



500-Series Polyurethane Products:

3M™ Polyurethane Construction Sealant 525

3M™ Polyurethane Construction Sealant 535

3M™ Polyurethane Sealant 540

3M™ Polyurethane Adhesive Sealant Fast Cure 550

3M™ Polyurethane Adhesive Sealant 551

3M™ Polyurethane Adhesive Sealant 560

Technical Data

March, 2009

Product Description

3M™ 500-Series Polyurethane Construction Sealant, Polyurethane Sealant and Polyurethane Adhesive Sealant products are one component, moisture curing products which form permanent elastic bonds. They bond to a wide variety of materials including plastics, metals, fiberglass, and wood. They are formulated to have a wide variety of Shore A hardness, open times, and performance parameters to meet many application needs.

Features/Advantages

Feature	3M™ 500-Series Polyurethane Products:						Advantage
	525	535	540	550 FC	551	560	
One component/ moisture curing	X	X	X	X	X	X	<ul style="list-style-type: none"> • No mixing • Simplifies production
Bonds dissimilar materials	X	X	X	X	X	X	<ul style="list-style-type: none"> • Gives design flexibility
Adheres to a wide variety of materials	X	X	X	X	X	X	<ul style="list-style-type: none"> • Multiple uses and design flexibility
Permanently elastic	X	X	X	X	X	X	<ul style="list-style-type: none"> • Provides long lasting bonds
Fast curing				X	X	X	<ul style="list-style-type: none"> • Speeds production
Paintable after cure	X	X	X	X	X	X	<ul style="list-style-type: none"> • Improves appearance
High tensile strength	X	X	X	X	X	X	<ul style="list-style-type: none"> • Gives high strength bonds • Replace rivets and mechanical fasteners
Low modulus / Low Shore A Hardness	X	X	X				<ul style="list-style-type: none"> • Ideal for sealing • Good for bonding material with different coefficients of thermal expansion
High modulus / High Shore A Hardness				X	X	X	<ul style="list-style-type: none"> • Ideal for bonding • Gives high strength bonds

3M™ 500-Series Polyurethane Products:

- Polyurethane Construction Sealant 525 • Polyurethane Construction Sealant 535
- Polyurethane Sealant 540 • Polyurethane Adhesive Sealant Fast Cure 550
- Polyurethane Adhesive Sealant 551 • Polyurethane Adhesive Sealant 560

Application Ideas

Market	3M™ 500-Series Polyurethane Products:					
	525	535	540	550 FC	551	560
General Industrial	X	X	X	X	X	X
Construction	X	X	X	X	X	X
Marine			X	X	X	
Specialty Vehicle			X	X	X	X
	Seals expansion joints, construction panels, roofing tiles. Bonds well to concrete.	Seals expansion joints, construction panels. Bonds well to concrete.	Seals lap seams on trucks, trains, trailers, etc., and construction panels.	Bonds and seals many diverse materials. Marine deck to hull bonding.	Bonds and seals many diverse materials. 550-type adhesive sealant with longer open time for use in large surface area applications.	Bonds floors, exterior / interior panels, roofs for trucks, trains, trailers, vans, etc.

Technical Data

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Properties	3M™ 500-Series Polyurethane Products:					
	525	535	540	550 FC	551	560
Tack-Free Time @ 73°F and 50% Relative Humidity	90 - 150 minutes	60 - 90 minutes	60 - 90 minutes	50 - 90 minutes	2 - 3 hours	50 - 60 minutes
Rate of Cure @ 73°F and 50% Relative Humidity	1/8" (3 mm) per 24 hour	1/8" (3 mm) per 24 hour	1/8" (3 mm) per 24 hour	3/16" (4 mm) per 24 hour	3/16" (4 mm) per 24 hour	3/16" (4 mm) per 24 hour
Shore A Hardness (ASTM C661)	25	40	40	45	45	55
Tensile Strength (ASTM D412)	400 psi (2.6 MPa)	300 psi (2.1 MPa)	300 psi (2.1 MPa)	450 psi (3.1 MPa)	450 psi (3.1 MPa)	580 psi (4 MPa)
Elongation at Break (ASTM D412)	>600%	>600%	>600%	>600%	>600%	>300%
100% Modulus (ASTM D412)	44 psi (0.3 MPa)	58 psi (0.4 MPa)	58 psi (0.4 MPa)	87 psi (0.6 MPa)	87 psi (0.6 MPa)	145 psi (1.0 MPa)
Service Temperature	-22°F - 176°F (-30°C - 80°C)	-40°F - 194°F (-40°C - 90°C)	-40°F - 194°F (-40°C - 90°C)	-40°F - 194°F (-40°C - 90°C)	-40°F - 194°F (-40°C - 90°C)	-40°F - 194°F (-40°C - 90°C)
Specific Gravity	1.17	1.17	1.17	1.17	1.17	1.17
Consistency	Medium paste	Medium paste	Medium paste	Medium paste	Medium paste	Medium paste
VOC Content	35.1 g/l	53.7 g/l	53.7 g/l	32.0 g/l	36.5 g/l	56.0 g/l

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- Polyurethane Sealant 540 • Polyurethane Adhesive Sealant Fast Cure 550
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Typical Properties of 3M™ Polyurethane Sealants / Adhesive Sealants

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Sagging (ISO 7390)	None
Application Temperature	40°F - 95°F (5°C - 35°C)
Resistance to dilute acids and bases	Average
UV resistance	Good
Water and salt spray resistance	Excellent
Compatibility with paints	Water based: yes Solvent based: test beforehand
Approximate Coverage (10.5 oz. [310 mm Cartridge])	1/8" (3 mm) bead = 126 lineal feet (38 lineal meters)

Performance Data

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Heat Resistance:

Long term exposure to temperatures greater than 194°F (90°C) will decrease tensile strength over time. Do not use these products in applications where the temperatures will continuously exceed 194°F (90°C).

Certification

Certification	3M™ 500-Series Polyurethane Products:					
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Standard Specification for Elastomeric Joint Sealants ASTM C920, Type S, Grade NS, Class 25, Use NT, G, M, and A		X	X	X		X
NSF R2 Coating for Use on Structural Surfaces	X			X		
Federal Railroad Administration Surface Flame Spread ASTM E162 Smoke Generation ASTM E662			X			X
Bombardier SP800-C Toxic Gas Production			X			X
IMO/MED International Maritime Organization			X	X		
Leadership In Energy and Environmental Design (LEED) Contributes to LEED credit	X	X	X	X	X	X

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Directions for Use

Surface Preparation:

Surfaces to be sealed or bonded should be clean and dry. Surfaces should be free from grease, mold release, oil, water/condensation, and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Adhesive Remover or methyl ethyl ketone (MEK).*

***When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to product label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.**

Local and federal air quality regulations may regulate or prohibit the use of these products or surface preparation and cleanup materials. Consult local and federal air quality regulations before using these products.

Note: Alcohol will interfere with the curing process and extra care must be taken when using alcohol as a cleaning solvent to prevent any contact with the sealant.

Primer:

Use of a primer is an extra step and cost and will depend on substrates and the final end use. Using primer can improve the corrosion resistance of certain metals as well as improve the durability of the bond when exposed to high humidity conditions. For most applications, high strength bonds on metal can be achieved without the use of a primer. Pre-testing for adhesion is suggested to determine if a primer is needed. Contact your 3M Technical Service representative for primer recommendation and application advice.

Application:

Loading the applicator gun: make sure the applicator is set up with correct plunger attachment for cartridge or sausage pack.

Cartridge: Puncture seal in nozzle and remove the pull-tab seal at the bottom of the cartridge. Load into applicator and fix retaining ring (if applicable). Assemble the nozzle (if applicable) and cut to desired size and shape.

Sausage Pack: Make a 1" slit close to the crimp on one end of the sausage pack. Load the sausage pack into the applicator barrel (slit side out). Place the rounded end of the supplied sausage nozzle onto the slit end of the sausage pack and fix with retaining ring. Cut nozzle to desired size and shape.

Product should be used within 24 hours after seal is punctured. Dispense product with the nozzle tip in contact with the substrate to insure good gap filling. Bonding must occur within the first 50% of published skin time

Do not apply polyurethane sealants and adhesive sealants on frozen nor wet surfaces. Do not apply over silicone nor in the presence of curing silicone nor hybrid products. Avoid contact with alcohol and solvents during curing. Sealant can be tooled immediately after applying to give desired appearance.

Cleanup:

While sealant is still soft, cleaning can be done with the same solvents used for surface preparation. Avoid cleaning with alcohol as it will interfere with the curing process. If sealant is already cured, removal is done mechanically with razor knife, piano wire, sanding or 3M™ Scotch-Brite™ Molding Adhesive and Stripe Removal Disc. This disc is available from 3M Automotive Aftermarket Division.

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Application Equipment Suggestions

Cartridge and Sausage Pack:

A variety of applicators are available. Please contact your sales rep for assistance in selecting an applicator.

Bulk Dispensing:

A 46:1 ratio dual action piston pump with a ram is suggested. Actual equipment should be designed for your application based on the volume required. Please contact your sales rep or the technical service group to suggest equipment manufacturers (Graco, Binks, etc).

Storage

Polyurethane sealants and adhesive sealants must be stored in a controlled environment to maximize shelf life. Store the products in the original unopened containers below 90°F (32C).

Shelf Life

When stored at recommended conditions, the shelf life is 6 months from date of shipment from 3M.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



Industrial Adhesives and Tapes Division

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