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CAW P22 Uniclass L675:P99			

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Description

SP525 is a low modulus sealant and adhesive formulated using advanced tremco illbruck SP polymer technology. It has high movement capability, excellent primerless adhesion to many substrates and long-term performance.

Colour

402 white	278 oyster white	105 concrete grey
211 light grey	237 medium grey	019 anthracite
053 black	332 sandstone beige	077 buff
219 light sandstone beige		

Packaging

600 ml sausage (20 per carton)

Technical Information

Property	Test Method	Results
Composition		advanced SP polymer formulation
Category		EN 1561-1 F-EXT-INT-CC
Specific Gravity		1.6
Consistency	EN 27390, 20 mm profile	Non-sagging
Shore A Hardness		25
Skin Forming Time	at +23°C, 50% RH	Approximately 30 minutes
Tack Free Time	at +23°C, 50% RH	60 minutes
Cure Rate	at +23°C, 50% RH	3 mm /first day
Tensile Strength	DIN 53504 S2	1.35 MPa
Modulus at 100% Elongation	ISO 8339	0.38 MPa
Elongation at Break	DIN 53504 S2	Approximately 550%
Movement Accommodation	IS) 9047	50%
Elastic Recovery	EN 27389-B	74%
Application Temperature		+5°C to +40°C
Service Temperature		-40°C to +90°C
Storage		Store in dry conditions between +5°C and +25°C
Shelf Life		12 months when stored as recommended in original unopened containers

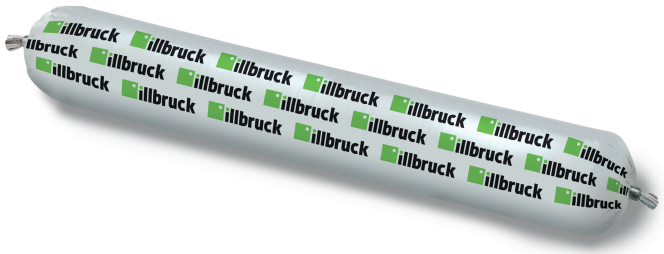
Necessary Tools

- Sausage application gun, smoothing tools such as AA311, and AA301 Smoothing Agent for sealant applications.

Priming

- SP525 has excellent primerless adhesion to many typical construction materials. Primer AT140 may be required for some porous substrates and AT150 for some non-porous substrates. For special situations, or if in doubt, please contact tremco illbruck Technical Services Department.

Adhesion Table



SP525

Frame and Façade Sealant & Adhesive

Usage / Purpose

SP525 is ideal for sealing joints in façades, rainscreens and curtain walls, perimeter joints around windows, doors and rooflights, and high movement joints (e.g. modular building). It is also used for the bonding of ME500 & ME501 Intelligent Window Membranes.

Key Benefits

- Meets the requirements of EN ISO 11600 F 25LM
- Formulation based on advanced SP polymer technology
- High movement, rapid curing and extremely low risk of staining**
- Excellent long-term resistance to weathering, ageing and UV
- Low modulus formulation ensures minimum stress at joint faces
- High strength bonding of ME500 & ME501 Intelligent Window Membranes
- Weather and airtight sealing of ME500 & ME501 Intelligent Window Membranes

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ABS	+, AT150	Polyamide	+, AT150
Acrylic glass (PMMA)	+, AT150	Polyester (reinforced with glass fibers)	+
Aluminium	+, AT150	Polypropylene	AT150
Brass	AT150	Polystyrene	+, AT150
Brick	AT140	PPC or Powder coating	+, Test
Concrete	+, AT140	PVC foil	+, AT150
Copper	AT150	PVC rigid	+, AT150
Electrically anodized aluminium	+, AT150	Sanitary Acrylic coloured	+, AT150
Glass	+	Stainless steel	+, AT150
Hot dip galvanized steel	+, AT150	Tiles back side	AT140
Iron	AT150		

+ = good adhesion can normally be expected without primer
Reference numbers (e.g. AT111) show the type of illbruck primer required to improve adhesion

Joint Design Considerations

- Joint design to be in accordance with BS 6093.
- For the purposes of joint width calculation in BS 6093, the MAF of SP525 is 50%.
- Minimum joint width should normally not be less than 5 mm.
- Typical maximum joint width of 30 mm, however for all large joints (greater than 30 mm), please contact tremco-illbruck to discuss project specifics.
- Width to depth ratio should typically be 2:1.
- Minimum width to depth ratio should typically be 1:1. Please note MAF is reduced at smaller width to depth ratios.
- The minimum contact area with any substrate (including for fillet joints) should be determined by the quality of the bond. If in doubt please contact tremco-illbruck.
- PE backing rod should be used in all parallel joint applications.

Surface Preparation

- Always carry out a test to confirm compatibility prior to use.
- Surfaces must be clean, free from grease and must be stable and dry.
- For non-porous substrates use cleaner AT200, do preliminary test.
- Use a brush to remove loose particles from joints.
- For plastics and powder coatings, clean with AT115 and conduct preliminary tests to confirm compatibility.

Application as a Sealant

- Application should be in accordance with BS 8000:16 - "Code of practice for sealing joints in buildings using sealants".
- Design of joints should be in accordance with BS 6093:2006.
- Apply between +5°C and +40°C using conventional sausage gun.
- All beads should be tooled after application to ensure firm, full contact with the joint faces using smoothing tools such as AA311 and AA301 Smoothing Agent.

Application as a Membrane Adhesive

- Apply between +5°C and +40°C
- An 8-10 mm diameter bead of SP525 should be applied to the window and/or construction material so that when the ME500/501 Membrane is located, the bead is 12- 15 mm inside the edge of the membrane.
- Once the membrane is positioned, compress so that the bead is approximately 25- 35 x 2 mm.
- Consolidate the bond with a seam roller. Take care not to allow adhesive to exude out from the edge of the membrane and potentially stain the frame.

Coverage

Width x Depth (mm)	Linear metres per 400 ml Sausage	Linear metres per 600 ml Sausage
6 x 6	11.1	16.7
10 x 6	6.7	10.0
10 x 10	2.0	3.0
20 x 10	1.3	2.0

Fillet Width x Depth (mm)	Fillet Linear metres per 400 ml Sausage	Fillet Linear metres per 600 ml Sausage
6 x 6	22.2	33.3
10 x 10	8.0	12.0

Circular Bead for Bonding Membranes (mm)	Linear metres per 400 ml Sausage	Linear metres per 600 ml Sausage
8	7.9	11.9
10	5.1	7.6

Cleaning of Equipment

Remove excess sealant immediately with AT200 Cleaner. Ensure surface is solvent resistant before cleaning. Cured sealant can only be removed mechanically.

Please Note

Contact with bituminous or tar containing surfaces can lead to discolouring. Not suitable for bonding to polyethylene, silicone, butyl rubber, neoprene or EPDM. Not suitable for areas permanently immersed in water.
tremco illbruck provide a service for testing compatibility of our adhesives/sealants with 3rd party materials and would advise that our representative is made aware of this requirement in order to organise appropriate samples and to instigate the required testing (comprehensive testing takes up to 4 weeks).
** Whilst illbruck have not experienced any complaints due to migratory staining, prior tests on natural stone and decorative concrete are recommended. FA870 and FA880 are alternative sealants safe for use on natural stone.

Health & Safety Precautions

Safety data sheet must be read and understood before use.

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Technical Service
tremco illbruck has a team of experienced Technical Service Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please call Customer Service on 01942 251400.

Guarantee / Warranty
tremco illbruck products are manufactured to rigid standards of quality. Any product which has been applied (a) in accordance with tremco illbruck written instructions and (b) in any application recommended by tremco illbruck, but which is proved to be defective, will be replaced free of charge.
No liability can be accepted for the information provided in this leaflet although it is published in good faith and believed to be correct.
tremco illbruck Ltd. reserves the right to alter product specifications without prior notice, in line with Company policy of continous development and improvement.

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