



## PRODUCT DESCRIPTION

**STARFIX PU-600** is a one-component, gun-grade, non-sag, moisture-cure polyurethane sealant designed to skin and cure rapidly. This high-performance product is designed with outstanding UV resistance and long-term durability.

## BENEFITS

- Paintable
- Single component & Convenient Packing
- Movement accommodation factor  $\pm 30\%$  excellent adhesion without Printing
- Highly resistant to seawater, diluted acids, and alkalis. Odorless
- UV Resistant/ Fast Curing
- Low VOC
- Accommodates 30% joint movement permanently flexible, excellent weather ability Easy to gun – Easy to tool
- Cures to a tough, durable, elastic consistency with excellent cut and tear resistance

## USES

- Sealant is designed to seal construction joints. To Seal Waterproof rivet seams and roof rails.
- To Seal Perimeter joints around windows and doors.
- Sealing corner moldings, fabricated roof-lap seams, bumper assemblies, and body-to-cab joints In motor homes. Sealing door hinges, skylights, and portholes.
- Sealing Air conditioning equipment, flashing and gutters

## TECHNICAL DATASHEET

<b>Skin Over Time</b>	>25 -35 mins.
<b>Tack Free Time (ASTM C 679 -87)</b>	1 hour.
<b>Shrinkage, %</b>	<5
<b>VOC, (g/L) (USEPA – 24)</b>	< 5
<b>Flow (sag or slump) (ASTM C 639 -01)</b>	Non-Sag
<b>Hardness: Shore A (ASTM D 2240 -97)</b>	30 $\pm$ 3
<b>Movement Capability, % (ASTM C 719)</b>	$\pm$ 30
<b>Peel Strength (N), concrete (ASTM C 794 -93)</b>	>30

<b>Tensile Strength (N/mm<sup>2</sup>) (ASTM D 412 -98a)</b>	1.3
<b>Elongation at break) (ASTM D 412 -98a)</b>	>300%
<b>Effects of Accelerated Aging @ 300 hrs. UV exposure (ASTM C 793)</b>	No deterioration
<b>Application Temperature (°C)</b>	-5°C to 40°C
<b>Service Temperature (°C)</b>	- 40°C to 80°C

## STANDARDS

- ASTM C 920 Type S, Grade NS, Class 25.
- Us Federal Specifications TT-S-00230C,
- Performance Criteria BS4254, BS5215 & BSEN 11600

## COLOURS

White, Grey, Black For another color, please contact the local SSPL representative

## PAINT/OVERCOAT COMPATIBILITY ON CURED SEALANT

- Water Base: Yes
- Solvent Base: Carryout Tests Before Hand

## EXPANSION JOINT DESIGN

**STARFIX PU-600** may be used in any joint designed in accordance with accepted architectural/engineering practices. Joint width should be at least 4 times the anticipated movement and not less than (5mm).

When applied on an expansion joint the depth (D) of the sealant should be equal to the width (W) of the joints that are less than 10mm wide. For wider joints, the width to depth ratio should be 2:1.

The maximum width of the joint on which **STARFIX PU-600** can be applied is 40 mm.

## JOINT BACKING

A closed-cell polyethylene backer rod is recommended as joint backing to control sealant depth and to ensure intimate contact of sealant with joint walls when tooling. Where the depth of joint is insufficient for the use of the backer rod, an adhesive-backed

## STAR SPECIALTIES POLYMERS PVT. LTD.

Survey No 52/3 & 54/6-D, Daman Industrial Estate, Village - Kadaiya, Nani Daman, Daman – 396210

Ph: 91-9712925770, [www.star-ind.com](http://www.star-ind.com), Mail: [info@ssplchem.com](mailto:info@ssplchem.com)

KSA

Tel. +996 12 677 7073

Email: - [ksa@star-uae.com](mailto:ksa@star-uae.com); web: - [www.star-uae.com](http://www.star-uae.com)

UAE

Tel. +971 6 5611411

Email: - [uae@star-uae.com](mailto:uae@star-uae.com) web: - [www.star-uae.com](http://www.star-uae.com)

polyethylene tape (bond breaker tape) should be used to prevent three-sided adhesion. All backing should be dry at the time of sealant application

### YIELD

The following formula is an approximate guideline to calculate foreseen yield for a standard 600 ml sausage of **STARFIX PU-600**.

- $L = 600 / (W \times D)$   
Where: L = Length of sealant in meters obtained per cartridge.  
D=Depth of the joining W=Width of the joint in mm

Joint Depth (mm)	Joint Width (mm)					
	6	10	12	15	20	25
6	6	10	12	15	20	25
6	16.6					
8		7.5	6.2	5		
10		6	5	4	3	
2					2.5	1.9
15						1.6

### SUBSTRATE PREPARATION

Surfaces must be sound, clean, and dry. All release agents, dust, loose mortar, laitance, paints, or other loose particles must be removed. This can be accomplished with a through wire brushing, sanding, or solvent washing, depending on the contamination. We recommend that surface temperatures be below 40°C at the time the sealant is applied

### FOR OPTIMUM PERFORMANCE

- In cool or cold weather, store the container at room temperature for at least 24 hours before using.
- **STARFIX PU-600** can adhere to other residual sealants in restoration applications. For best results always clean the joint as advised in the Surface Preparation section of this data guide. A product field adhesion test for **STARFIX PU-600** within the specific application is always recommended to confirm the adhesion and suitability of the application.
- When using **STARFIX PU-600** in a traffic-bearing horizontal joint, use a firmer joint backing, such as neoprene rod or polyethylene foam block, and recess the surface of sealant (3mm - 6mm).

### APPLICATION

**STARFIX PU-600** is easy to apply with conventional caulking equipment. Ensure that the backer rod is friction fitted properly. Mask the sides of the joint with tape prior to filling for a cleaner finish. Fill the joint completely with a proper width-to-depth ratio and tool to ensure intimate contact of sealant with joint walls. Dry tooling is always preferred, although xylene can be used in limited amounts to slick the spatula if needed following the initial dry tooling.

### SUBSTRATE CLEAN UP

Excess sealant and smears adjacent to the joint interface can be carefully removed with xylene or mineral spirits before the sealant cures. Any utensils used for tooling can also be cleaned with xylene or mineral spirits.

### CURING TIME

**STARFIX PU-600** generally cures at a rate of 2 mm per day at 25°C and 50% relative humidity. Skin in 15-20 minutes and be tack-free in 1 hour. Lower temperatures and humidity will extend the curing time

Pursuant to accepted industry standards and practices, using rigid paints and/or coatings over flexible sealants can result in a loss of adhesion of the applied paint and/or coating, due to the potential movement of the sealant however, should painting and/or coating be desired it is required that the applicator of the paint and/or coating conduct on-site testing to determine compatibility and adhesion.

Proper application is the responsibility of the user. Field visits by SSPL personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the job site.

### LIMITATION

- Do not apply over damp or contaminated surfaces.
- Do not use **STARFIX PU-600** as a structural (load transferring) sealant
- Do not apply when the ambient temperature is below 10°C or above 45°C.
- Do not apply during rains.
- Make sure the surface has a pull-off strength of more than 1.5 MPa.
- When applying on a concrete surface make sure the concrete is completely cured.

## STAR SPECIALTIES POLYMERS PVT. LTD.

Survey No 52/3 & 54/6-D, Daman Industrial Estate, Village - Kadaiya, Nani Daman, Daman – 396210

Ph: 91-9712925770, [www.star-ind.com](http://www.star-ind.com), Mail: [info@ssplchem.com](mailto:info@ssplchem.com)

KSA

Tel. +996 12 677 7073

Email: [ksa@star-uae.com](mailto:ksa@star-uae.com); web: [www.star-uae.com](http://www.star-uae.com)

UAE

Tel. +971 6 5611411

Email: [uae@star-uae.com](mailto:uae@star-uae.com) web: [www.star-uae.com](http://www.star-uae.com)



# STARFIX®

## PU-600

Rev. No./SSPL-1222/02

### Product Data Sheet



## CLEANING

Clean tools and equipment with water before the material hardens.

## HEALTH & SAFETY

As with all chemicals, caution should always be exercised. Protective clothing such as gloves and goggles should be worn.

**INHALATION:** Inhalation of vapor or mist should be avoided. If inhaled symptoms include coughing, wheezing, laryngitis, shortness of breath, headache, nausea, and vomiting. Immediately shift the victim to fresh air, and, if needed immediately start artificial respiration. Give oxygen if breathing is labored. Get emergency medical help.

**EYE CONTACT:** Flush eyes with water for 15 minutes and call for medical help.

**INGESTION:** causes nausea, vomiting, and loss of consciousness. If accidentally swallowed do not induce vomiting rather call for medical help immediately.

**SKIN CONTACT:** Flush with water or soap and water till all traces have been removed. Seek medical attention if required.

## STORAGE & SHELF LIFE

Shelf life is 12 months in a sealed Sausage. Store away from sunlight and preferably below 30°C. Storage should be frost protected.

## PACKING

**STARFIX PU-600** is available 600 ml sausage, 20 Sausage per carton.

## WARRANTY

The information given is based on our knowledge and performance of the material. Every precaution is taken in the manufacture of the product and our responsibility is limited to the quality of supplies with no guarantee of the results in the field, as the manufacturer has no control over site conditions or execution of work.

## DISCLAIMER

The product information & application details given by the company & its agents have been provided in good faith & meant to serve only as a general guideline during usage. Users are advised to carry out tests & take trials to ensure the suitability of products meeting their requirements prior to full-scale usage of our products. Since the correct identification of the problems, quality of other materials used, and the on-site workmanship are factors beyond our control, there are no expressed or implied guarantees/warranty as to the results obtained. The company does not assume any liability or consequential damage for unsatisfactory results, arising from the use of our products.

## STAR SPECIALTIES POLYMERS PVT. LTD.

Survey No 52/3 & 54/6-D, Daman Industrial Estate, Village - Kadaiya, Nani Daman, Daman – 396210

Ph: 91-9712925770, [www.star-ind.com](http://www.star-ind.com), Mail: [-info@ssplchem.com](mailto:-info@ssplchem.com)

**KSA**

Tel. +996 12 677 7073

Email: - [ksa@star-uae.com](mailto:ksa@star-uae.com); web: - [www.star-uae.com](http://www.star-uae.com)

**UAE**

Tel. +971 6 5611411

Email: - [uae@star-uae.com](mailto:uae@star-uae.com) web: - [www.star-uae.com](http://www.star-uae.com)