



H.B. Fuller

Window

Polysulfide

PS-998R Product Information

Product Description

PS-998R is a 2-component, solvent-free adhesive/sealant based on polysulfide. The rheological properties of the product make it suitable for manual and robot processing. The instructions of the equipment manufacturer should be observed.

Application Areas

PS-998R adheres to glass, aluminum, galvanized steel and stainless steel without the use of primer. For other products, such as coated glass, glass from which the coating has been removed, treated spacer profiles or profiles made of other materials, relevant trials must be carried out to ensure the product's suitability. The use with polycarbonate or polymethyl methacrylate (PMMA) is not recommended.

	Component A	Component B
Color	beige	black
Density	approx. 1.77 g/cm ³	approx. 1.73 g/cm ³
Odor	of polysulfide	odorless
Consistency	Pasty – thixotropic	Pasty – thixotropic
Mixing ratio		
By weight	10	1
By volume	10	1.02

Mixture (Component A +B)

Color	dark anthracite
Density	approx. 1.76 g/cm ³
Consistency	pasty - thixotropic
Sag resistance	profile in horizontal position, in line with EN 27390: < 3 mm
Potlife	30-40 minutes(at standard temp. and humidity:23/50 DIN 50014)
No longer tacky after	approx. 2 hours (at standard temp. and humidity: 23/50 DIN 50014)
Shore A Hardness	
according to DIN 53505	
(at standard temp. and humidity)	
Average values	
after 3 hours	approx. 42
after 24 hours	approx. 45
Tensile strength	
in line with DIN 52 455	
Average values	approx. 0.85 MPa

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.

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Application Preliminary statement

Prior to application it is necessary to read the **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed.

Pretreatment

All surfaces must be clean, dry and free from grease.

Application

PS-998R is preferably applied at a material temperature of between +15°C and +25°C. For processing at temperatures below +15°C, the relevant instructions given in the recommendations of the equipment manufacturer must be taken into account. After the pot life has elapsed, PS-998R cures rapidly. For this reason, care should be taken to remove the mixed material from the mixing equipment in due time, for instance by rinsing it with component A. Another possibility of prolonging the product's pot life is to store the mixing equipment in a freezer (at -25°C max.), which extremely slows down the curing reaction. A deep-frozen mixture is allowed to stay in the freezer for 24 hours max. Pot life depends on the temperature, i. e. higher temperature accelerates the curing process; reduce pot life and the permissible dwell time in the mixing equipment, whereas at lower temperatures curing is slowed down. The actual processing time depends on the technical conditions of the mixing equipment and on temperature. Due to its rheological properties, the product's temperature rises when it is fed and mixed in the equipment, so that the temperature of the mixture is approx. 7°C to 12°C higher than that of the components in their packaging units. Packaged in drums PS-998R is processed using suitable dosing pumps with a follower plate. Heating of the product by means of the plate is allowed up to + 30°C max. It is not possible to preheat an overcooled product (<< + 15°C) by means of the heated plate.

Storage

Frost-sensitive	None. Prior to processing, the product must be brought to a suitable processing temperature (see relevant information).
Recommended storage temperature	+15°C to +25°C. Must be protected from direct sunlight and/or thermal radiation. Storage at temperature between -20°C and +15°C does not cause damages to the product, but requires a sufficiently long preheating time. Depending on the time the product is exposed to cold, its pre-heating may need several weeks. When stored at temperatures > +25°C, the product's properties such as viscosity, sag resistance, potlife and curing time are affected.
Shelf life	9 months original closed packaging

Packaging

Drum kit	191 liters of component A in a drum with, Øi = 571,5mm, 19 liters B-component in a drum with Øi = 280mm
Drum / drum combination	10 drums of 191 liters each of component A each, Øi = 571,5mm 1 drum of 191 liters of component B

Hazard Indications / Safety Recommendations / Transport Regulations

see Safety Data Sheet

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