

## SELECTION & SPECIFICATION DATA

<b>Description</b>	Two-component, self-leveling, polyurethane sealant. It exhibits excellent flexibility with moderate hardness and good chemical resistance to organic acids, alkalis and most solvents. Uses: can be used in conjunction with all lining systems in a wide range of applications. All high movement joints: isolation, expansion or control Thermal shock situations Exterior applications
<b>Features</b>	<ul style="list-style-type: none"> <li>• Long term abrasion and chemical resistance</li> <li>• Excellent bond strength assures good adhesion</li> <li>• Pourable viscosity allows easy installation to horizontal surfaces</li> <li>• Retains physical properties over a wide temperature range, -20 to 150°F (-29 to 66°C)</li> <li>• Factory proportioned packaging ensures consistent high quality and simplified mixing</li> <li>• Compatible with all Carboline lining systems</li> </ul>
<b>Color</b>	Grey
<b>Finish</b>	N/A
<b>Primer</b>	After proper surface preparation, 6325 Sealant will attain adhesion to most surfaces without the use of primer.
<b>Coverage Rate</b>	350 cubic inches/5736 cubic cm per gallon
<b>Topcoats</b>	Not Applicable

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Substrate must be sound, uncontaminated and dry. The surface must be free of any foreign materials such as paint, oil, wax, mastic and loose aggregate. Metal surfaces must be free of rust, corrosion, oil, lacquer, grease, etc. Do not apply over asphalt impregnated surfaces. To remove any contaminants, an industrial cleaner is recommended. After scrubbing, flush thoroughly with clean water. It is recommended that all joints be taped before the application proceeds.
<b>Special Instruction</b>	<p><b>TAPING</b> Taping should be done after priming to avoid wicking primer under tape on rough surfaces where bonding may be insufficient. Adjacent areas to joint should be masked for neatness. Remove all masking tape immediately after tooling is complete.</p> <p><b>BACKING MATERIALS</b> In deep-jointed areas the sealant penetration should be controlled through the installation of a polyurethane foam rod or polyethylene backer rod. Diameter of the backer rod stock should be one grade larger than the joint width to ensure compression of the backer rod when inserted. Care should be taken to ensure backer rod is not punctured. Where the joint design or depth of joint will not permit the use of joint backing, adhesive-backed polyethylene bond breaker tape must be installed. These materials prevent three-sided adhesion which allows the Sealant to perform to specification. Proper joint dimensions allow for a maximum depth equal to half the joint width.</p> <p>Minimum ambient and surface temperatures are 60°F/16°C at the time of application. Apply only on clean, sound, properly prepared substrate. Application and curing times are dependent upon ambient conditions. Do not use water or steam in the vicinity of the application. Moisture can seriously affect the working time and properties of the material.</p>

# Semstone<sup>®</sup> 6325 Sealant

## PRODUCT DATA SHEET



### PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	Results
Hardness Shore A	50 (ASTM D-2240)
Joint Movement Capability	+/- 25% (TT-S-00227E)
Percent Elongation	450% (ASTM D-638)
Specification	6325 Sealant meets the requirements of a general purpose sealant
Tensile Strength	250 psi (ASTM C-307)

The above physical properties were measured in accordance with the referenced standards. Samples of the actual system including binder and filler were used as test specimens.

### MIXING & THINNING

**Mixing** | Mixing must be achieved by mechanical means. Mechanical mixing should be done using a heavy-duty, slow-speed drill (80-150 rpm) with a Jiffy Mixer. Pour contents of Component A into a mixing container and premix to assure the suspension of solids. Add Component B and continue to mix to a uniform consistency for a period of approximately two minutes. Avoid high-speed mixing that will entrain air into the mix. Thorough mixing of the two components is required.

### APPLICATION PROCEDURES

**Application** | The Sealant must be applied immediately after mixing. Pour the mixed material directly into the joint. The Sealant is self-leveling and will seek its own level but tooling is necessary to ensure complete edge contact and a completely smooth surface. Use a joint finishing tool.  
**NOTE:** Working time for the material is 40 minutes @ 77°F. (25°C)

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	60°F (16°C)	60°F (16°C)	60°F (16°C)	0%
Maximum	85°F (29°C)	110°F (43°C)	85°F (29°C)	80%

Application and curing times are dependent upon ambient conditions. Do not use water or steam in the vicinity of the application, moisture can seriously affect the working time and properties of the material.

### CURING SCHEDULE

Surface Temp.	Light Traffic	Tack Free Surface	Ultimate Physical Characteristics
77°F (25°C)	24 Hours	12 Hours	14 Days

### CLEANUP & SAFETY

**Caution** | Both components are skin and eye irritants - avoid contact. The use of a NIOSH/MSHA approved respirator, safety goggles and impervious gloves is recommended. Use only adequate ventilation. In case of contact flush the area with water for 15 minutes and seek medical attention. Wash skin with soap and water.

---

## PACKAGING, HANDLING & STORAGE

---

**Packaging** | 2 units of part A and 2 poly bags in a box

**Shelf Life** | 24 months in the original, unopened containers

**Storage Temperature & Humidity** | Store both components between 60-85°F/16-29°C in a dry area. Avoid excessive heat.  
DO NOT FREEZE

**Storage** | Store indoors

**Shipping Weight (Approximate)** | 44 pounds

## WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.