



## TECHNICAL DATA

# Acrylethane™ SM8400 Acrylic / Urethane Sealant

### PRODUCT DESCRIPTION:

SM8400 Acrylethane™ is a high performance sealant that is specifically targeted for back-bedding vision lites in wood windows and doors. It is the first back bedding sealant to combine the strength and tenacious adhesion of urethane with the excellent weathering characteristics of acrylic. Independent laboratory tests verify that the bonding of SM8400 exceed the load requirements in sash designed to meet Grade 60 of ASTM E1017 both before and after accelerated weathering.

### BASIC USE:

SM8400 is used for back-bedding (glazing) vision lites in wood windows and door sash. A precise integral rheology provides “wet grab” and prevents squeeze out. This helps maintain a proper position of the vision lite and thickness of sealant.

### FEATURES:

- High bond strength
- Long term durability
- Withstands high deflection
- Integral rheology
- Paintable / Stainable
- Very low VOC
- Deglazeable / reglazeable

### SPECIFICATION COMPLIANCE:

AAMA 805.2 Group C

### APPLICATION:

SM8400 Acrylethane™ Sealant can be applied using standard caulking guns or industrial pump and flow gun equipment. A 30:1 ration pump system can be used for successful sealant application. Hoses from pumps or header systems, all seals, packing, follower plates and other internal parts be resistant to corrosion.

- Surfaces must be clean and free from contaminants such as oil, release agents, old caulking, loose paint, dust and free standing water.
- Sinker stock millwork should not be used.
- Do not apply the sealant at temperatures below 40°F (4.45°C) or when it will be subjected to water before a skin forms.

### TYPICAL PROPERTIES:

Property	Typical Value	Test Method
Consistency:	Nonstringy, buttery	
Odor:	Mild-Pleasant	
Density:	9.0 lbs. /gal. (1.08 kg/l)	ASTM D1475
Percent Solids:		
By Weight	58%	
By Volume	55%	
pH:	7.5	
Flash Point:	>200°F (>93°C)	Tag Open Cup
VOC:	48 g/l	
Slump:	0"	ASTM D2202
Viscosity:	145,000 to 180,000 cps	Brookfield HBT, Spindle 7 @100 rpm
Extrusion Rate:	80-120 sec. (20 grams)	ASTM D2452 (20psi, 0.104" orifice)
Freeze/Thaw Stability:	Passes	5 cycles 0°F/75°F (-17.8°C/23.9°C)
Tack-Free Time:	15-20 min.	ASTM D2377
Service Temperature Range:	-20°F – 180°F (-29°C – 82°C)	
Max Tensile Strength:	157 psi (1.083N/mm <sup>2</sup> )	ASTM D412
100% Modulus:	107 psi (0.738N/mm <sup>2</sup> )	ASTM D412
Elongation:	733%	ASTM D412
Hardness:	25 Shore A	ASTM C661
Low Temperature Flexibility:	Pass	AAMA 800
Peel Adhesion:		AAMA 800
Glass	38 P.L.I. (6.65N/mm)	
Treated Wood	36 P.L.I. (6.30N/mm)	
Lap Shear:	250 psi (1724KPa)	ASTM C732
Clean-up:	Strikes off easily, use water	
Contamination of Wood Surfaces:	None: Paintable and Stainable	
Shelf Life:	SM8400 has an 18 month shelf life when stored in a tightly closed container at 50°F – 90°F (10°C – 32°C).	

### LIMITATIONS:

Not recommended for:

- a) Surfaces contaminated with oils or release agents.
- b) Skylights.

### CLEAN-UP:

Excess bedding sealant should be scraped off with a plastic spatula. A water moistened cloth will readily aid in cleaning up any sealant smear before cure. A soapy water mixture will facilitate cleaning tools and equipment.

**PRETEST ADHESION:**

Pretest for adhesion is intended to eliminate potential field problems by testing SM8400 with samples of building materials on which it will be applied. This testing will aid in determining the proper surface preparation method and effective cleaning techniques prior to application.

**PRECAUTIONS:**

IF THIS PRODUCT IS USED IN DIRECT CONTACT WITH ANY OTHER SEALANT, ELASTOMER, THERMAL-BREAK COMPOUND OR ARCHITECTURAL PAINT, A COMPATIBILITY TEST MUST BE CONDUCTED, BY PURCHASER OR USER, PRIOR TO ACCEPTANCE. The suitability of this product, for each intended use, must be determined by the purchaser prior to acceptance.

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