

CI/SfB	Yt4
CAW P22	
Uniclass L675:P99	

## Description

SP525 is a low modulus sealant and adhesive formulated using advanced SP polymer technology. It has high movement capability, excellent primerless adhesion to many substrates and long-term performance.

## Colour

White, light grey, mid-grey, concrete grey, anthracite, black, light sandstone, dark sandstone and buff

## Packaging

400 ml sausage (20 per carton)

600 ml sausage (20 per carton)



## Technical Information

Property	Test Method	Results
Composition		advanced SP polymer formation
Specific Gravity		1.6
Consistency	EN 27390, 20 mm profile	Non-sagging
Shore A Hardness		25
Skin Forming Time	at +23°C, 50% RH	Approximately 30 minutes
Tack Free Time	at +23°C, 50% RH	60 minutes
Cure Rate	at +23°C, 50% RH	3 mm / day
Tensile Strength	DIN 53504 S2	1.35 MPa
Modulus at 100%	ISO 8339	0.38 MPa
Elongation		
Elongation at Break	DIN 53504 S2	Approximately 550%
Movement	BS 6093	± 25%
Accommodation		
Elastic Recovery	EN 27389-B	74%
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, tooling sticks for sealant application and sharp knife.

## Priming

- SP525 has excellent primerless adhesion to many typical construction materials. Primer AT140 may be required for some porous substrates and AT150 for some non-porous substrates. For special situations, or if in doubt, please contact tremco illbruck Technical Services Department to discuss your requirements.

## Joint Design Considerations for Sealant Application

- 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%.
- Width to depth ratio of SP525 should be ideally 2:1.
- Minimum depth of joint 5 mm.
- Sealant width not to be less than sealant depth.
- For fillet joints, the minimum bite onto each surface should be 10 mm for porous substrates and 6 mm for non-porous substrates.
- A polyethylene backer rod should be used for joints wider than 6 mm.

## 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, high movement joints (e.g. modular building). It is also used for the bonding of ME500 & ME501 Intelligent Window Membranes.

#### Key Benefits

- Meets the requirements of EN ISO 11600 F 25LM
- Formulation based on advanced SP polymer technology
- High movement, rapid curing and non-staining formulation
- Excellent long-term resistance to weathering, ageing and UV
- Low modulus formulation ensures minimum strain at joint faces
- High strength bonding of ME500 & ME501 Intelligent Window Membranes
- Weather and airtight sealing of ME500 & ME501 Intelligent Window Membranes

### Surface Preparation

- Joint faces should be clean, dry and free from dust, oil, grease, old sealant and any traces of contaminant which may affect adhesion. Any previously applied sealant must be mechanically removed.
- Thoroughly clean with a suitable cleaning solvent using the two cloth method, using one cloth dampened with the cleaning product to lift contaminants and a second clean dry cloth is used to remove any cleaner residue.
- Apply masking tape to prevent contamination of adjacent surfaces.
- Contact tremco illbruck Technical Services Department for further information if required.

### Joint Backing

- Deep joints should be filled with an approved material such as FM230 or FM330 PU foam in order to provide thermal and acoustic insulation. When the width of the joint exceeds 6mm, apply a polyethylene backer rod in order to control the depth of sealant and prevent three-sided adhesion.

### Application as 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 sausage application gun.
- All beads should be tooled after application to ensure firm, full contact with the joint faces.

### Application as Adhesive

- Apply between +5°C and +40°C
- An 8 - 10 mm diameter bead of SP525 should be applied to the window and/or construction material so that when the ME500/501 Membrane is located, the bead is 12 - 15 mm inside the edge of the membrane.
- Once the membrane is positioned, compress so that the bead is approximately 25 - 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 400 ml Sausage	Linear metres per 600 ml Sausage
6 x 6	11.1	16.7
10 x 6	6.7	10.0
10 x 10	2.0	3.0
20 x 10	1.3	2.0

Fillet Joint Width x Depth (mm)	Linear metres per 400 ml Sausage	Linear metres per 600 ml Sausage
6 x 6	22.2	33.3
10 x 10	8.0	12.0

Circular Bead for Bonding Membranes	Linear metres per 400 ml Sausage	Linear metres per 600 ml Sausage
8	7.9	11.9
10	5.1	7.6

### Cleaning

Remove excess sealant immediately with AW421 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. Staining at the edges is possible on natural stone. Application on backs of mirrors, plastics which are sensitive to stress cracking and lasting exposure to water or vapour is not recommended. Not suitable for bonding to polyethylene, silicone, butyl rubber, neoprene or EPDM. We provide a service for testing compatibility of our adhesives 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).

### 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.



**tremco illbruck Limited**  
Coupland Road, Hindley Green  
WN2 4HT Wigan  
T: +44 1942 251400  
F: +44 1942 251410

info.uk@tremco-illbruck.com  
www.tremco-illbruck.co.uk