CI/SfB			
		Yt3	
CAW Z20 Uniclass L673			

illbruck
making it perfect.

Description
Illbruck SP350 is a single component multi-purpose, non-sagging, high strength, hybrid polymer, adhesive/ sealant, designed to bond to a variety of substrates that are commonly found in manufacturing and construction sealings.

SP350 represents advancements in adhesive/sealant technology. It is solvent and isocyanate free, exhibits excellent weather resistance, and has both adhesive and sealant capabilities.

Colour
White.

Packaging
300 ml cartridges (12 per carton)

Basic Uses
illbruck 350 is durable, flexible, and exhibits tenacious adhesion once fully cured. Typical applications include but are not limited to all window substrates (glass, aluminum, pvc & fiberglass), HVAC units, boats, metal buildings, modular construction, cabinets, etc.

Typical substrates include metals, plastic, wood, foam, vinyl, drywall, etc.

Adhesion testing is always recommended prior to use.

Necessary Tools
- This is a high viscosity material and a geared application gun such as AA854 or AA874 is recommended and a sharp knife to cut nozzle.

Protective Equipment
Use in well ventilated conditions and ensure all recommended protective equipment is worn during handling & use of this product. For full recommendation, refer to safety data sheet.

Preparation
- May be applied to damp substrates.
- For optimum adhesion, surfaces should be clean, dry, sound and free of contamination.
- Always carry out a test to confirm compatibility prior to use.
- Roughen non-porous surfaces.
- On materials such as glass, aluminium, ceramics, lacquered wood, epoxy and polyester no primer is required. For other materials, please contact the Technical Services.

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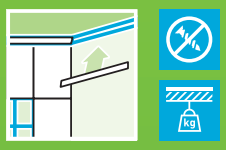
EMISSION CLASS FOR BUILDING MATERIALS M1

SP350

High Tack Pro



Usage / Purpose
SP350 is ideal for a vast range of interior & exterior applications and may be applied to damp substrates.
Applications include:
- Fixing aluminium and PVCu nosings and extrusions to concrete and wooden stairs.
- Carpet grippers to most subfloors without using tacks or nails.
- Most types of wall cladding, direct wall studding, internal wall surfaces or timber battens.
- As stiffener for ACP and steel sheets panel applications

Key Benefits
- High initial grab and rapid development of final bond
- Formulation is solvent free, very low odour, and chemically neutral
- Instant grab can minimise the need for additional clamping or other mechanical supports
- Good resistance to light, weather and ageing - suitable for internal and external applications

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Primer Table

Bricks, Concrete & Stone	
Brick	AT140
Concrete	AT140
Fibre Cement	+
Natural Stone	
Plaster	
Metals	
Aluminium	+
Aluminium Anodised	+ AT150
Aluminium Powder Coated	Test in every case
Brass	
Copper	
Galvanised Steel	+, AT150
Iron	+, AT150
Stainless Steel	+
Glass	
Glass	+
Plastics	
ABS	AT150
Acrylic Glass PMMA	-
Polyamide*	AT150
Polycarbonate*	-
Polyester GRP	+
Polypropylene	-
Polystyrene	AT150
PVC Rigid*	AT150
PVC Soft Sheet/Film*	AT150
Sanitary Acrylic*	-
Wood	
Wood*	
Wood Primed*	
Wood Painted (acrylic)*	
Wood Stained	
Tiles	
Glazed Tiles	+, AT140
Tiles Reverse Side	+, AT140
Unglazed Tiles	

+ good adhesion can normally be expected without primer.
Reference numbers (e.g. AT111) show the type of illbruck primer required to improve adhesion.
Where there is no result listed according to substrate please contact technical department.
* Substrates can vary in their surface properties; therefore, adhesion tests prior to use are recommended.
- not recommended on this substrate.
This is a general rule on substrates like polyethylene, silicone, butyl rubber, Neoprene, EPDM, bituminous or tar containing surfaces as well as on natural stone.

Application

- Ensure good contact between the joint surfaces before applying adhesive. Apply a bead of adhesive to one or both surfaces. For larger bond areas, apply parallel beads at approx. 100 mm spacing, so that after joining the parts an aerated gap remains between the beads.
- Bring the two components together immediately. Sufficient working strength will normally develop after 10 minutes.

Coverage

Width x Depth (mm)	Linear metres per 300 ml Cartridge
5 x 5	12.4
8 x 6	6.4
10 x 8	3.8
15 x 10	2.0
20 x 12	1.2
25 x 15	0.8
30 x 15	0.6

Cleaning

Remove excess adhesive immediately with AT200 High Strength Cleaner. Ensure surface is solvent resistant before cleaning. Cured adhesive can only be removed mechanically.

Priming

Illbruck SP350 High Tack Pro typically adheres to common construction substrates without primers; however, due to the variability of substrate finishes such as Kynar and anodized aluminum, Tremco always recommends that application- specific testing be performed on the actual materials being used in the manufacturing process to verify the need for a primer, proper cleaning and prep requirements.

Please Note

As mirror composition can differ between various manufacturers, we recommend a test in each case to confirm suitability.
Not suitable for bonding polyethylene, polypropylene, Teflon® or nylon. Not recommended for sheet laminate.
Do not use as a structural glazing adhesive. Not suitable for use for bonding plastics that are sensitive to stress cracking. Not recommended for prolonged exposure to water. Contact with bituminous or tar containing surfaces can lead to discolouration. Staining on natural stone may occur. If 2 non-porous substrates are glued the maximum width should not exceed 15 mm.
When bonding to copper or brass, please consult tremco illbruck technical services for priming details.

Health & Safety Precautions

Safety data sheet must be read and understood before use.

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Technical Information

Property	Test Method	Results
Specific Gravity	DIN 52451-A	~ 1.5
Consistency	EN 27390 20 mm profile	0 mm , non-sagging
Film Formation Time		~ 20 min. at 23°C/50% R.H.
Cure Rate		~ 4 mm/1st day
Volume Shrinkage	DIN 52451	~ 3.4%
Modulus at 60% Elongation	ASTM D412	~ 0.8N/mm²
Modulus at 100% Elongation	ASTM D412	~ 1.2 N/mm²
Tensile Strength	ASTM D412	~ 2.5 N/mm²
Elongation at Break	ASTM D412	~ >400%
Shore A Hardness	DIN 53505	~ 50
Application Temperature		+5°C up to +40°C
Service Temperature		-40°C up to +90°C
Storage		Store in shaded dry conditions between +5°C and +25°C.
Shelf Life		12 months when stored as recommended in original unopened containers.

Property	Results
Water Resistance	No Voids, Cracks, Separation, or Breakdown
Service Temperature (Ref ISO 4663)	-40°F (-40°C) to 212°F (100°C)
Application Temperature	41°F (5°C) or above 95°F (35°C)
Change/Discoloration	No visible change
Accelerate UV Exposure	No cracking
Cold Temperature Exposure	No cracking
Surface Cracking	
77°F (25°C) for 21 days	None
180°F (82°C) for 14 days	None
140°F (60°C) for 21 days with UV	None
Horizontal Slump	None
Low Temperature Flexibility	No Cracks or Adhesion Loss
Vertical Slump	None
Vertical Migration	None
Painting	After 24 hours or 3 days if using relatively inflexible paint. Any latex and most oil-based paints are fine. Best results achieved when sealant is primed with latex enamel. Some paints might crack in dynamic joints.

Technical Service
Tremco CPG APAC has a team of experienced Technical Sales Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please contact our Customer Services.

Guarantee / Warranty
Tremco CPG APAC products are manufactured to rigid standards of quality. Any product which has been applied (a) in accordance with Tremco CPG APAC written instructions and (b) in any application recommended by Tremco CPG APAC, but which is proved to be defective, will be replaced free of charge.
No liability can be accepted for the information provided in this leaflet although it is published in good faith and believed to be correct. Tremco CPG APAC reserves the right to alter product specifications without prior notice, in line with Company policy of continuous development and improvement.

Part of TREMCO Construction Products Group

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