**Description**

LD410 Duct Sealant is a single-part gun grade duct sealant. The formulation is based on an emulsion acrylic polymer system, which gives a firm, but flexible seal in low movement joints.

**Colour**

Grey

**Packaging**

310 ml cartridge (25 per carton)

**Technical Information**

<table>
<thead>
<tr>
<th>Property</th>
<th>Test Method</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Composition</td>
<td></td>
<td>water based acrylic</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td></td>
<td>1.62 - 1.66</td>
</tr>
<tr>
<td>Shore A Hardness</td>
<td></td>
<td>30</td>
</tr>
<tr>
<td>Tack Free Time</td>
<td>at 23°C, 50% RH</td>
<td>15-60 minutes</td>
</tr>
<tr>
<td>Movement Accommodation</td>
<td></td>
<td>±12.5%</td>
</tr>
<tr>
<td>Application Temperature</td>
<td></td>
<td>+5°C to +40°C</td>
</tr>
<tr>
<td>Service Temperature Range</td>
<td></td>
<td>-15°C to +75°C</td>
</tr>
<tr>
<td>Storage</td>
<td>Store in shaded dry conditions between +5°C and +25°C</td>
<td></td>
</tr>
<tr>
<td>Shelf Life</td>
<td>12 months when stored as recommended in original unopened containers</td>
<td></td>
</tr>
</tbody>
</table>

**Necessary Tools**

- Cartridge gun and sharp knife.

**Protective Equipment**

Use in well ventilated conditions and ensure all recommended protective equipment is worn during handling & use of this product. For full recommendation, refer to safety data sheet.

**Priming**

- No priming required.

**Surface Preparation**

- Joints should be clean, dry and free from substances likely to impair adhesion.
- Loose friable material should be removed.
- Use mechanical abrasion to clean non-porous surfaces if necessary.
- Joint width and joint depth should not be less than 3 mm to ensure adequate penetration of the sealant and performance.
- For sealing around door and window frames the minimum joint width should be 6 mm.

**Joint Backing**

- If necessary back fill the joint with polyethylene joint backing in order to control the depth of sealant.

**Usage / Purpose**

LD410 has been designed for the permanent sealing of low movement assembly joints in low, medium and high pressure ductwork installations to prevent loss of air pressure. When correctly applied, the product is capable of sealing to the air leakage requirement of Class C to HVCA standard DW 144.

**Key Benefits**

- Prevents air leakage in low, medium and high pressure ductwork
- Can be used to meet requirements of Class C to HVCA standard DW 144
- Water based: especially suited for safe use in confined spaces
LD410 | Duct Sealant

Application
- The user is advised to conduct tests to determine the suitability of the product for the intended application prior to use.

Flange Joints
- Apply a strip of TN013 Flange Sealing Tape around the inside perimeter of the joint to be sealed to act as a spacer.
- Apply a continuous bead of illbruck LD410 around the external perimeter. Assemble the joint and strike off any excess adhesive.
- Alternatively, apply a continuous bead between the flanges around the edge of the gasket after assembly and firmly tool into the joint.

Seam Joints
- Firmly gun a bead of sealant along the seam and tool as required.

Spigot Joints (spiral ducting)
- Apply a thick coat of LD410 to the male end of the coupling, slide on the straight run of ducting and mechanically fasten.
- Strike off any excess material over the exterior of the assembly and screw heads. Leave to cure fully before pressure testing and commissioning.
- The rate of cure in the joint is dependent on the ambient environmental conditions and also the assembled joint arrangement and the depth of the sealant between the joint faces.
- Protect from water for a minimum of 24 hours after application. Application in damp or humid conditions will significantly extend the cure time.

Cleaning
Uncured sealant can be removed by sponging with warm water. Cured sealant can only be removed mechanically.

Please Note
Not recommended for continuous contact with moisture, or external use where moisture is likely to be present prior to sealant cure. Do not use in contact with bituminous material. Do not expose to water until fully cured, or attempt to abrade when cured. Do not over paint until a surface skin has formed.

Health & Safety Precautions
Safety data sheet must be read and understood before use.