend of butyl rubber with other synthetic polymers and resins, which contain no volatile materials.
Colour & Form	Black rubbery solid.
Density	1.1 g/cm <sup>3</sup> .

### Typical Performance

Moisture Vapour Transmission Rate	<0.1 g/m <sup>2</sup> per day for a 2 mm film at 25°C, 100% RH. (ASTM method E96).
Application Temperature	From 190°C to 205°C

### Storage/Shelf life

Evo-Stik Hiflo Hot Melt Sealant should be stored in unopened containers in dry conditions within the temperature range 5°C-25°C. Under these conditions the usable life will be at least 12 months.

### Method of Use

#### IMPORTANT

Before embarking on any work involving Evo-Stik Hiflo Hot Melt Sealant the Safety Data Sheet should be carefully studied by those carrying out the work. Gloves and eye protection are recommended.

#### Surface Preparation

Evo-Stik Hiflo Hot Melt Sealant exhibits excellent adhesion to cut, ground or polished glass, aluminium and galvanised steel spacer bar. It is essential that all surfaces are clean and dry and free from foreign matter. For small scale usage, the glass can be cleaned by hand using Evo-Stik Window 6440 Glass Cleaner which has been specifically formulated for glass cleaning. The safe usage of Evo-Stik Window 6440 Glass Cleaner is described in a separate Product Data Sheet.

#### Application

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 daily with a digital thermometer at the gun whilst gunning sealant. Further advice can be obtained from the Bostik Findley Technical Service Department.

The sealant should be applied into the cavity of the insulating glass 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 and the sealant should be pressed together whilst still molten by means of a silicone rubber pad, in order to prevent any holes or gaps in the sealant at the corners, which could lead to premature unit failure. If the units are to be stored on a rack ensure that they are adequately supported under both panes of glass.

#### Glazing Method

Units manufactured with Evo-Stik Hiflo should be glazed in accordance with the current G.G.F. (Glass and Glazing Federation) methods or other G.G.F. recognised and approved methods. Further information may be obtained from the Bostik Findley Technical Service Department. The use of adhesive tape is not recommended to cover the edge of the unit.

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

If the unit is to be glazed using a glazing compound which is likely to be in contact with the edge seal of the unit, then it is important to ensure its compatibility with the Hiflo Sealant BEFORE glazing.

Further detailed information can be obtained from the relevant Hiflo Technical Bulletin 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.

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