

Cl/SfB		Yt3	
CAW Z20			
Uniclass L673			

Description

SP350 is a one component, non-sagging, elastic adhesive based on hybrid polymers.

Colour

White.

Packaging

310 ml cartridges (12 per carton)

Technical Information

Property	Test Method	Results
Specific Gravity	DIN 52451-A	~ 1.5
Consistency	EN 27390 20 mm profile	0 mm , non-sagging
Film Formation Time		~ 20 min. at 23°C/50% R.H.
Cure Rate		~ 4 mm/1st day
Volume Shrinkage	DIN 52451	~ 3.4%
Modulus at 25% Elongation	DIN 53504 S2	~ 0.5 N/mm ²
Modulus at 100% Elongation	DIN 53504 S2	~ 1.2 N/mm ²
Tensile Strength	DIN 53504 S2	~ 2.5 N/mm ²
Elongation at Break	DIN 53504 S2	~ 400 %
Modulus at 100 % Elongation	DIN EN ISO 8339 Method A	~ 1.1 N/mm ²
Tensile Strength	DIN EN ISO 8339 Method A	~ 2.0 N/mm ²
Elongation at Break	DIN EN ISO 8339 Method A	~ 320%
Shore A Hardness	DIN 53505	55
Application Temperature		+5°C up to +40°C
Service Temperature		-40°C up to + 90°C
Storage	Store in shaded dry conditions between +5°C and +25°C.	
Shelf Life	12 months when stored as recommended in original unopened containers.	

Necessary Tools

- This is a high viscosity material and a geared application gun such as AA854 or AA874 is recommended and a sharp knife to cut nozzle.

Protective Equipment

Use in well ventilated conditions and ensure all recommended protective equipment is worn during handling & use of this product. For full recommendation, refer to safety data sheet.

Preparation

- May be applied to damp substrates.
- For optimum adhesion, surfaces should be clean, dry, sound and free of contamination.
- Always carry out a test to confirm compatibility prior to use.
- Roughen non-porous surfaces.
- On materials such as glass, aluminium, ceramics, lacquered wood, epoxy and polyester no primer is required. For other materials, please contact tremco illbruck Technical Services.



SP350

Fix & Seal High Tack



Usage / Purpose

SP350 is ideal for a vast range of interior & exterior applications and may be applied to damp substrates.

Applications include:

- Fixing aluminium and PVCu nosings and extrusions to concrete and wooden stairs.
- Carpet grippers to most subfloors without using tacks or nails.
- Most types of wall cladding, direct wall studding, internal wall surfaces or timber battens.

Key Benefits

- High initial grab and rapid development of final bond
- Formulation is solvent free, very low odour, and chemically neutral
- Instant grab can minimise the need for additional clamping or other mechanical supports
- Good resistance to light, weather and ageing - suitable for internal and external applications

Primer Table

Bricks, Concrete & Stone	
Brick	AT140
Concrete	AT140
Fibre Cement	+
Natural Stone	
Plaster	
Metals	
Aluminium	+
Aluminium Anodised	+ AT150
Aluminium Powder Coated	Test in every case
Brass	
Copper	
Galvanised Steel	+, AT150
Iron	+, AT150
Stainless Steel	+
Glass	
Glass	+
Plastics	
ABS	AT150
Acrylic Glass PMMA	-
Polyamide*	AT150
Polycarbonate*	-
Polyester GRP	+
Polypropylene	-
Polystyrene	AT150
PVC Rigid*	AT150
PVC Soft Sheet/Film*	AT150
Sanitary Acrylic*	-
Wood	
Wood*	
Wood Primed*	
Wood Painted (acrylic)*	
Wood Stained	
Tiles	
Glazed Tiles	+, AT140
Tiles Reverse Side	+, AT140
Unglazed Tiles	

+ good adhesion can normally be expected without primer.

Reference numbers (e.g. AT111) show the type of illbruck primer required to improve adhesion.

Where there is no result listed according to substrate please contact technical department.

* Substrates can vary in their surface properties; therefore, adhesion tests prior to use are recommended.

- not recommended on this substrate. This is a general rule on substrates like polyethylene, silicone, butyl rubber, Neoprene, EPDM, bituminous or tar containing surfaces as well as on natural stone.

Application

- Ensure good contact between the joint surfaces before applying adhesive. Apply a bead of adhesive to one or both surfaces. For larger bond areas, apply parallel beads at approx. 100 mm spacing, so that after joining the parts an aerated gap remains between the beads.
- Bring the two components together immediately. Sufficient working strength will normally develop after 10 minutes.

Coverage

Width x Depth (mm)	Linear metres per 310 ml Cartridge
5 x 5	12.4
8 x 6	6.4
10 x 8	3.8
15 x 10	2.0
20 x 12	1.2
25 x 15	0.8
30 x 15	0.6

Cleaning

Remove excess adhesive immediately with AT200 High Strength Cleaner. Ensure surface is solvent resistant before cleaning. Cured adhesive can only be removed mechanically.

Please Note

As mirror composition can differ between various manufacturers, we recommend a test in each case to confirm suitability. Not suitable for bonding polyethylene, polypropylene, Teflon® or nylon. Not recommended for sheet laminate. Do not use as a structural glazing adhesive. Not suitable for use for bonding plastics that are sensitive to stress cracking. Not recommended for prolonged exposure to water. Contact with bituminous or tar containing surfaces can lead to discolouration. Staining on natural stone may occur. If 2 non-porous substrates are glued the maximum width should not exceed 15 mm. When bonding to copper or brass, please consult tremco illbruck technical services for priming details.

Health & Safety Precautions

Safety data sheet must be read and understood before use.

Technical Service

tremco illbruck has a team of experienced Technical Sales Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please call Customer Services on +44 1942 251400.

Guarantee / Warranty

tremco illbruck products are manufactured to rigid standards of quality. Any product which has been applied (a) in accordance with tremco

illbruck written instructions and (b) in any application recommended by tremco illbruck, but which is proved to be defective, will be replaced free of charge.

No liability can be accepted for the information provided in this leaflet although it is published in good faith and believed to be correct. tremco illbruck Limited reserves the right to alter product specifications without prior notice, in line with Company policy of continuous development and improvement.



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