



# Bostik 5000 Hot Melt Butyl

## HOT MELT SEALANT

### KEY BENEFITS

- Can be used as a single seal
- Very low moisture vapour transmission rate
- Excellent application characteristics on manual and robotic equipment

### DESCRIPTION

Bostik 5000 Hot Melt Butyl Sealant has been specifically formulated for use in the production of insulating glass units. Bostik 5000 is a single part butyl rubber based sealant which, when applied at the correct temperature, sets quickly from its molten state allowing units to be moved from their assembly location between two and five minutes after application. Units can therefore be sealed and glazed within the same day. Bostik 5000 has a high output and fast heat loss enabling optimum turn round of unit production. The combination of these properties also means that corner defects can be easily avoided thereby ensuring a complete seal around the unit.

### FEATURES

- Compatible with all types of manual and robotic dispensing equipment currently available
- Quick-setting from the molten state
- Clean application with no wastage
- No cleaning or purging of dispensing equipment required
- Can be used as a secondary seal in conjunction with a P.I.B. primary sealant such as Bostik 2000. Consult the Bostik Technical Service Department

### IMPORTANT

Before embarking on any work involving Bostik 5000 Hot Melt Butyl Sealant, the Safety Data sheet should be carefully studied by those carrying out the work. Gloves and eye protection are recommended.

### SURFACE PREPARATION

Bostik 5000 exhibits excellent adhesion to cut, ground or polished glass, aluminium, galvanised steel, stainless steel and tinplate spacer bar, and is fully compatible with Quanex SuperSpacer®. It is essential that all surfaces are clean, dry and free from foreign matter. Coated glasses which require edge deleting must be used in accordance with the glass manufacturer's instructions.



### PRODUCT CHARACTERISTICS

<b>Packaging</b>	200kg (440lb) steel drum 200kg (440lb) fibre drum 6.5kg (14.3lb) block
<b>Constitution</b>	A blend of butyl rubber with other synthetic polymers and resins, which contain no volatile materials
<b>Colour</b>	Black / Grey
<b>Form</b>	Rubbery solid
<b>Density</b>	1.16 to 1.18 g/cm <sup>3</sup>
<b>Shelf life/Storage</b>	2 years from date of manufacture when stored unopened in a cool, dry place within the temperature range +5°C to +25°C (+40°F to +80°F)

### TYPICAL PERFORMANCE DATA (APPROX.)

<b>Moisture vapour transmission rate</b>	< 0.1 g/m <sup>2</sup> per day for 2mm film at 25°C (77°F), 100% RH. (ASTM method E96)
<b>Application temperature</b>	+180°C to +195°C (+365°F to +383°F) (ex nozzle)

## APPLICATION

The sealant should be applied by means of a suitable heated dispenser. It is very important that the sealant is applied within the recommended temperature range; therefore it is advisable that the application temperature be checked daily with a digital thermometer at the applicator nozzle whilst applying sealant. Further advice can be obtained from the Bostik Technical Service Department.

The sealant should be applied into the cavity of the insulating glass unit in such a manner that complete wetting of the glass and spacer occurs. If an internal locating nozzle is used, the nozzle should be checked regularly to avoid excessive wear, in order to ensure that the correct seal depth is maintained.

Care should be taken on sealing each corner and the sealant should be pressed together whilst still molten by means of a silicone rubber pad, or other method. This is to prevent any holes or gaps in the sealant at the corners, which could lead to premature unit failure. If the units are to be stored on a rack ensure that they are adequately supported under both panes of glass.

## GLAZING METHOD

Units manufactured with Bostik 5000 should be glazed in accordance with the current G.G.F. (Glass and Glazing Federation) methods or other G.G.F. recognised and approved methods (UK) or Sigma Glazing Guidelines (US). Further information may be obtained from the Bostik Technical Service Department.

The use of adhesive tape is not recommended to cover the edge of the unit. Drained and ventilated systems should be used where possible otherwise fully bedded glazing methods are necessary. If the unit is to be glazed using a glazing compound which is likely to be in contact with the edge seal of the unit, then it is important to ensure its compatibility with the Hot Melt Sealant BEFORE glazing. Further detailed information can be obtained from the Bostik 5000 Technical Bulletin and Bostik 5000 User Guide from the Bostik Technical Service Department.

## PRECAUTIONS IN USE

For health and safety instruction, first aid measures and spillage & disposal instructions, see separate health & safety data sheet for Bostik 5000 Hot Melt Butyl Sealant.

## BSI STANDARDS



*Bostik is a member of Glass and Glazing Federation and Insulating Glass Manufacturers Alliance*



The information given and recommendations made herein are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product's performance. It is the buyer's obligation, prior to using the product, to test the suitability of the product for an intended use under the conditions that will exist at the time of the intended use. Bostik does not warrant the product's suitability for any particular application. The product is sold pursuant to Bostik's Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

## SMART HELP

**Please contact your local representative**



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