



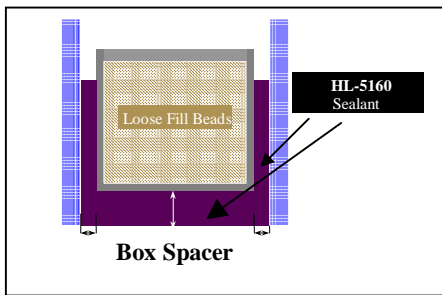
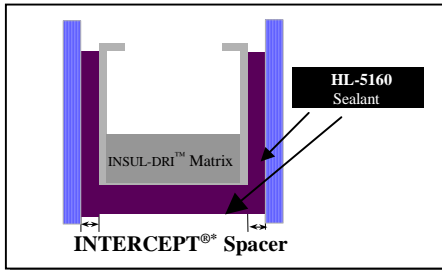
HL-5160 C-125 Product Information

Product Description

HL-5160 is a 100% solids, single-component sealant designed for the insulating glass industry. It is a warm-applied moisture-curing product that is intended for use in single seal applications.

HL-5160 features the following performance properties:

- Low modulus
- Low MVTR
- High initial handling strength



*INTERCEPT® is a registered trademark of PPG, Inc.

ADEQUATE TESTS: The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.

Table 1
Typical Application Properties

| | |
|--|---------------|
| Color | Gray |
| Shelf Life | Six Months |
| Application Temperature - Extruder | 96 – 102°C |
| Oven Exit Temperature (glass over sealant) | >60°C |
| Form and Packaging | Solid / Drums |

Table 2
Typical Physical Properties

| | |
|---|----------------------------|
| Raw Material Base | Moisture Cure Polymer |
| Specific Gravity | 0.95 g/cc |
| Viscosity @ 149°C | 350,000 mPA.s |
| MVTR 38°C/98% RH 1.5 mm | 0.6 gm/m ² /day |
| RT, Lap Shear – Glass/Aluminum (Initial) | 0.35 MPa |
| RT, Lap Shear – Glass/Aluminum (After Cure) | 0.59 MPa |

Application Limitations

- HL-5160 is compatible with low E coatings. It should **not** be used in non-edge deleted applications unless approved by the glass supplier.
- HL-5160 is **not** intended for structural glazing applications.
- HL-5160 should only be used in sloped glazing applications after review by a design specialist. It should not be used if the IG is unframed or unsupported.

Applicable Standards

HL-5160 single seal insulating glass sealant meets or exceeds the requirements of the following standards when used with a suitable secondary sealant.

- Level A requirements of ASTM E773/E774
- CAN/CGSB 12.8 Fog Test

Surface Preparation

Glass must be cleaned with detergent and hot water when using the HL-5160 single seal insulating glass sealant. We suggest following your glass washer or glass supplier's recommended practices for glass washing. Good practices include using hot water (49 - 60°C) and detergent.

H.B. FULLER'S ACCEPTANCE OF ANY ORDERS FOR THIS PRODUCT IS EXPRESSLY CONDITIONAL UPON PURCHASER'S ASSENT TO THE TERMS SHOWN ON THE REVERSE SIDE.

Surface Preparation (Cont.)

Do we need to edge delete our low-E glass? We have done some limited performance testing with specific types of non-edge deleted low-E glass. Your H.B. Fuller representative can supply you with a list of testing types and results.

Contaminants on the spacer stock adversely affect the adhesion of HL-5160 single seal insulating glass sealant. Coil and spacer stock should always be covered when stored. Contaminants like oil, dust, corrosion and dirt negatively affect the adhesion of any sealant. Check for cleanliness by taking a clean white cloth and wiping the spacer. Any noticeable particles or oils must be removed prior to manufacturing.

Glazing

All glazing recommendations of the Insulating Glass Manufacturers Alliance (IGMA) should be followed. For recommendations on specific glazing designs or use of glazing compounds, contact H.B. Fuller.

Equipment Suggestions

Drum unloaders with gun attachments are available. H.B. Fuller is a distributor of application equipment and can help you select the right system for your operation. We also have equipment service capabilities.

The development of semi-automatic equipment for hot melt sealants has resulted in many new operations using high-speed, high technology equipment. H.B. Fuller has trained technicians who can help set up and train personnel in the operation of this equipment.

Clean Up

Any uncured material can be cleaned up with a common solvent, such as acetone, MEK or toluene.

Health & Safety Precautions

To minimize the risk of burns, eye protection and protective clothing should be worn when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature of 232°C. Prevent the buildup of vapors. Extinguish all sources of ignition during hot melt use. Use only in a well-ventilated area. Consult Material Safety Data Sheet for additional information.

WARNING: EXTREME CARE SHOULD BE EXERCISED WHEN WORKING WITH HOT MELTS IN THEIR HOT, FLUID STATE.

Severe burns will result if skin contact occurs. When moving a hot melt from one location to another, protective gloves should be worn. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress, and see a physician immediately.

Packaging & Shelf Life

HL-5160 single seal insulating glass sealant is packaged and shipped in sealed, straight-sided 200 l drums. HL-5160 single seal insulating glass sealant has a minimum shelf life of six months from the date of manufacture.

Disposal

- In most localities, empty drums may be crushed and sent to a local landfill. Since local landfills have the right to refuse any material, check first.
- Check with the local drum recycler to see if they will accept the empty drums for recycling.
- Empty drums also may be discarded as scrap metal for a local scrapping company.
- Check the Material Safety Data Sheet for disposal requirements.

9 April 2008

LIMITED WARRANTY AND TERMS H.B. FULLER COMPANY

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

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LIMITATION OF ACTIONS AND VENUE — Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

ARBITRATION — Purchaser agrees that any claim of less than \$100,000 shall be submitted for binding arbitration before a single arbitrator and shall be governed by the rules and procedures of the American Arbitration Association. The arbitrator and the American Arbitration Association shall be paid by the Purchaser.

CONDITIONAL ACCEPTANCE — Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.