



Bostik

smart adhesives

HOT MELT BUTYL INSULATING GLASS SEALANT

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.



Product Characteristics

Packaging	200kg (440lb) steel drum 200kg (440lb) fibre drum 6.5kg (14.3lb) block
Constitution	A blend of butyl rubber with other synthetic polymers and resins, which contain no volatile materials
Colour	Black
Form	Rubbery solid
Density	1.16 to 1.18 g/cm ³
Shelf life / Storage	At least 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.)

Moisture Vapour Transmission Rate	<0.1 g/m ² per day for 2mm film at 25°C (77°F), 100% RH. (ASTM method E96)
Application Temperature	+180°C to +195°C (+365°F to +383°F) (ex nozzle)

Directions for Use

Surface Preparation

Bostik 5000 exhibits excellent adhesion to cut, ground or polished glass, aluminium, galvanised steel, stainless steel and tin plate spacer bar, and is fully compatible with Super Spacer®. 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.

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.

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Melt Butyl



Glazing Method

Units manufactured with Bostik 5000 should be glazed in accordance with the current GGF (Glass and Glazing Federation) methods or other GGF 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 for Use

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