



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS

Silaprene®

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TECHNICAL SALES BULLETIN

SILAPRENE® M6324 ADHESIVE/ SEALANT

SILAPRENE M6324 ADHESIVE/SEALANT is an exceptional one-part product that combines ease of application, versatility of use, high ultimate strength, permanent bonds and long service life. M6341 is a high quality, high solids elastomeric sealant that provides superior adhesion to a variety of surfaces. Bond strength improves with age.

DESIGNED TO BOND:

1. All kinds of metal, including galvanized.
2. Wood, particleboard and plywood.
3. Rubber, concrete, masonry and glass.
4. Thermoplastics, such as ABS, styrene and polyolefins.
5. Thermoset plastics like phenolic, polyurethane, polyesters and epoxies.
6. Outstanding resistance to water, oils and greases, fuels, industrial chemicals, acid and bases.
7. Resists cracking, chipping and peeling.
8. Requires no mixing, priming or heating.
9. Paintable.
10. Exceptional weatherability.
11. Forms a tight, long-lasting seal to most surfaces.
12. Shelf life: 7 months at room temperatures not to exceed 80°F.

TYPICAL PROPERTIES:

(Specification values available on request)

Base:	Polychloroprene
Color:	Off white
Solvent:	Toluene
Solids:	51%
Viscosity:	700,000 cps Brookfield RVF #7 @ 2
Temperature range:	-60° F to 250° F
UV Range:	No effect, 3000 hours with intermittent water spray every 30 minutes (ASTM D-42)
Flammability Rating:	Dried film meets MVSS 66
Slump Resistance:	Self Leveling
Creep Resistance:	Excellent
Ozone Resistance:	Excellent
Elongation:	500%

Typical Lap Shear Strengths:

	psi
Aluminum to aluminum	416
Fiberglass to fiberglass	540
Aluminum to fiberglass	475
Plywood to plywood	453
Plywood to fiberglass	475
Galvanized steel to galvanized steel	415

PREPARATION OF SUBSTRATES:

Surfaces to be bonded should be cleaned of all dust, oils or other contaminants. A solvent wipe is often adequate. Bonds to rigid surfaces are usually improved by a solvent wipe followed with light abrasion (180 grit) and solvent wiping to remove abrasive residue. Dry surfaces thoroughly before applying sealant.

METHOD OF APPLICATION:

Adhesive/Sealant can be applied by brush, trowel or pressure pumping. Pumping equipment should be of the follower-plate type. Aro, Binks, DeVelbiss, Graco and Lincoln all produce suitable equipment for handling this material.

Apply a bead of Adhesive/Sealant to one surface at temperatures above 40°F. When used as a sealant, the applied bead will shrink approximately 60% so no tooling is necessary for most applications. The bead surface will be tack free in 15-45 minutes, depending on ambient conditions. Initial set time is 4 hours, after which parts may be handled.

When used as an adhesive between two non-porous surfaces, solvent must escape through the edges of the bond line. Clamping, taping or use of mechanical fasteners to hold parts in place until adhesive/sealant develops strength is recommended. After 24 hours at room temperature, the product is considered self-holding. The use of a heat lamp at 150°F for 1 hour will speed solvent evaporation and accelerate strength build-up. An alternative technique is to: apply product to one surface, press the two surfaces to be bonded together to ensure adhesive transfer, separate parts and allow to air dry 10-20 minutes, then press together with good pressure.

Adhesive/ Sealant M6341 is formulated for room temperature curing, and curing is initiated when a majority of

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This product is warranted to the original purchaser to meet published specifications, if any, and, in the absence of published specifications, to be merchantable quality. Such warranty may not be assigned or otherwise transferred by purchaser. No other warranty, expressed or implied, of fitness for a particular purpose or any other thing is made. Purchaser's exclusive remedy for breach of this warranty shall be a refund of the price paid for the products by the purchaser. Except as stated above, Royal Adhesives & Sealants, LLC, shall not be liable for any defect in, or breach of obligation relating to the defects in these products, regardless of the theory that may be asserted, including, without limitation, negligence, contract, absolute liability in tort or misrepresentation. If the purchaser does not accept goods on these terms, they are to be returned at once, unopened.

the solvent has been evacuated from the bond line. Strength build-up is very fast in the early stages to give high holding power, with continued strength build-up over time.

CLEANER AND THINNER:

Toluene/ Hexane/Textile Spirits

PRECAUTIONARY DATA:

This product is extremely flammable. Vapors may form an explosive mixture with air. Precautions should be taken to keep product away from fire, sparks, motors and other sources of heat or flame. Turn off or deactivate any electrical equipment or sources of ignition. Adequate ventilation is required to keep vapor concentrations below the Threshold Limit Value.

- For professional or industrial use only.
- Read the container label and the Safety Data Sheet carefully before use.
- Keep away from children.
- Keep container closed when not in use
- Store closed container under 80°F.
- This product contains a toxic chemical subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-to-Known act of 1986 and 40 CFR 372.

DISPOSAL INFORMATION:

When discarded, this material is hazardous waste. Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and local regulations.