

PRODUCT DATA

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BOSTIK BOND-FLEX 400 SILICONE SEALANT

Bostik Bond-Flex 400 Silicone Sealant is a single part, low modulus, neutral curing silicone rubber sealant. It cures on exposure to atmospheric moisture to form a resilient highly elastic seal which maintains flexibility over a wide range of temperatures. Unlike many silicone sealants, Bostik Bond-Flex 400 has a low odour when curing. The sealant is extremely resistant to weathering, ageing and water. It conforms to ISO 11600 F&G 25LM.

Features

- Conforms to ISO 11600 F&G 25 LM
- Quick cure – low dirt pick up
- Permanent flexible seal
- Excellent weatherability
- Primerless adhesion to many materials
- Compatible with water-based and solvent based coatings: no plasticizer migration
- Flexible at low (-50°C) and high temperatures (+120°C)
- Low shrinkage

Product Characteristics

Colour	White & clear
Form	Non-slump paste
Specific gravity (density)	1.027 g/cm ³
Composition	Silicone rubber
Packaging	Cartons of 25 x C20 plastic cartridges
Shelf life/storage	At least 9 months from date of manufacture when stored unopened in a cool, dry place within the temperature range +5°C to +25°C and out of direct sunlight. PROTECT FROM FROST

Typical Performance Data (approx.)

Drying time	<i>Touch:</i> 10 - 25 minutes <i>Through:</i> 24 hours (dependent on bead size and humidity – rate of cure is approx 1.5mm a day at 25°C/65% RH)
Service temperature	-50°C to +120°C
Application temperature	+5°C to +40°C
Coverage	10 linear metres of 6mm diameter bead per cartridge

Joint movement accommodation	±25%
Flow	< 2mm (ISO 7390)
Tensile strength	1.0 MPa (N/mm ²) (DIN 53504) for a 2mm film
Elongation at break	400% (DIN 53504)
Modulus 100% elongation	0.30 MPa (N/mm ²) (DIN 53504) for a 2mm film
Shore A hardness	16 (DIN 53505) for a 2mm film
Solvent for cleaning up	White spirit

Directions for use

IMPORTANT

Before embarking on any work involving Bostik Bond-Flex 400 Silicone Sealant, the separate Safety Data Sheet should be carefully studied by those carrying out the work.

1. Surfaces should be clean, dry, firm and free from dust, oil, grease and any loose materials.

Do not clean PVC-u profiles with acetone or similar solvents. Loose and flaking paint should be thoroughly removed before sealing. As paint surfaces vary considerably, it is recommended that a preliminary adhesion test should be carried out before application.
2. If required place masking tape along joint edges and remove within 5 minutes of applying the sealant.
3. Cut off the dome at the top of the cartridge, cut the nozzle to the required diameter and then screw it onto the cartridge.
4. Insert the cartridge into a skeleton gun and squeeze the trigger until the sealant appears.
5. Apply ensuring no air is trapped behind the sealant.

NOTE: For conventional construction joints subject to movement, it is important that the dimensional proportions of the joint are correct. For Bostik Bond-Flex 400:

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Bostik Limited, Common Road, Stafford, ST16 3EH, England

Tel: +44 (0)1785 272727

Fax: +44 (0)1785 257898

www.bostik.co.uk

Width: *Minimum* 4mm
Maximum 25mm

Depth: *Minimum* 5mm
Maximum 25mm

Ideally the width of the joint should be twice the depth of the joint.

When using Bostik Bond-Flex 400 for sealing typical expansion joints a suitable inert filling material such as closed cell polythene foam should be used to prevent sealant adhesion to the bottom of the joint, thus avoiding excess tension of the sealant.

6. The sealant surface can be tooled immediately to a smooth finish using a tooling stick or trowel dipped in diluted detergent.
7. Clean application equipment and remove excess uncured sealant with white spirit and cured sealant by abrasion.

Restrictions on Use

Bostik Bond-Flex 400 is not suitable for use on PMMA, polyethylene, polypropylene, Teflon and bituminous surfaces or wax or paraffin containing surfaces.

Bostik Bond-Flex 400 may be discoloured in contact with organic elastomers such as EPDM and neoprene.

Bostik Bond-Flex 400 may yellow in applications in unventilated areas which are closed from UV light. This may also occur if contact is made with chemical fumes.

Bostik Bond-Flex 400 is not recommended for sealing of aquaria or for continuous water immersion, or for structural glazing.

Precautions in Use

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate health and safety data sheet for Bostik Bond-Flex 400 Silicone Sealant.

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