Yeşilbayır Mah. Şimşir Sk. No: 22 Hadımköy - İstanbul/TÜRKİYE Tel: 0212 771 13 71 Fax: 0212 771 38 88 www.akfix.com - info@akfix.com

P645

PU METAL SEALANT

Akfix P645 is a one-component, high-modulus polyurethane sealant that cures on exposure to atmospheric humidity. It possesses excellent adhesion to sheet iron, aluminum, stainless steel, lead, copper, ceramic, glass, wood and various plastic materials.

FEATURES & BENEFITS

- **Permanently flexible**
- **Non-sag consistency - Exceptional thixotropy**
- **Non-sticky / does not pick up dirt**
- **High mechanical resistance**
- Improved storage stability
- Easy to gun, can be easily smoothed
- Over-paintable

Durable Adhesion to Metal Surfaces

APPLICATION AREAS

- **Body construction of cars, containers, caravans etc.**
- **Sealing and bonding of ventilation ducts, gutters and spouts etc.**
- **Sealing of sheet metal seams**
- **For vibration reduction in all type of sheet metal assembly works**
- **Sealing against water, air, gas and dust.**

INSTRUCTIONS

- Joint surfaces must be dry, clean and free of all contamination. Glass, metal and other non-porous surfaces must be free of any coatings and wiped clean with solvent.
- Cut opens the cartridge, screw on nozzle and cut off tip at desired angle. Take off the aluminum cover at the bottom of the cartridge. Insert cartridge in gun and apply the sealant bubble-free continuously into the joint.
- Fill the joint completely. Smoothen it by pressing with a spatula or similar apparatus.

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Consumption (approx.)

Joint width	15 mm	20 mm	25 mm	30 mm	35 mm
Joint Depth	8 mm	10 mm	12 mm	15 mm	15 mm
Joint length / 600 ml	5 meters	3 meters	2 meters	1,3 meters	1,1 meters

Surface Preparation

Following cleaning procedure and materials are recommended:

Glass	Degrease with alcohol or MEK
Aluminium, light alloys and stainless steel	Degrease with alcohol or MEK
Other Metals	Lightly abrade then degrease as above
Wood	Lightly abrade surface then remove dust
Plastics	Degrease using an agent recommended by plastics manufacturer
Concrete and other alkaline Surfaces	Brush and remove dust

STANDARDS

Meets or exceeds the requirements of the following specifications:

- The requirements of VOC content specifications in LEED credit EQc4.1 “Low-emitting products” of SCAQMD rule 1168.
- The French VOC requirements for class A+
- CE marked for façade elements and pedestrian walkways.

RESTRICTIONS

- It must not be used in totally confined spaces where sealant cannot cure due to lack of atmospheric moisture.
- Do not use in applications where continuous water immersion is possible.
- Do not apply on frozen or wet surfaces or through standing water.
- Prolonged exposure to direct sunlight can cause discoloring,
- Avoid application below 5 °C and above 40 °C.

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STORAGE AND SHELF LIFE

- 15 months if stored in its original package, away from direct sunlight and moisture, between +10 °C and +25 °C

SAFETY & DISPOSAL

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

PROPERTIES

BEFORE CURING		
Basis	: Polyurethane	
Consistency	: Thixotropic	
Curing Mechanism	: Moisture Curing	
Density	: 1.18±0,03 g /ml	
Tack free time	: 60 ±10 min. (23°C and 50% R.H)	
Curing Rate	: Min. 3mm/day (23°C and 50% R.H)	
Sagging	: 0 mm	(EN ISO 7390)
Temperature Resistance	: -40°C to +90°C	
Application Temperature	: +5°C to +40°C	

AFTER CURING			
Hardness Shore A	: 45±3	After 28 days	(ASTM C661)
Paintibility	: Yes *		

*Considering the diversty of paint base and quality,compatibility tests should be done.

MECHNANICAL PROPERTIES (ISO 8339)		
Elongation at break	: ≥ 120%	(ISO8339)
E100 Modulus (23 °C)	: 0.40-0.45 N/mm^2	(ISO8339)
MECHNANICAL PROPERTIES (ASTMD412)		
Elongation at break	: ≥%400	(ASTM D412)
Tensile Strength	: Min. 2.0 N/mm^2	(ASTM D412)

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PRODUCT

Product Type	Volume	Package
White/ Black/ Grey	**310 ml**	12
White/ Black/ Grey/ Brown/ Golden Oak	**600 ml**	12

DISCLAIMER

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired. Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in maccordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.