

REC FLEX 425 Si

HIGH ULTIMATE TENSILE STRENGTH SEALANT IDEALLY SUITED FOR STRUCTURAL BONDING AND PROTECTIVE GLAZING APPLICATIONS

DESCRIPTION

REC FLEX 425 Si is a one-part neutral-curing silicone sealant designed specifically for structural bonding applications of glass and metal in factory or field situations. The rate of surface cure and cure-in-depth of most one-part RTV silicone sealants is affected by the temperature and humidity of the environment. However, an environment of high temperatures in combination with high humidity may slow the surface cure rate of **REC FLEX 425 Si**.

PRIMARY APPLICATION

Silicone structural glazing and protective glazing applications.

FEATURES/BENEFITS

- Odorless, non-corrosive cure system.
- Cures to form an extremely tough elastomeric rubber ensuring a durable, flexible, watertight bond.
- Excellent weather ability and high resistance to ultraviolet radiation, heat and humidity, ozone and temperature extremes.
- Excellent mechanical properties.
- Successfully tested for use in protective glazing applications.
- Excellent unprimed adhesion to wide range of substrates including coated, enameled, and reflective glasses; anodized and polyester coated or painted aluminum profiles including most fluoropolymer-based paints.

TECHNICAL INFORMATION

Color	Black, gray, white	
Tack-Free Time, 50% RH (ASTM C679)	65 minutes	
Curing Time 25°C (77°F) at 50% RH	7–14 days	
Full Adhesion	14–21 days	
Flow, Sag, or Slump (ASTM C639)	0.1 inches	
Working Time	10–20 minutes	
Specific Gravity	1.339	
VOC	30 g/L	
Joint Movement Capability (ASTM C719)	±50 %	
Ultimate Elongation (After 7 Days)	525%	
Shore A Hardness (ASTM 2240) (After 7 Days)	40	
Ultimate Tensile Strength (ASTM D412) (25°C, 50% RH)	After 7 Days	After 21 Days
	350 psi (2.41 MPa)	170 (1.17 MPa)
Tensile after 21 Days (ASTM C1135)	At 25% Elongation	At 50% Elongation
	43 psi (0.30 MPa)	65 psi (0.43 MPa)

APPLICABLE STANDARDS

REC FLEX 425 Si complies with ASTM C-920 Type S & ASTM C1184.

DIRECTIONS FOR USE

a. SURFACE PREPARATION

Clean all joints and glazing pockets, removing all foreign matter and contaminants such as grease, oil, dust, water, frost, surface dirt, old sealants, or glazing compounds and protective coatings.

b. APPLICATION METHOD

Install back-up material or joint filler, setting blocks, spacer shims, and tapes. Mask areas adjacent to joints to ensure neat sealant lines. Primer is generally not required on non-porous surfaces, but may be necessary for optimal sealing of certain porous surfaces. A test placement is always recommended.

Apply **REC FLEX 425 Si** in a continuous operation using a positive pressure. (The sealant can be applied using many types of air-operated guns and most types of bulk dispensing equipment.) Before a skin forms (typically within 10 minutes), tool the sealant with light pressure to spread the sealant against the backing material and joint surfaces. Remove masking tape as soon as the bead is tooled.

LIMITATIONS

REC FLEX 425 Si should not be applied:

- To building materials that bleed oils, plasticizers, or solvents— materials such as impregnated wood, oil-based caulks, green or partially vulcanized rubber gaskets or tapes.
- In totally confined spaces as the sealant requires atmospheric moisture for cure.
- When surface temperatures exceed 60°C (140°F).
- Where painting of the sealant is required, as the paint film may crack and peel.
- To surfaces in contact with food— this sealant does not comply with Federal Food and Drug Administration food-additive regulations.
- In below-grade applications.
- For use as an interior penetration fire stop sealing system.
- In horizontal floor joints where abrasion and physical abuse are likely to be encountered.
- To frost-laden or damp surfaces.
- For continuous immersion in water.

PACKAGING

This product is available in different sizes and can be supplied to client on demand.

STORAGE & SHELF LIFE

12-month shelf life from manufacture date when stored in a cool, dry area. Elevated temperatures >50°C may reduce shelf life.

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