

Technical Data Sheet

AS-204

General Purpose Sealant

Physical Properties

Base:

Silicone polymer

Appearance:

Soft paste (Before curing)
 Elastic rubber (After cured)

Standard Colours:

(C10) Clear
 (W10) White
 (B10) Black

Special Colours:

(Made-to-Order)
 (G10) Grey
 (B30) Bronze

Tack-free time:

10 - 30 minutes
 (at 25 °C & 50% R.H)

Application temperature:

-20 °C to 50 °C

Service temperature:

Up to 150 °C

Storage:

Store in a dry and cool place
 with temperature below 30 °C.

Shelf life:

12 months

Packaging:

Content	Quantity/ carton
230 mL cartridge	24



Description

ALSEAL General Purpose Sealant is a one-component, versatile, acetic cure silicone sealant formulated for general purpose glazing and sealing applications where long term reliability is required. It will bond to form a durable, flexible, waterproof seal on many common wet area building materials. It is suitable for both indoor and outdoor applications.

Features

- ◆ Versatile sealant
- ◆ Permanently flexible
- ◆ Excellent durability
- ◆ Indoor and outdoor use

Applications

- ◆ Well-suited for general sealing applications such as sheet metal, skylights, ventilators, air-conditioning systems, metals/plastic signs, glass block structures and as a bedding for marine hardware.

Technical Data

Curing system	: Moisture curing, acetoxo
Specific gravity	: 0.95 – 0.98
Tensile strength (ASTM D412)	: >0.5 N/mm ²
Elongation at break (ASTM D412)	: >350 %
Shore A hardness (ASTM C661)	: 10 – 20
VOC content (USEPA method 24)	: 98.51 g/L

Approvals/ Specifications

AS-204 meets the requirements of the following specifications:

- ◆ Low VOC - USEPA Method 24 under SCAQMD Rule 1168

Usage Instructions

1. Surfaces must be clean, dry and free of dirt, grease, oil or water.
2. Surfaces should be cleaned with alcohol, M.E.K. or other suitable solvent. Do not use soap or detergent.
3. For a neat finish, apply masking tape and remove it before sealant skins over.
4. Cut nozzle at 45° angle to desired bead-width and apply to substrate with cartridge gun.
5. Tool the sealant within 5 minutes of extrusion before tack-free time.
6. Uncured sealant can be cleaned up with mineral spirits.



AS-204 General Purpose Sealant

Joint Design

- ◆ The specified sealant bead size should be calculated to comply with the compression and extension capabilities of the sealant in relation to the anticipated joint width due to expansion and contraction.
- ◆ Generally calculation of the width sealant bead should be computed on the basis of a maximum $\pm 20\%$ movement capability
- ◆ Minimum joint depth should not be less than 6 mm to accommodate movement.
- ◆ Sealant design joint width-to-depth ratio should be 2:1.

Coverage

Width	Depth	Coverage (230 ml) *	Coverage (280 ml) *
6 mm	6 mm	5.81 meter	7.07 meter
10 mm	10 mm	2.09 meter	2.55 meter
20 mm	10 mm	1.05 meter	1.27 meter
25 mm	12 mm	0.70 meter	0.85 meter

* The coverage figures shown above are approximate linear meter run based on 10% wastage assumption. Actual coverage may vary.

- ◆ Calculation formula:
 $X / [(Y \times Z) \times 1.1] = \text{Coverage}$

X = volume of cartridge (or sausage) in ml,
Y = joint width in cm, **Z** = joint depth in cm,
1.1 = 10% wastage assumption,
Coverage = linear meter run in cm per cartridge

Limitation

Not recommended for following applications:

- ◆ Substrates that could be corroded by acetic acid released as the sealant cures.
- ◆ Copper or any alloys containing copper.
- ◆ Polyethylene, polypropylene, and polytetrafluoroethylene (Teflon)
- ◆ Traffic areas subject to abrasion.
- ◆ Structural glazing.
- ◆ Substrates such as concrete, marble, quartzite, or natural stone.
- ◆ Neoprene rubber.

Caution

Product releases acetic acid during application and curing. Keep out of reach of children. Use in well ventilated areas. Safety data sheet available on request. For further health and safety information, consult the latest safety data sheet.

Disclaimer

Every endeavour has been made to ensure that the information given herein is true and reliable but it is given only for the guidance of our customers. The company cannot accept any responsibility for the loss or damage that may result from the use of the information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm suitability of this product by their own tests.