

ACRILONE



DESCRIPTION: Acrilone is a fire resistive, fibrated water based, indoor/outdoor vapour barrier sealant for low, medium and high velocity heating and air conditioning ducts. It performs as a tough and flexible adhesive and sealant, forming a durable seal against air leakage when used with or without reinforcing tape or membrane. Mechanical fasteners of the type and number normally used for duct assemblies are required to provide rigidity to the duct system.

CHARACTERISTICS: Acrilone has excellent weather resistance, low water vapour permeance and good water resistance, allowing it to be used outdoors and in high humidity environments. It may be pressure tested within 16 hours dry time above 70 °F (21 °C) and below 60 % RH. It quickly forms a strong bond to galvanized, aluminium, or mild steel ducts and on both flexible duct and rigid faced fibreglass duct systems. It has a mild odour when wet.

Acrilone complies with current USDA regulations regarding use in meat and poultry processing areas under federal inspection.

Acrilone contains no asbestos, lead, mercury, or mercury components.

LIMITATIONS: Store and apply between 40 °F (4 °C) and 100 °F (38 °C), protect from freezing.

To resist rain washoff, allow at least 12-15 hours drying time above 40 °F (4 °C), with a relative humidity of 50 %. Higher humidity or lower temperatures may retard drying.

Always test foil and paper facings for acceptable adhesion. Outdoor horizontal surfaces must always drain completely. A pitch of at least ¼ inch per foot (2 cm/m) is required.

If used between impermeable surfaces, drying time will be extended.

TECHNICAL DATA:

Colour:	white, grey.
Application consistency:	brush, trowel, caulking gun, or power extrusion.
Weight per U.S. Gallon (FSTM 3):	12,4 lbs (1,5 Kg/l).
Average non-volatile (FSTM 9A):	55 % volume (70 % by weight).
Coverage range (FSTM 72):	brush: 25 ÷ 50 sq. ft./gal. (0,6 ÷ 1,2 m ² /l) 0,064 in. (1,6 mm) – 0,032 in. (0,8 mm) wet film thickness.
Service temperature limits (FSTM 165):	Caulking gun: 130 lineal ft. per 11 fl. oz. tube, 1/8 in. bead (40 m/33 l tube, 3,2 mm bead).
Water vapour permeance (ASTM E 96):	20 °F to 200 °F (-7 °C to 93 °C).
Wet flammability (ASTM D 3278):	procedure A, 0,45 perms (0,30 metric perms) at 35 mils(0,9 mm) dry.
Surface burning characteristics (ASTM E 84):	no flash to boiling, over 210 °F (99 °C) flame spread: 5 Smoke developed: 0 Tested at coverage rate of 25 sq. ft. per gal. (0,6 m ² /l) in a 2 inch (6,4 mm) inorganic reinforced cement board. The flame spread may vary at different product thicknesses and/or when applied over other surfaces.

BS 476 Parts 6+7: class "O"

Acrilone is produced under the classification and follow-up service of Underwriter's Laboratories, inc. and meets NFPA 90A and 90B 25/50 requirements.

APPLICATION: Do not thin. Apply only to clean, dry, oil-free surfaces. Keep container closed when not in use.

Apply by brush, trowel or extrusion. On spiral duct apply a thick coat of 32 ÷ 17 to the male end of the coupling prior to slipping the straight run of spiral duct over it. Brush excess 32 ÷ 17 over the exterior of the joint and over the heads of all metal screws after they are in place and the joint is mechanically fastened. On the flanges of rectangular ducts both flange faces should receive a coat of 32-17 before joining with the flange gasket. Join and bond while sealant is still wet (0 ÷ 5 minutes). Do not exceed 1/8" (3,2 mm) wet film thickness.

POWER EXTRUSION: Acrilone may be applied using a wide variety of power (pressure) extrusion equipment suitable for use with waterbase sealants. It is a soft buttery gel with a typical viscosity range of 60,000 ÷ 80,000 cps. Corrosion resistant pumps and fittings are suggested.

CLEAN UP: Use fresh water to clean brushes and equipment before product dries. Dry product may be removed with hot soapy water or strong solvent such as chlorinated solvent (non-flammable) or xylol (flammable).

DATA REPORTED FROM ASTM E84 FIRE TEST (TUNNEL TEST)

ADHESIVES	
H.B. Fuller Company	
Surface Burning Characteristics ¼ inch (6.4 mm) Inorganic Reinforced Cement Board	
Surface Flame Spread	5
Smoke developed	5
Number of coats	1
Tested as applied in a 2 in. wide strip at a coverage of 25 sq. ft. per gal.	

No specific hazard warnings for normal use conditions.

Caution: Eye contact may cause irritation.
Prolonged skin contact may cause irritation.
Harmful if swallowed.
Observe all label safeguards for emptied containers that retain product residue.
Consult Material Safety Data Sheet for further information.
Keep out of reach of children.