

## ADSEAL 4540 SERIES

### METAL NEUTRAL CURE SILICONE ADHESIVE/SEALANT

#### DESCRIPTION

ADSEAL 4540 SERIES is a one-component neutral cure silicone adhesive that vulcanizes to a durable elastic rubber silicone in contact with ambient humidity. Due to its rheological and non-sagging characteristics, it can be applied above the head and on horizontal and vertical surfaces. ADSEAL 4540 SERIES was designed to bond metal reinforcement inside garage doors and to seal curtain wall back pan. ADSEAL 4540 SERIES adheres to glass, most types of wood, clean metals, silicone resins, ceramics, vulcanized silicone, synthetic and natural fibers and many painted surfaces (Validate with your representative) or certain plastics.

**AVOID USING ADSEAL 4540 SERIES IN CONTACT WITH SEALED GLASS UNIT.**

**ADSEAL 4540 SERIES CAN NOT BE PAINTED.**

It does not give off any unpleasant odor during vulcanization and will not oxidize the metal (discoloration of copper-based metals may occur when sealed tightly). Due to its vulcanization system in contact with moisture, the dimension (depth / thickness) of the bead should not exceed 13 mm (1/2 ") x 13 mm (1/2 "), otherwise the sealant cannot vulcanize completely. For applications with a bead depth of more than 13 mm (1/2 "), we recommend a two component silicone. Minimum movement joint size should be 1/4" x 1/4".

#### SPECIFICATIONS

- Meets CAN / CGSB standards 19.13-M82
- Meets ASTM C920, type S, NS grade

#### LIMITATIONS

- Not designed for permanent immersion joints
- Where the sealant is encapsulated and does not have access to ambient humidity
- In contact with strongly acidic or alkaline products
- Not designed for horizontal seals with circulation
- Joint less than 1/4 "(6 mm) wide and deep

#### PHYSICAL PROPERTIES

Uncured	
Appearance	Pasty
Color	White (4542) Galvanised grey (4549WD) special colors available upon request
Density	0.93 gr/cm <sup>3</sup> (7.73 lbs/ US gal.)
V.O.C.	<b>108.4 g/L</b>
Extrusion rate (20 psi/diamètre 5mm)	100 – 300 g/min
Skin time	4 – 8 minutes
Tack free time (ASTM C679)	12 minutes at 23°C (73°F) 50% r.h.

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Cured	
Hardness (shore A) (ASTM D2240)	20
Elongation at break (ASTM D412)	432%
Maximum Tensile strength (ASTM D412)	91 psi
Tensile strength at 100% elongation (ASTM D412)	39 psi
Tear strength (ASTM D624) Die C	19 lbs/inch

#### APPLICATION

- Metal reinforcement inside garage doors
- Metal reinforcement inside steel doors
- Metal reinforcement inside insulated panels
- Curtain wall back pan

#### SURFACE PREPARATION

Surface must be free of dust, oil, grease, frost or any other contaminant. Use ADSOLV 6002 or ADSEAL CLEANER 6003 to clean all surfaces. Let it evaporate 20 minutes before sealant application. In some cases ADSEAL 4549WD may require the use of a primer. If this is the case, use the ADSEAL PRIMER MK60095. Let evaporate the primer 20 minutes prior to ADSEAL 4549WD application. Consult our technical department for more information.

#### METHOD OF USE

ADSEAL 4540 series is easy to apply with a conventional manual, electric or pneumatic applicator (do not exceed 45 psi for a cartridge). Bonding or tooling should be done before skin formation.

#### PACKAGING

- 304ml cartridge
- 600ml sausage
- Pail
- Drum

#### STORAGE

Store the sealant in closed original packaging. Store in dry premises at a temperature lower than 25°C (77°F). Expiration date is indicate on each container. Storage beyond the date specified on the container does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality insurance reasons. Contact our technical service.

**ADSEAL 4540 SERIES**  
**METAL NEUTRAL CURE SILICONE ADHESIVE/SEALANT****CAUTION**

Always consult sds before using the product. Apply usual hygienic rules. Always test the product on your application before use. For industrial use only. For more information, please contact your technical representative.

**IMPORTANT****READ CAREFULLY**

The information and recommendations contained herein are derived from our research and information from other reliable sources. This data applies only to our products and not when used with other products. We believe in the reliability of our information. However, no guarantee is offered to that effect. It is the responsibility of the buyer to verify this data according to their own operating conditions to ensure that they conform to the purpose for which the product is intended, even before using it.

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