

Cl/SfB		Yt4
CAW P22		
Uniclass L675:P99		

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 15651 part 1	Type F-EXT-INT-CC, class 25LM
Fire Classification	EN13501-1	Class E
Specific Gravity	DIN 52451-A	1.6
Consistency	EN 27390, 20 mm profile	Non-sagging
Shore A Hardness	DIN 53505	25
Skin Forming Time	at +23°C, 50% RH	~ 30 minutes
Cure Rate	at +23°C, 50% RH	3 mm /first day
Tensile Strength	DIN EN ISO 8339 Method A	~ 0.7 N/mm ²
Modulus at 100% Elongation	DIN EN ISO 8339 Method B	0.4 N/mm ²
Elongation at Break	DIN 53504 S2	~ 550%
Maximum Movement Capacity	ISO 11600	25%
Elastic Recovery	BS EN ISO 7389 method A	75%
Acoustic Insulation		61 dB in a 10 mm wide joint 58 dB in a 20 mm wide joint 56 dB in a 30 mm wide joint
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 (such as AA956), smoothing tools such as AA311, and AA301 Smoothing Agent for sealant applications.

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.



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. SP525 will enhance the acoustic performance of a joint, providing up to 61 dB sound reduction.

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
- Provides up to 61 dB sound reduction in a 10 mm wide joint

Frame and Façade Sealant & Adhesive

Priming

- SP525 has excellent primerless adhesion to many typical construction materials but some substrates may require a primer – see primer table for details. For special situations, or if in doubt, please contact tremco illbruck Technical Services Department.

Adhesion Table

ABS	+, AT150	Polyamide	AT150
Acrylic glass (PMMA)	+, AT150	Polyester (reinforced with glass fibers)	+
Aluminium	+	Polypropylene	AT120
Brass		Polystyrene	AT150
Brick	AT140	PPC or Powder coating	+, Test
Concrete	+, AT140	PVC foil	+, AT150
Copper		PVC rigid	+, AT150, AT160
Electrically anodized aluminium	+	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.

Where there is no result listed according to substrate please contact technical department.

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 25%.
- 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.
- PR102 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.

- Use a brush to remove loose particles from joints.
- For non-porous substrates use cleaner AT200, do preliminary test.
- 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 such as AA956 or AA976.
- 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
- For bonding to the window frame, apply a minimum 10 mm dia bead of SP525 Adhesive to align 15 mm from one edge of the back (shiny) face of the membrane and bond to the window frame face or edge (ensure frame is dry and clean), compress to approximately 20-30 x 2-3 mm using a seam roller, taking care that the adhesive does not exude out onto the frame. If it is not possible to apply a consolidated bead of minimum 20 mm, please consult tremco illbruck technical department.
- For bonding to the construction substrate, apply a 10 mm dia bead to align 15 mm inside the edge of the membrane and after locating against the frame, consolidate using a seam roller. The compressed adhesive bead should now be approx 30- 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 600 ml Sausage
6 x 6	16.7
10 x 6	10.0
10 x 10	6.0
20 x 10	3.0
Fillet Width x Depth (mm)	Fillet Linear metres per 600 ml Sausage
6 x 6	33.3
10 x 10	12.0
Circular Bead for Bonding Membranes (mm)	Linear metres per 600 ml Sausage
8	11.9
10	7.6

Frame and Façade Sealant & Adhesive

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 tremco 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.

When bonding to copper or brass, please consult tremco illbruck technical services for priming details.

Health & Safety Precautions

Safety data sheet must be read and understood before use.



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 continuous development and improvement.



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