



PERMATHANE® SM6104 Controlled Flow Sealant

TECHNICAL DATA

PRODUCT DESCRIPTION:

Permathane® SM6104 Controlled Flow Sealant is a one component, moisture cure, polyurethane sealant. It is designed to seal small joints. SM6104, after cure, is highly elastic and has excellent adhesion to a wide variety of substrates. A tack free skin is formed during the curing process in 2 to 4 hours at normal conditions (75°F/23.88°C, 50% R.H.) and full cure takes place in 24 to 48 hours. Cure rates vary with changes in temperature and humidity.

BASIC USES:

SM6104 is designed to seal joints that are found on recreational vehicle and mobile modular roof systems.

ADVANTAGE:

- Accommodates 50% joint movement
- Permanently flexible, excellent weatherability
- Easy to gun – Easy to tool
- Cures to a tough, durable, elastic consistency with excellent cut and tear resistance
- Paintable (waterbased or oil) – non-sticky after cure
- VOC Compliant
- Not affected by water contact during or after cure on non-porous substrates.

TYPICAL USES:

- Lap joints
- Gutter systems
- Vent flanges
- Through roof attachments
- Air conditioning mounts

SPECIFICATION COMPLIANCE:

Permathane® SM6104 Controlled Flow Sealant meets or exceeds the test requirements of:

ASTM C 920* Type S, Class 25
* except for rheological properties

WARNING:

SM6104 SHOULD NOT BE APPLIED IN PROXIMITY OF OXIME CONTAINING UNCURED SILICONE. CURE OF SM6104 WILL BE IMPAIRED.

TYPICAL PROPERTIES:

Property	Typical Value	Test Method
Peel Adhesion:	15 – 25 P.L.I.	ASTM C794
Viscosity:	200,000 – 250,000 cps	HBT Brookfield Viscosimeter, #5 spindle @ 5rpm
Elongation:	700% (81% Recovery)	ASTM D412
Percent Solids:	97% Min.	
Hardness (Shore A):	30-40	ASTM C 661
Service Temperature Range:	-40°F to 200°F, (-40°C to 93.3°C)	
Water Resistance:	Passes	AAMA 800
Flash Point:	148°F (64.4°C)	ASTM D56
Odor:	Slight aromatic before cure – None after cure	
Skin Time*:	2-4 hours	
Cure Time*:	24-48 hours	
* Skin and cure times are dependant on temperature, humidity, and porosity of the substrates. The above times are based on a 3/16" (5mm) bead at 75°F and 50% relative humidity. Low humidity, cooler temperature and non-porous substrates will lengthen these times.		
Shelf Life:	SM6104 will exhibit a twelve (12) month shelf life when stored at or below 80°F (26.7°C)	

APPLICATION:

It is always recommended that a bead of sealant be applied to the surface of a substrate to pretest for adhesion. A clean, dry, sound and uncontaminated surface is recommended. Mill finish aluminum may contain an invisible oil film or oxide. Clean with a good degreasing solvent like xylene, toluene or commercial grade isopropyl alcohol. The use of these solvents (or other solvents) may be hazardous to your health. Use only in well ventilated areas. **KEEP CLEANING SOLVENTS AWAY FROM OPEN FLAME.** Read all labeling prior to use, and follow solvent manufacturer's recommendations / instructions for safe handling. In some cases, abrasion of the surface with steel wool or fine emery paper may be required during preparation. Many high-performance coatings or unusual surface treatments may require special preparation.

APPLICATION LIMITATIONS:

- SM6104 must not be applied to frost-bearing surfaces or if temperature will be below freezing within 24 hours.
- Special architectural finishes without proper testing.
- Joints contaminated with silicone type cutting or fabricating oils.
- Joints that exceed 3/16" (4.76 mm) width and depth.

PRECAUTIONS:

If this product is used in direct contact or in close proximity with any other sealant or elastomer, a compatibility test must be conducted by the purchaser or user prior to use. When applied in close proximity, oxime containing silicones will prevent SM6104 from curing. There will be no problem if either sealant is applied and allowed to cure prior to the application of the other. Use caution if applying the silicone first since SM6104 will not adhere to silicone or its residue.

Avoid skin and eye contact. On contact, uncured sealant could cause irritation to the skin and eyes. In case of eye contact, flush eyes with warm water for 15 minutes, call a physician. For skin contact remove sealant with a paper towel. If swallowed, do not induce vomiting, call a physician. **KEEP OUT OF REACH OF CHILDREN.** This product is manufactured for industrial use only.

EXCLUSION OF WARRANTIES:

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1-800-TRUSTSM
1-800-878-7876

SCHNEE-MOREHEAD[®], INC.

111 N. Nursery Road
Irving, TX 75060
972-438-9111 Fax: 972-554-3939
www.trustsm.com