

### TECHNICAL DATA SHEET

#### PRODUCT DESCRIPTION:

Acryl-R<sup>®</sup> SM5555 is a solvent release acrylic compound that exhibits excellent strength after cure. Tests indicate that this compound imparts flexibility, superior adhesion and resistance to ultraviolet and infrared radiation. Ease of application, moderate shrinkage, fast skin formation, and primerless adhesion to a wide variety of substrates makes this an excellent adhesive sealant.

#### ADVANTAGE:

- Excellent adhesion
- Bonds and seals a wide variety of surfaces
- Outstanding UV resistance – non-yellowing
- Fast skinning
- Seals dissimilar substrates
- Permanently flexible
- Paintable/ Mildew resistant
- Deglazeable/ Reglazeable (window applications)
- Repairable – bonds to itself

#### TYPICAL USES:

- Primary seal for “drop in” glazing details in wood, vinyl and aluminum windows. When fully cured will withstand uniform structural loading in excess of 130 psf (228 mph wind load).
- Waterproofing sidewall and roof seams
- Bonding vehicle trim and molding
- Sealing around openings in RV’s, buses, and trailers – windows, doors, skylights, air conditioners, etc.

#### APPLICATION LIMITATIONS:

Not recommended for use:

- On frost-bearing surfaces or when the temperature is below 40°F (4.6°C)
- On joints that will be subjected to continuous water immersion
- An expansion joint sealant
- On special architectural finishes without pretesting adhesion
- As a sealant on polycarbonate or acrylic surfaces when in tension
- On Polystyrene or foam insulation
- In joints with more than 15% total movement or joints exceeding 3/8” in width or depth

#### TYPICAL PROPERTIES:

Property	Typical Value	Test Method
Odor:	Aromatic solvent odor before cure; None after cure.	
Percent Solids:	62 % Min.	ASTM D 1475
Viscosity:	500,000 cps	HBT Brookfield Viscometer
VOC	395.4 g/L	EPA Method 24
Flash Point:	55°F (12.8°C)	ASTM D3278
Elongation:	100% Min.	ASTM D412
Hardness:	24-30, Shore A	ASTM C 661
Peel Adhesion: (glass/aluminum)	20 pli minimum	ASTM C 794
Slump:	0.10” max.	ASTM D2202
Cure Time:	Tack Free: 15-20 min Paintable: 1-2 hours Full Cure: 7-10 days	¼” bead @ 75°F, 50% RH. Lower temperatures and higher humidity will increase these times.
Water Resistance:	Excellent	AAMA 800
Vehicle Migration:	Passes	AAMA 800
Extrusion Rate:	55-80 sec (20 grams)	ASTM D2452 (60psi with 0.104” orifice @ 77°F)
Density:	9.075 lbs/ gallon	ASTM D 1475
Paintability:	Compatible with most alkyds, enamels and lacquers after solvent release.	
Service Temperature Range:	0°F – 180°F (-17.77°C – 82.22°C)	
Shelf Life:	SM5555 has a shelf life of 1 year when stored in original closed containers at or below 80°F (26.67°C)	

#### SPECIFICATION COMPLIANCE:

AAMA 805.2  
(Back Bedding Glazing Compounds)

#### GENERAL APPLICATION:

ITW POLYMERS SEALANTS NORTH AMERICA, INC.

111 S. Nursery Road, Irving, TX 75060  
Tel: 972-438-9111 Fax: 972-554-3939 [www.itwsealants.com](http://www.itwsealants.com)

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### Surface Preparation

- Clean and dry surface thoroughly before applying this product. Remove any old adhesive or sealant. Fill any deep joints with closed cell backer rod to within 3/8" of the surface.
- SM5555 should be applied in dry weather at temperatures above 40°F. For easier running in cold weather, warm sealant to room temperature before use.

### Technique

- Apply continuous bead of SM5555 into joint at 45° angle using consistent pressure.
- SM5555 can be tooled with a putty knife dampened with isopropyl alcohol or xylene.

### Clean up

- Use xylene or toluene to clean tools and equipment before SM5555 dries. Follow the necessary precautions regarding the use of solvents.
- Remove thin films of dried SM5555 with xylene or toluene.

### BACK BEDDING APPLICATION:

Standard caulking guns or industrial pump and flow gun equipment with a 46:1 ratio chop check value can be used successfully for compound application. Hoses from pumps or header system and all seals/packing must be of Teflon or polypropylene. Apply to clean dry surfaces. Cleaning of metal, glass or plastic surfaces should be by a solvent wipe procedure or by mechanical means. Detergent or soap and water cleaning treatments are not recommended. Protective films must be removed and cleaned with a solvent recommended by the manufacturer of the film or by other means which leaves no residue. In all cases where used, solvents shall be applied with one clean cloth or lintless paper towel, and the solvent wiped clean with a second cloth or towel. Cleaning solvents should not be allowed to air dry or evaporate without wiping. READ ALL LABELING BEFORE USING SOLVENTS. FOLLOW THE SOLVENT MANUFACTURERS RECOMMENDATIONS AND INSTRUCTIONS FOR SAFE HANDLING.

If this product is used in direct contact or in close proximity with any other sealant or elastomer, a compatibility test must be conducted by the purchaser or user prior to use. The suitability of this product, for each intended use, must be determined by the purchaser prior to acceptance.

### PRETEST FOR ADHESION:

Pretest for adhesion is intended to eliminate potential field problems, by testing SM5555 with samples of substrates on which it will be applied. This testing will aid in determining the proper surface preparation method and effective cleaning techniques prior to application.

### EXCLUSION OF WARRANTIES:

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Complete technical information is available from  
ITW Polymers Sealants North America, Inc.

### PRECAUTIONS:

### ITW POLYMERS SEALANTS NORTH AMERICA, INC.

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