

TONOFLEX 600

<Product Description>

TONOFLEX 600: Is a High performance two component polysulphide sealant

Description: **TONOFLEX 600** is a two-part polysulphide sealant which when the components are mixed together, cures to form a flexible rubber seal. It has good adhesion to concrete, stone, metals and many other common building substrates

Applications: For sealing structural floor joints in various applications such as:

- Parapet wall joints.
- Joints in metal and concrete sea walls.
- Joints in water retaining structures (including potable water when using gun grade).
- Runway aprons and runways
- Structural Floor Joints

Technical Properties:	Color:	Grey
	Solids:	100% passes the lead requirements for the VOC
	Typical shore A hardness:	ASTM D2240 ± 5 for Gun Grade
	Working life:	1:30 - 3:30 hr @ 20°C 40 - 60 min @ 35°C
	Application on temperature:	5 - 50°C
	Setting time:	36 - 48 hr @ 15°C
		15 - 20 hr @ 25°C
		10 - 15 hr @ 35°C
	Service temperature:	-40 - 90°C
	Cure rate:	7 days @ 25°C in a typical 10 mm x 10 mm
		At colder temperatures the cure rate will be extended
	UV resistance:	Good
	Biological resistance:	Resist microbiological active situations
	Service life:	20 years (when used in trafficked areas or other special environments the life may be reduced)
	Flammability:	Does not support combustion

- **MovementAccommodation:**

Buttjoints (movement in tension and compression): 25%
 Lap joints (movement in shear) 25% 50%
 VOC: < 10 g/ltr

- **Advantages:**

Cold applied.
 God adhesion to concrete, stone, metals and many other common building
 Available in two grades, gun and pouring grade.
 UV-resistant.□
 High movement accommodation on factory
 High service life

- **Standards:**

Gun Grade:
 BS EN ISO 11600 F 25 LM.
 BS4254 : 1983.
 WRAS approved product. Listing number 9609512.
 BS6920 : 1996.
 ASTM C920, Type M, Grade NS, Class 25, Use NT, T, I& M
Pouring Grade:
 BS 5212 1990 TYPE FB (includes types N & F)

- **Method of Use**

Joint Preparation:

The joint surfaces must be clean, dry and free from all contamination. The surfaces should be degreased usingthe appropriate Flex Cleaner

Priming

ISOPEEL is a universal primer suitable for usewith porous and non-porous surfaces. Using small brush applies one thin coat at the joint sides and avoid over priming. Leave the primer for 6 hours @20oC, or 3 hours @ 35oC to become tack-free and then Apply the mixed **TONOFLEX 600** sealant

- **Mixing:**

Gun grade: The base and curing agent ratio controls the adhesion, strength and durability of **TONAFLEX 600**. The components must therefore be thoroughly mixed. The curing agent and base component is supplied within the same tin and ready for mixing. Mix thoroughly using slow speed drill fitted with proper mixing paddle for 3 minutes. Make sure to scrub sides and bottom of the tin and mix again for extra 2 minutes.

Pouring grade: **TONAFLEX 600** pouring grade is supplied in two separations. the small tin which contains the curing agent should be transferred to the base tin and mix thoroughly as per gun grade above.

- **Application:** The normal method of application is to fill the mixed sealant into Flex Barrel Guns using a heavy duty follower plate. The barrel of the gun is placed over the hole in the centre of the plate. Steady downward pressure and withdrawal of the plunger rod results in the barrel of the gun being filled. To obtain a neat joints finish, apply masking tape on the top of the joint sides before apply the primer or the sealant. The sealant is then ready for application. The sealant should be extruded firmly into the joint by maintaining an even pressure on the trigger of the gun. All joint preparation, priming, and sealant application should be carried out in accordance with BS8000, Part 16, the British Standard for the sealing of joints in buildings using sealants.
- **Finishing:** The freshly applied sealant should be tooled to a smooth finish. A small amount of surface lubricant such as diluted detergent solution may be used to help achieving the right finish. Any masking tape should be removed immediately after tooling while the sealant is still at the working life.

- **Packaging:**

Gun Grade:	2.5 Ltr packs (includes base and curing agent)
Pouring Grade:	2.5 Ltr packs (includes base and curing agent). The curing agent is packaged separately within the can
Primers:	ISOPEEL 1 liter tin

- **Sealant Quantity Estimator:**

Joint size m	Litres/linear meter	Linear meter/ 2.5 ltr pack
5x 5	0.025	100.00
5x 10	0.050	50.00
10x 10	0.100	25.00
20x 10	0.200	12.50
20x 20	0.400	6.20
40x 20	0.800	3.10
50x 25	1.250	2.00
50x 50	2.500	1.00

- **Storage:** TONAFLEX 600 and ISOPEEL have a shelf life of 12 months from date of manufacture if stored at Temperatures between 2°C and 35°C.
- **Health and Safety:** The curing agent of TONAFLEX 600 contains manganese dioxide and is therefore labeled 'Harmful' under the Chemicals (Hazard Information on and Packaging for Supply) regulations 1994. The base is labeled 'Irritant' under the Chemicals (Hazard Information on and Packaging for Supply) regulations 1994.
For further information on refer to the Material Safety Datasheet.
- **Fire:** ISOPEEL is flammable.
Ensure adequate ventilation when using. Do not use near naked flame and do not smoke during use.