

Code	Description	Size	Colour
20054	Holdfast Carbond 940FC Automotive PU Sealant	310ml	Black
20055	Holdfast Carbond 940FC Automotive PU Sealant	310ml	White
20064	Holdfast Carbond 940FC Automotive PU Sealant	600ml	Black
20066	Holdfast Carbond 940FC Automotive PU Sealant	600ml	White
20069	Holdfast Carbond 940FC Automotive PU Sealant	600ml	Grey
20082	Holdfast Carbond 940FC Automotive PU Sealant	600ml	Grey

1. Description

Holdfast Carbond 940FC Automotive PU Sealant is a high quality, elastic, one-component adhesive for structural bonding of body elements based on polyurethane.

2. Characteristics

- Very easy to apply
- Permanent elastic after curing
- Excellent resistance to UV radiation
- Excellent adhesion.
- High resistance to many chemicals
- Agri Quality approved for flooring joints

3. Technical Data

Base:	Polyurethane
Consistency:	Stable paste
Curing System:	Moisture curing
Skin Formation* (20°C/65% R.H):	Ca. 15 min
Curing Speed* (20°C/65% R.H):	3mm/24hr
Hardness:	40 ± 5 Shore A
Density:	1,30 g/ml
Elastic Recovery (ISO 7389):	>80%
Maximum Allowed Distortion:	± 20%
Max. Tension (DIN 53504):	1,70 N/mm ²
Elasticity Modulus 100% (DIN 53504):	0,80 N/mm ²
Elongation at Break (DIN 53504):	700%
Temperature Resistance:	-30°C - 90°C
Application Temperature:	5°C - 35°C
VOC (%)	2%
VOC (g/litre)	34

*This varies according to ambient conditions such as temperature, humidity, substrate etc

4. Applications

- All sealing and bonding applications in the building industry.
- Structural bondings in vibrating constructions.
- Sealing of shrinking joints in concrete floors.
- Bonding of roof tiles
- Can be used on coolroom areas

5. Packaging

310ml Alu cartridge, 600ml sausage

6. Shelf Life

12 months in unopened packaging in a cool and dry storage place at temperatures between 5°C - 25°C

7. Application Instructions

Method:	Manual and Pneumactical Caulking Gun
Backing Material:	PE backer rods for correct joint dimension
Application Temperature:	+5°C until +35°C
Clean:	Gorilla Solvent Cleaner immediately after use.
Repair:	Holdfast Carbond 940FC Automotive PU Sealant
Finish:	With soapy solution

Due to the range of substrates on the market recommend preliminary compatibility tests prior to commencement of application.

Surfaces

Type:	All usual building substrates, metals and polyesters (not PVC).
State:	Surfaces must be clean, dry, free of dust and grease. Porous substrates; Surfaces such as lightweight aerated concrete, masonry plasters and other surfaces regarded as very porous should be primed with Primer 150. Non-porous substrates; due to the wide range of materials, coatings and surface finishes we recommend to test to verify adhesion to determine the correct adhesion promoter. Preparing the surface with Gorilla 696 Surface Activator will maximise adhesion.

Joint Size

Min width for bonding:	2mm
Min width for joints:	5mm
Max width for bonding:	10mm
Max width for joints:	30mm
Min depth for joints:	5mm
Recommendation sealing jobs:	Joint width = 2 x joint depth

Limitations:

Holdfast Carbond 940FC may be painted, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application. The drying time of alkyd resin based paints may increase.

Holdfast Carbond 940FC can be applied to a wide variety of substrates. Due to the fact that specific substrates such as metals, plastics, polycarbonate, etc may differ from manufacturer to manufacturer, we recommend preliminary compatibility tests.

While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding. For optimum adhesion the use of Gorilla 696 Surface Activator is recommended.

This product cannot be used as a glazing sealant.

8. Maintenance and Inspection of Weather-Tightness Sealant Joints

Maintenance and Inspection of Weather-Tightness Sealant Joints

Applies to the following joints:

- Linear Joints
- Penetration seals

Inspection

Holdfast recommends that the first inspection of joints is done 6 months following application, followed by an annual inspection. Normally this inspection is combined with the inspection of the painting. The most effective is to judge the joints during a colder season as building materials shrink the most under low temperatures, resulting in the widest joints. This period is best to judge if the sealants are still able to cope with the pressure, and if detachments appear.

During inspection specifically pay attention to:

Detachments in facades of buildings can result into leakage. When leakage is noticed but the exact cause and location is unclear, the exact spot should be found by testing. We have two methods for this test:

- Test with a (garden) hose. With a hose the facade can be sprayed. While doing this we work downward towards above, while the inside is checked on water entering the building. When no leakage is found this way, the possibility exists the leakage will only appear when rain and wind pressure are combined at the same moment. Wind pressure causes over pressure on the outside while under pressure on the inside appears. This can cause water to be sucked inside through very small openings. With higher building the water can be pushed up and find its way into buildings.
- Test with a smoke pipe. With a smoke pipe possible leakages can be identified more easily, especially when wind pressure occurs.

Warning

Do not apply on glass or PVC. When painted with oxidative drying paints disturbances in the drying of the paint may occur, as skin time is approximately 15 minutes do not apply in runs that would exceed 10 minutes before tooling. No adhesion on glass, PE, PP, PTFE (Teflon®) and bituminous substrates.

Primers are not a substitute for incorrect surface preparation but will improve the long term performance of the sealant if applied correctly in accordance with the technical data. It is the users responsibility to ensure that the adhesion of the cured sealant, on typical test joints on site before and during application, is sufficient to satisfy themselves that adequate adhesion is obtained.

Holdfast recommends preliminary compatibility tests to ensure that the user is satisfied with the result given.

8. Health and Safety Recommendation

- Apply the usual industrial hygiene
- Please refer to the MSDS for more detailed information.

Remark

The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments.

If any clarification is required, please contact Holdfast Technical Services or email sales@holdfast.co.nz.

Last Updated: 6 November 2017