



CHEM LINK

**The New Wave of
High-Performance,
Earth Friendly
Super Sealants**

**No Solvents
No Fumes
Non-Toxic
Non-Flammable**

**High Strength
High Adhesion
Non-Shrinking
Waterproof**

Technical Data Guide

CHEM LINK Brands

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Last Revision: 05/19/14
 Document No. L1274

Product Description

M-1 Marine is a moisture cure polyether adhesive/sealant formulated for applications above the water line or after curing below the water line and in areas where solvent based materials are not tolerated. The product is solvent free and contains no isocyanates. It will not shrink upon curing, will not discolor when exposed to ultra violet light, and will not “out-gas” or bubble on damp surfaces as urethane sealants often do. The sealant has resilient elastomeric properties and excellent adhesion to most substrates. It can be used effectively in many difficult conditions, cures rapidly in wet or dry climates, and low temperatures compared to urethane based materials.



Standards and Compliance

- Conforms to OTC Rule for Adhesives
- Meets requirements of California Regulations: CARB, SCAQMD, and BAAQMD
- Conforms to California Proposition 65
- VOC Content: Less than 15 grams per liter ASTM D-2369, EPA Method 24

Advantages

- 100% VOC Compliant
- Tough elastomeric bonds
- Solvent Free
- Fast Setting
- High adhesion
- Paintable within 24 hours
- Gun grade, no special tools or mixing required
- Can be applied at temperatures as low as 32°F (0°C)

Applications	Substrates
Wood to fiberglass	Teak deck planking
Portlights	Fiberglass
Deck fittings	Gelcoat
Fiberglass to fiberglass	Metal
Moldings	Glass
Struts and planking	Polycarbonate
Stern joints	Most plastics*

*Test all plastic substrates for bond strength and compatibility before application.

Colors		
White	Gray	Black*

*Additional colors available by special order.

Packaging

- **10.1 oz (300 ml)**
12 cartridges/carton, 105 cartons/pallet
- **20 oz (600 ml) available by special order**
12 sausages/carton, 45 cartons/pallet
- **5 gallon pails or 50 gallon drums**
available by special order

Application Instructions

M-1 Marine Grade Structural Adhesive/Sealant is a gun grade material that is applied from caulking guns, high viscosity pump guns, or automated bead application equipment. This product sets rapidly upon exposure to moisture. Open containers must be quickly protected from atmospheric moisture.

Mask off areas that must be protected from adhesives. Allow the assembly to cure for 30 minutes to an hour before handling or machining. When bonding two impermeable materials, brief separation and reassembly of the bonding surfaces to expose the adhesive to atmospheric moisture will often accelerate the cure.

In extremely dry environments, local humidification may be needed to initiate curing. Low temperature will retard the cure reaction and heat will accelerate the cure reaction. Optimum application is between 60°F to 100°F (16°C to 38°C).

Substrate Preparation

Bonding surfaces must be clean, dry and free of oxidation, mill oils, wax, and release agents that may interfere with adhesion. Dry and fully cure painted surfaces before bonding. Alcohol and ammonia water are effective cleaners for surface preparation. Abraded or irregular surfaces are acceptable bonding surfaces but must be clean and sound. For use with teak, wipe with alcohol prior to application to remove surface oils

Storage

Store original, unopened containers in a cool, dry area. Protect unopened containers from water, heat and direct sunlight. Elevated temperatures will reduce shelf life. **M-1 Marine Grade Structural Adhesive/Sealant** will not freeze.

Shelf Life

Twelve months from date of manufacture when stored at 70°F / 21°C with 50% relative humidity. High temperature and high relative humidity may significantly reduce shelf life. Pails have a shelf life of six months.

All properties described in this document are derived from testing conducted in laboratory conditions. Properties and performance will vary depending on environmental conditions and application technique. Test and evaluate to determine appropriate usage. Visit www.chemlink.com for the Safety Data Sheet, Technical Data Guides and full warranty for this product.

LIMITED WARRANTY: **CHEM LINK** warrants this product's performance, provided it is properly stored and applied within 1 year. If this **CHEM LINK** material is proved to be defective, return remaining product and purchase receipt for refund or replacement of product exclusive of labor or cost of labor. This is the sole and exclusive remedy for defects or failure of this product. User must read and follow the direction of the current Technical Data Guide and SDS prior to product use. User determines suitability of product for intended use and assumes all risks. Manufacturer shall not be liable for damages (including consequential or incidental damages) in excess of the purchase price, except where such exclusion or limitation is prohibited by state law. THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, WRITTEN OR ORAL, STATUTORY, EXPRESS OR IMPLIED INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE; except for the above express warranty given by manufacturer, the product is sold with all faults. **CHEM LINK** SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. This warranty gives you specific legal rights, and you may also have other rights in the U.S. which vary from state to state. For warranty claim information, call 800-826-1681.

Typical Physical Properties		
Viscosity	1,200,000 +/- 400,000 cp at 72°F (22°C)	Brookfield RVF, TF spindle, 4 RPM
Density	11.8 +/- 0.2 lbs per gallon	ASTM D1475
Tack Free Time	20 +/- 10 min	45 +/- 5 % R.H.
Elongation at Break	275 - 325%	ASTM D412
Tensil Strength	325 - 375 psi	ASTM D412
Hardness Shore A	38 - 42	ASTM C661
Low Temp. Flex	-10°F (-23°C) Pass 1/4 inch mandrel	ASTM D816
VOC Content	Less than 15 g/l	ASTM D2369
Shrinkage	No visible shrinkage after 14 days	
Service Temp.	-40°F to 200°F / -40°C to 93°C	

Limitations

- Not intended for engine compartment use
 - Horizontal applications will require tooling.
 - In areas where prolonged chemical exposure is anticipated, contact Technical Services for recommendations.
 - Allow treated wood to "cure" for six months prior to application per APA guidelines.
 - Do not store in elevated temperatures.
 - Remove all coatings and sealers before application.
 - Please contact customer service for application guidelines with temperatures below 32°F (0°C).
 - Test and evaluate all paints before application.
- Polyurethane and oil based paints may dry slowly.





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Last Revision: 01/19/15
 Document No. L1260

Product Description

DuraLink is an extremely elastic moisture curing sealant designed for use in residential siding, metal architecture, curtain wall construction and joints subject to movement. **DuraLink's** adhesion to difficult surfaces permits its use on anodized metal and coatings such as Kynar 500® PVDF. **DuraLink** will not stain absorbent stone substrates like limestone or marble. **DuraLink's** unique polyether chemistry eliminates out-gassing on green concrete and protects against "sun tanning" or discoloration when exposed to ultraviolet light.

Applicable Performance Standards

- ASTM C920, Type S, Grade NS, Class 50, Uses NT, T₂, M, G, A & O
- Federal Specification TT-S-00230-C Type II, Class A
- Corps of Engineers CRD-C-541, Type II, Class A
- Canadian Standards Board CAN 19, 13-M82
- SWR Institute Validated (Sealant Waterproofing and Restoration)
- AAMA 802.3-08 Type II, AAMA 803.3-08 Type I, and AAMA 805.2-08 Group C

Regulatory Compliance

- Conforms to OTC Rule for Sealants
- Meets requirements of California Regs: CARB, BAAQMD and SCAQMD
- Conforms to California Proposition 65
- Conforms to USDA Requirements for Non-food Contact

Green Standards:

- LEED 2.2 for New Construction and Major Renovations: Low Emitting Materials (Section 4.1) 1 Point
- NAHB Model Green Home Building Guidelines: 5 Global Impact Points
- VOC Content: less than 19 grams / liter ASTM D2369 EPA Method 24 (tested at 240°F / 115°C)



Advantages

- Bonds to Kynar 500® PVDF coated metal
- Solvent free, 100% solids will not shrink
- Non-slump, applies vertically and overhead
- 30 minute skin over
- No outgassing on damp surfaces
- Color stability, will not suntan
- Paintable within 24 hours (See limitations)
- +/- 50% joint movement

Colors

Medium Bronze	Dark Bronze	Black
Forest Green	Stone	Gray
Terra Cotta	Aluminum	Limestone
Tan	Almond	Weathered Wood
White		

* Color matching is available in batch quantity only

Packaging

- **10.1 oz (300 ml)**
24 cartridges/carton, 45 cartons/pallet
- **20 oz (600 ml)**
12 sausages/carton, 40 cartons/pallet
- **2 and 5 gallon pails or 50 gallon drums**
available by special order

Joint Preparation

Joint surfaces should be clean, dry and free from all contamination including: dirt, oils, grease, tar, wax, rust and any other substance that may inhibit the sealant's performance.

Joint Design

Install all joint applications per ASTM and SWRI recommendations and guidelines. Joints shall be designed with a depth to width ratio of 1:2 (joint depth one-half the width). Control the depth of the sealant by using a polyethylene backer rod that is 25% larger than the joint opening at standard temperature. To prevent three-point adhesion use a backer rod or bond breaker tape to ensure proper joint movement and a long lasting weatherproof seal. Where the joint configuration will not permit a backer rod, CHEM LINK recommends that an alternative bond breaker be used.

Joint Width Inches (mm)	Joint Depth Inches (mm)
1/4 - 1/2 (6-13)	1/4 (6)
1/2 - 3/4 (13-19)	1/4 - 3/8 (6-10)
3/4 - 1 (19-25)	3/8 - 1/2 (10-13)
1 - 2 (25-50)	1/2 (13)

CHEM LINK recommends an appropriate substrate primer to be used on high moving joints or dissimilar substrates which require increased adhesion properties.

Compatible Substrates*	
Kynar 500® PVDF Coated Metal	Brick, Concrete and Stone
Galvanized Metal	EPDM and SBS Mod Bit
Aluminum	EPS Foam
Engineered Plastics, PVC	B.U.R (Built up Roofing)
Glass	Fiberglass FRP
James Hardie Board	Vinyl Siding

*Test and evaluate to ensure adequate adhesion.

Typical Physical Properties		
Gun Grade	Zero Slump	
Viscosity	750,000 cp +/- 150,000 cp	Brookfield RVF TF Spindle, 4 RPM, 73°F (23°C)
Density	11.0 +/- 0.2 lbs per gallon	ASTM D1475
Tack Free Time	40 +/- 20 min	45 +/- 5% R.H.
Elongation at Break	700%	ASTM D412
Peel Strength	25 - 30 psi	ASTM C794
Tensile Strength	150 - 200 psi	ASTM D412
Hardness Shore A	20 - 23	ASTM C661
Lap Shear Strength	150 - 175 psi	ASTM D1002
Low temp. flex	Pass -10°F (-23°C) 1/4 inch mandrel	ASTM D816
Shrinkage	No visible shrinkage after 14 days	
Service Temperature	-40°F to 200°F (-40°C to 93°C)	
Weathering	No cracking or chalking, slight matte finish after 2000 hours QUV "A" bulb. Durometer gain of 5 points	

Basic Uses	
Window and door frames	Siding
Pre-cast concrete	Weather Sealing
Block and Masonry	Cove Joints
Curtain Walls	Parapets
Expansion joints	Transportation

Application Guidelines:

Concrete

Prior to application remove any residual contamination by mechanical abrasion, sand blasting or power washing. On green concrete, remove all release agents, friable and loose concrete. Dry all visible and standing water prior to applying **DuraLink**. Install an appropriate backer rod to avoid three-point bonding.

Metal

Prepare all metal to ensure maximum adhesion. Remove all rust, scale and residue by wire brushing to a bright metal sheen. Remove films, loose or inappropriate coatings and oils with an appropriate solvent such as alcohol.*

**CHEM LINK recommends that coated substrates be tested for adhesion prior to starting a project. Please contact Technical Services for specific application guidelines and recommendations.*

Wood

Wood should be clean, sound and dry prior to sealant application. Allow treated wood to weather for six months prior to application. Remove all coatings and paint (or test for compatibility) to ensure proper bonding. Do not use on fire retardant lumber.

Priming

In most instances **DuraLink** will not require a primer. However, certain applications or substrates may require a primer to ensure a long lasting bond and weatherproof seal. It is the applicator's responsibility to determine the need for a primer. CHEM LINK recommends a primer be used for any application where prolonged immersion is anticipated.

Clean-Up

Wet sealant can be removed using a solvent such as alcohol. Cured **DuraLink** can be removed by abrading or scraping the substrate.

Storage

Store original, unopened containers in a cool, dry area. Protect unopened containers from water, heat and direct sunlight. Elevated temperatures will reduce shelf life. **DuraLink** will not freeze.

Shelf Life

Twelve months from date of manufacture when stored at 70°F / 21°C with 50% relative humidity. High temperature and high relative humidity may significantly reduce shelf life.

Pails have a shelf life of six months.

Application Instructions

Remove all dirt, oil, loose paint, frost and other contamination from all working surfaces with alcohol DO NOT USE petroleum solvents such as mineral spirits or xylene. Maintain **DuraLink** at room temperature before applying to ensure easy gunning and tooling. Test and evaluate to ensure adequate adhesion. Carefully gun the sealant with a smooth, continuous bead. If tooling is needed, do so within fifteen minutes of application.

Caution

Avoid prolonged contact with skin. Uncured adhesive irritates eyes. In case of contact with eyes immediately flush with water. Call a physician. Please refer to the SDS for first aid information.

See www.chemlink.com for most current SDS .

KEEP OUT OF REACH OF CHILDREN.

Limitations

- In areas where prolonged chemical exposure is anticipated, contact Technical Services for recommendations.
- Allow treated wood to "cure" for six months prior to application per APA guidelines.
- Do not use in areas subject to continuous immersion.
- Do not store in elevated temperatures.
- Remove all coatings and sealers before application.
- Please contact customer service for application guidelines with temperatures below 32°F (0°C).
- Test and evaluate all paints before application. Polyurethane and oil based paints may dry slowly.
- Do not use on TPO without CHEM LINK TPO primer.



Description

DuraSil is a moisture cure (RTV) silicone, adhesive sealant, designed for application on dissimilar materials such as glass, aluminum, steel, masonry and many engineering plastics such as polycarbonate, vinyl (PVC), fiberglass (FRP) and acrylic. **DuraSil** is also well suited for difficult to bond surfaces such as Kynar 500® PVDF and Tedlar® PVF.

DuraSil's low odor, non corrosive, and neutral cure chemistry will not damage unprotected metals. **DuraSil** is highly elastic and low modulus with mechanical properties capable of low temperature flexibility and 50% joint movement. **DuraSil** is recommended for metal architecture, windows and doors, curtain wall construction, and glass block.

DuraSil develops properties rapidly and is effective in many industrial applications where strength, elasticity, adhesion and speed of set are required.

Industrial Uses

Window and door frames	Kynar 500® PVDF
HVAC equipment	Steel
Expansion joints	Galvanized steel
Appliances	Aluminum
Glass	Anodized aluminum
Weather sealing	Tedlar® PVF

Advantages

- 100% VOC compliant
- Neutral cure
- Tough elastomeric bonds
- Non-flammable
- Solvent free
- Fast settings
- Self fixturing
- High adhesion
- No carcinogens

Substrate Preparation

Bonding surfaces must be clean, dry and free of oxidation, mill oils, wax, and release agents that may interfere with adhesion. Dry and fully cure painted surfaces before bonding. Alcohol and ammonia water are effective cleaners for surface preparation. Abraded or irregular surfaces are acceptable bonding surfaces but must be clean and sound. All substrates must be free of manufacturing defects.

* Test all substrates for bond strength and compatibility before using in production.

Application Instructions

DuraSil is a gun grade material that is applied from caulking guns, high viscosity pump guns, or automated bead application equipment. This product sets rapidly upon exposure to moisture. All application equipment must be clean and dry before using **DuraSil**. Open containers must be quickly protected from atmospheric moisture. Guns, pumps and hoses must be sealed when not in use.

Mask off areas that must be protected from adhesives.

Beads can vary in size from 1/16 inch to 3/8 inch diameter for best application control.

Apply adhesive to one side of the assembly. Do not use excessive adhesive.

Compress beads firmly between substrates to set bonds. Presses and clamps are usually not required.

Allow the assembly to cure for 30 minutes to an hour before handling or machining. When bonding two impermeable materials, brief separation and reassembly of the bonding surfaces to expose the adhesive to atmospheric moisture, will often accelerate the cure.

In extremely dry environments, local humidification may be needed to initiate curing. Low temperature will retard the cure reaction and heat will accelerate the cure reaction. Optimum application is between 60°F to 100°F (16°C to 38°C).

DuraSil will not shrink and may be used to fill gaps around bulkhead penetrations or seal joints. Fill the seam or void with **DuraSil** and tool to a smooth surface. Mask off areas as required to protect surface finish.

Standards and Compliance

- ASTM C-920, Type S, Grade NS, Class 50, Uses NT, T, M, G, A and O.
- Federal Specification TT-S-00230-C Type II, Class A
- Corps of Engineers CRD-C-541, Type II, Class A
- Canadian Standards Board CAN 19, 13-M82
- Conforms to OTC Rule for Sealants and Caulks
- Meets requirements of California regulations CARB, SCAQMD and BAAQMD
- Conforms to California Proposition 65
- Conforms to USDA requirements for non-food contact

Colors

White, black, gray, and translucent

Packaging

- 50 gallon open head drum
- 5 gallon pump pails
- 20 oz sausages (825 ml)
- 10.1 oz and 28 oz cartridges.

Storage

Store original, unopened containers in a cool, dry area at temperatures not in excess of 100°F / 38°C. Elevated temperatures will reduce shelf life. **DuraSil** will not freeze. For easy application do not store below 40°F / 5°C.

Shelf Life

Drums and pails: 6 month shelf life.
Sausages and cartridges: 6 month shelf life.

Typical Uncured Properties

Viscosity	750,000 - 1,000,000 cP at 72°F (22°C)	Industrial Method
Density	8.0 to 8.4 pounds per gallon	ASTM D1475
VOC content	33 grams/ liter	ASTM D2369
Tack free time	10 minutes at 50% RH, 72°F (22°C)	ASTM C-679
Skin time	10 - 15 minutes	Industrial Method
Cure Through	1/4" bead = 9 hours	Industrial Method
Odor	Mild Oxime Smell	Industrial Method

Typical Cured Properties

Elongation at break	450 - 550%	ASTM D-412
Shear strength	70 - 80 psi	ASTM D-1002
Hardness shore A	10 - 13	ASTM C-661
Low temp. flex	Pass ¼ inch mandrel -20°F (-29°C)	ASTM D-816
Shrinkage	No measurable shrinkage after 14 days	

Typical Peel Values ASTM C-794

Aluminum	14 pli cohesive failure
Concrete	10 pli cohesive failure
EPDM	13 pli cohesive failure
Glass	19 pli cohesive failure
PVC	17 pli cohesive failure
Vinyl	13 pli cohesive failure

Important Notice

Except where prohibited by law, Chem Link makes no warranties, expressed or implied, statutory or otherwise, including but not limited to, any implied condition or warranty of merchantability or fitness for a particular purpose. User is responsible for determining whether this Chem Link product is fit for a particular purpose and suitable for user's method of application.

Limitations of Remedies and Liability

If this Chem Link product is proved to be defective, the exclusive remedy at Chem Link's option shall be to refund the purchase price of or to repair or replace the defective Chem Link product. Chem Link shall not otherwise be liable for loss of damages, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including negligence, warranty or strict liability.

Read and ensure that the most up-to-date MSDS and technical guidelines are being followed. Proper use and application are the responsibility of the applicator. Proper specification and application is the responsibility of the user. Prepare test assemblies to verify performance.

When in doubt call the Technical Hot Line at 800.826.1681

ChemLink Engineered Systems is a division of Chem Link Inc. P.O. Box 9, Schoolcraft, Michigan, 49087.

CHEM LINK ENGINEERED SYSTEMS INC.

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Last Revision: 07/12/11

Product Description

NovaLink is a moisture curing, polyether sealant designed for application in damp, dry or cold climates. It is solvent free and contains no isocyanates. The product will not shrink upon curing, will not discolor when exposed to UV light, and can not “outgas” or bubble on damp surfaces as urethane sealants often do. It has excellent adhesion to most construction materials and resilient “elastomeric” properties. The product is capable of joint movement in excess of 35% compression and extension. Because it cures in wet or dry climate conditions and at low temperatures (30°F / -1°C), it can be used effectively in many difficult construction site conditions.

Applicable Performance Standards

- ASTM C-920, Type S, Grade NS, Class 35, Uses NT, T, M, G, A, and O
- Federal Specification TT-S-00230-C Type II, Class A
- Corps of Engineers CRD-C-541, Type II, Class A
- Canadian Standards Board CAN 19, 13-M82

Regulatory Compliance

- Conforms to OTC Rule for Sealants and Caulks
- Meets requirements of California Regs: CARB BAAQMD, and SCAQMD
- Conforms to California Proposition 65
- Conforms to USDA requirements for Non-food Contact

Green Standards:

- LEED for New Construction and Major Renovations: Low Emitting Materials (Section 4.1) eligible 1 Point
- NAHB Model Green Home Building Guidelines: 5 Global Impact Points
- VOC Content at 240°F: less than 19 grams/liter (including water), ASTM D2369, EPA Method 24

Application Instructions

Remove all dirt, oil, loose paint, frost and other contamination from all working surfaces with alcohol. DO NOT USE petroleum solvents such as mineral spirits or xylene. Maintain the product at room temperature before applying to ensure easy gunning and leveling. Test and evaluate to ensure adequate adhesion. Carefully gun the sealant with a smooth, continuous bead. If tooling is needed, do so within fifteen minutes of application.

Advantages

- Solvent free, 100% solids will not shrink
- Non-slump, applies vertically and overhead
- 20 minute skin over, will not pick up dirt
- No outgassing on damp surfaces
- Very good color stability, will not suntan
- Paintable within 24 hours

Limitations

- In areas where prolonged chemical exposure is anticipated, contact Technical Services for recommendations.
- Allow treated wood to “cure” for six months prior to application per APA guidelines.
- Do not use in areas subject to continuous immersion.
- Do not store in elevated temperatures.
- Do not apply at temperatures below 30°F (-1°C).
- Do not use on TPO without CHEM LINK TPO primer.

Storage

Store original, unopened containers in a cool, dry area. Protect unopened containers from water, heat and direct sunlight. Elevated temperatures will reduce shelf life. the product will not freeze.

Shelf Life

One year from date of manufacture when stored in normal environments. High temperature and high relative humidity may significantly reduce shelf life. Pails and special orders have a shelf life of three months.

Basic Uses
Expansion joints
Pre-cast concrete
Block and Masonry
Curtain Walls
Window and Door Frames
Siding
Parapets
Cove Joints
Transportation
Weather Sealing

Compatible Substrates*
Concrete
Block & Brick
Stone
Masonry
Aluminum and Galvanized Metal
Wood
Engineered Plastics, PVC
Glass
Fiberglass FRP
EPS Foam

***Test and evaluate to ensure adequate adhesion.**

Packaging

- 50 gallon, open head, pump drums
- Cartridges, 10.1 oz and 28 oz.
- 5 gallon pump pails
- Sausages available on request

Important Notice

User is responsible for determining whether this Chem Link Engineered Systems product is fit for a particular purpose and suitable for user's method of application. Except where prohibited by law, Chem Link Engineered Systems makes no warranties, expressed or implied, statutory or otherwise, including but not limited to, any implied condition or warranty of merchantability or fitness for a particular purpose.

Limitations of Remedies and Liability: If this Chem Link Engineered Systems product is proved to be defective, the exclusive remedy at Chem Link Engineered Systems' option shall be to refund the purchase price of or to replace the defective Chem Link Engineered Systems product. Chem Link Engineered Systems shall not otherwise be liable for loss of damages, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including negligence, warranty or strict liability.

Read and ensure that the most up-to-date MSDS and technical guidelines are being followed. Proper use and application are the responsibility of the applicator. Proper specification and application is the responsibility of the user. Prepare test assemblies to verify performance.

When in doubt call the Technical Hot Line at 800.826.1681

Chem Link Engineered Systems is a division of Chem Link Inc. P.O. Box 9, Schoolcraft, Michigan, 49087.

Typical Uncured Properties		
Gun Grade	Zero Slump	ASTM C 697
Viscosity	1,200,000+ cP 73°F (23°C)	Brookfield RVF, TF spindle, 4 RPM
Tack Free Time	45 minutes	ASTM C-679
Odor	Mild Mint Smell	

Typical Cured Properties		
Elongation at Break	450-500%	ASTM D-412
Hardness Shore A	25 +/- 3	ASTM C-661
Shear Strength	175 PSI	ASTM D-1002
Low Temperature Flex	Minus 10°F (-23°C) pass ¼ inch mandrel	ASTM D-816
Shrinkage	No measurable shrinkage after 14 days	
Service Temperature	Minus 40°F to 200°F (-40°C to 94°C) continuous service	
Shelf Life	Cartridges and sausages: 1 year Pails: 6 months	

Caution

Avoid prolonged contact with skin. Uncured adhesive irritates eyes. In case of contact with eyes, immediately flush with water. Call a physician. Please refer to the MSDS for First Aid information. Most current MSDS can be found at www.chemlinkinc.com. KEEP OUT OF REACH OF CHILDREN.

Clean-Up

Wet sealant can be removed using a solvent such as alcohol. Cured product can be removed by abrading or scraping the substrate.