



Seam Sealant Application Process

Preparation of a New Cartridge

1. Loading the cartridge into the dispensing gun
 - A. Remove the plastic nut from the outlet end of the sealant cartridge.
 - B. Remove the metal retaining clip and the plastic plug in the outlet ports of the cartridge and discard (re-insertion of the plugs into the wrong side can cause sealant to cure and block the ports).
 - C. Load cartridge into dispensing gun ensuring that the plungers are lined up properly.
2. Leveling the plungers
 - A. To ensure that the sealant is mixed and dispensed at the proper ratio, the plungers need to be level at the start of each new cartridge prior to use.
 - B. Prior to installing the mixing tip, slowly advance the plungers until a small amount of material is equally dispensed from each port. Once this occurs, the plungers are level.
 - C. Hand mix the dispensed material and discard.
3. Attach Mixing Tip and Purge
 - A. After leveling the plungers, fit the plastic mixing tip onto the outlet end of the cartridge and secure with the plastic nut that was removed previously.
 - B. After mixing tip has been secured, dispense a small bead of material (approximately one tip length) to ensure that a proper mix ratio is being achieved.
 - C. Material is now ready for use.
4. Open Time
 - A. Open time is the amount of time from when the sealant begins to travel down the mixing tip until dispensed product needs to be completely worked/processed in the seam.
 - B. It is important to note that open time begins at initial mix, not at time of dispense onto the surface of the application.
 - C. For Urethane Sealant, the approximate open time is 3-5 minutes at 75°F (24°C). This means that at an ambient temperature of 75°F (24°C), the material applied to the seams of the wall panel must be worked/processed within 3 minutes of the initial purge through the mixing tip.
 - D. Open time will fluctuate as temperature increases or decreases. It can be estimated that for every 18°F (10°C) increase in temperature, the open time will be cut in half.
 - E. Operators will also need to be aware of the timing in regards to the material remaining in the mixing tip after each application. Material will either need to be purged (approximately every 2-3 minutes at 75°F) between uses or a new mixing tip applied at the re-start of a partial cartridge. Temperature fluctuations described above have same effect on purge time.

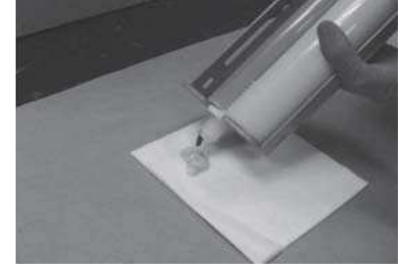


Figure 1: Leveling the Plungers

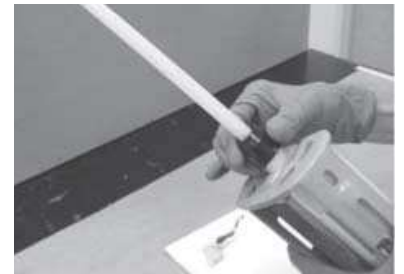


Figure 2: Attach Static Mixing Tip to Cartridge

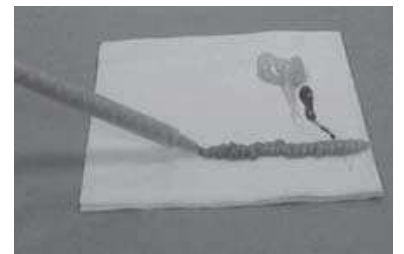


Figure 3: Purge sealant through Static Mixing Tip

Seam Sealant Workability Time

		Temperature (°F)			
		70	80	90	100
Time (Minutes)	1	Workable	Workable	Workable	Workable
	2	Workable	Workable	Workable	Workable
	3	Workable	Workable	Workable	Suspect
	4	Workable	Workable	Suspect	Not Workable
	5	Workable	Suspect	Not Workable	Not Workable
	6	Suspect	Not Workable	Not Workable	Not Workable
	7	Suspect	Not Workable	Not Workable	Not Workable
	8	Not Workable	Not Workable	Not Workable	Not Workable
	9	Not Workable	Not Workable	Not Workable	Not Workable
	10	Not Workable	Not Workable	Not Workable	Not Workable

Workable
Suspect
Not Workable

IMPORTANT INSTALLATION NOTE

Seam Sealant workability begins at initial dispense

FRP Wall Panel Installation

Please see the Cleanroom Wall System Installation Guide (form 7616) for information on using seam sealant with Crane Composites FRP wall panels.

www.FRP.com | 1.800.435.0080 | 1.815.467.8666 (fax) | salesbp@cranecomposites.com

Crane Composites is the manufacturer of Glasbord, Sequentia, Sanigrad II and a variety of other fiberglass reinforced plastic (FRP) composite wall panels. Inspired by the Kermite tradition, Crane Composites has over 55 years of experience in Commercial Building Products and is a recognized industry leader in FRP applications.



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