



## TECHNICAL DATA SHEET

### FULAFLEX FAÇADE

#### Description

FulaFlex Facade is a high performance, high joint-movement, methoxysilyl-terminated silane polymer specifically formulated for use in applications where a sealant that can maintain a high degree of joint movement is required. FulaFlex Facade cures to form a seal that is tough, elastic and weatherproof with good chemical resistance. FulaFlex Façade has excellent application and tooling properties to ensure a clean and neat application can be achieved.

#### Standards Compliance

- **ISO 11600** Type F, Class 50, sub-class LM
- **ASTM C-920** Type S, Grade NS, Class 50, Use: NT, A and G
- **ASTM C719** - Highly flexible -  $\pm 50\%$  of original joint width
- **ASTM C794** (Adhesion in peel) - PASS
- **ASTM C793** Weatherability - Excellent resistance to weathering and UV radiation, resists yellowing
- **ASTM C1442** Adhesion in peel under cycle UVA/ASTM G154 Cycle 1 - PASS
- **ASTM C510** Staining and colour change - PASS

#### Benefits

- Isocyanate and solvent free
- Mould Resistant – Will not support fungal growth
- Excellent long term chemical resistance to seawater, caustic solutions and cleaning agents
- Short term chemical resistance to petrol, grease and mineral oils
- Long open time

- No bubble formation when curing
- Paintable with high build, flexible emulsion coatings
- Strong adhesion
- Sag Resistant
- Meets the criteria of a sealant for use in AS3740-2010 (Waterproofing of Domestic Wet Areas) waterproofing applications

#### Uses

- Sealing expansion joints in external facades constructed of aluminium and other building materials
- Sealing expansion and control joints in tiling, walls, roofs, wall, door and window frame perimeters, cladding and brickwork
- Applications where a high amount of joint movement is anticipated

#### VOC Content

VOC content: (Californian South Coast Air Quality Management Rule 1168) is 0g per litre. This product is VOC-free.

#### Compatible Substrates

Concrete	Ceramic
Cement sheeting	Plastics (pretest)
Masonry	ABS (pretest)
Plasterboard	Aluminium
Steel inc. Painted Steel	Glass
Powdercoated Extrusions*	

\*Contact the H.B. Fuller Technical Department for a list of approved powdercoated extrusion colours.

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### Performance Data

Property	Data
Polymer Base	Methoxysilyl-terminated polymer
Specific Gravity	ca. 1.40
Sag	Nil @ 25°C
Shrinkage	0%
Skin time	ca. 40 minutes @23°C / 50% RH
Cure Rate	ca. 2 mm / day @ 23°C / 50% RH
Full Cure	After 7 days
Storage Life	12 months unopened
Durometer Hardness	ca. Shore A 20
Service Temperature	-40°C to 100°C
Modulus – 50%	ca. 0.2MPa
Modulus – 100%	ca. 0.4MPa
Max. Tensile Strength	ca. 1.2MPa
Elongation (ISO 37)	>900%
Application temperature	5°C to 40°C

### Coverage

Approximate linear meters coverage of FulaFlex Facade sealant as per table:

Joint Width mm	Joint Depth mm	Yield (600ml sausage (Lineal metres))
6 (min)	6	16.7
10	10	6.0
12	12	4.2
18	12	2.7
24	12	2.1
30	15	1.5

### Pack Sizes

FulaFlex Facade is available 600ml sausages.

### Surface Preparation

All surfaces must be clean, dry, sound and free of dust, oil, old sealant or other contamination.

Lightly contaminated surfaces should be wiped with Isopropyl Alcohol (IPA) using the 2-rag wipe method. Apply IPA to a clean lint-free cloth and wipe onto the surface to be cleaned to solubilize and remove the majority of the contaminant. A clean dry cloth should then be applied to remove remaining contamination and dry the surface. Ensure wet cleaner is not allowed to dry on surface. For more heavily contaminated surfaces or where the IPA does not remove the contaminant, a generic wax and grease remover should be applied using the same 2-rag wipe method. Once this has been completed the surface should be given a final clean with IPA using the 2-rag wipe method to ensure the surface is adequately prepared. Adhesion to metals and some surface finishes can be further improved by light abrasion prior to cleaning with IPA using the 2 rag-wipe method. Manufacturers of plastics should be consulted about suitable cleaning solvents. Adhesion to plastics should be pre-tested. Mask either side of joint to produce a neat finish.

Use a suitable sized foam backing rod or polyethylene bond breaker tape to prevent three sided joint contact impeding the free and even deformation of the sealant in a cyclic joint. Open-cell polyurethane foam is recommended. Use a size 25% wider than the joint width that will compress when inserted into the joint.

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### Joint Design

A good joint design is imperative if a sound, durable seal is to be achieved.

In general, joints should be designed to be at least 4 times as wide as the anticipated movement.

Joint width and depth should not be less than 6 mm and depth should never exceed width.

Joint Width.	Recommended Joint Depth.
< 10 mm	Depth = Width (1:1)
10 mm – 25 mm	Width/Depth ratio 2:1

### Product Application

Cut tip off sausage. Cut nozzle at an angle to desired size. Insert sausage into gun barrel and attach nozzle onto caulking gun. Apply sealant in a steady, continuous flow by pushing the sealant ahead of the nozzle so that it completely fills the joint and is in contact with both sides. Immediately after application, tool the sealant using a spatula. A dilute soap/water detergent solution may be used to tool FulaFlex Facade, although the solution should be pre-tested to confirm it does not affect the sealant in any way, as this can compromise long-term durability. Avoid contact with alcohol or other solvent cleaners during cure. Remember to remove the masking tape before the sealant skins.

### JOINT DESIGN CONSIDERATIONS AND CAULKING GUIDELINES FOR FACADE SYSTEMS

FulaFlex Facade achieves an exceptional primer-free bond to both aluminium and fibre cement facade panels, coating systems and auxiliary components. As the fabrication and finish of facade panels can vary, the H.B. Fuller Technical Department recommends pre-testing these substrates or submitting samples to H.B. Fuller for benchmarking qualification.

### Surface Preparation

Thoroughly clean all surfaces with Isopropyl Alcohol (IPA), wax and grease remover, or similar oil/grease free cleaning agent. This includes top-hats, panel/joint edges and the rear of the panel where the sealant comes in contact with that surface.

Do not use cleaners that will leave a residue on the substrate as this will compromise adhesion performance.

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### Caulking

Mask joint edges to create a neat joint edge. Gun sealant into the joint and tool the sealant to ensure complete contact with the joint edges and backing rod/material. Avoid three-sided joint adhesion as this will compromise the free and even deformation of the sealant under cyclic movement.

Tool FulaFlex Facade within 30 minutes to leave a concaved joint finish to minimize the risk of the sealant standing proud of the panel face under panel expansion (sealant compression.)

Avoid the use of tooling lubricants due to the risk of lubricant contacting joint edges prior to the sealant and consequent adhesion failure.

Remove masking tape immediately after tooling the sealant, pulling the tape in a direction away from the sealed joint.

### Cassette Installation Method (Figure 1)

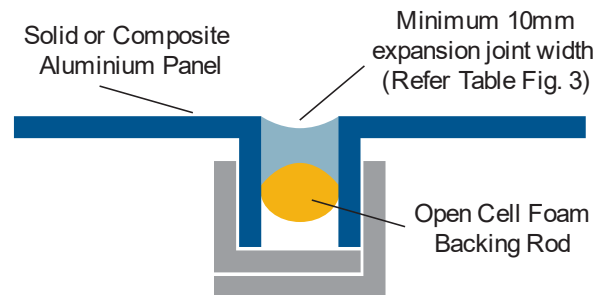
Refer to the panel manufacturers' installation specifications.

Install a foam backing rod to prevent three-sided joint contact and to provide a suitable backing for tooling the sealant.

Open cell foam backing rod is recommended, this will assist the sealant curing from the rear of the joint.

The recommended joint width to depth ratio is 1:1 for joints 10mm wide, and 2:1 for joints 20mm and above. For joint widths ranging from 10mm to 20mm, use a sealant depth of 10mm. Ensure the joint depth never exceeds the joint width. The minimum joint width should always be 10mm.

Figure 1



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### Additional Considerations

- Climatic conditions at time of caulking**  
Aluminium facade panels can be subjected to significant expansion and contraction depending on climatic conditions. This must be taken into consideration when caulking aluminium facade systems as excessive joint movement in joints caulked with FulaFlex Facade prior to the sealant completely curing can compromise sealant performance and appearance. **Figure 2** illustrates the impact of temperature change on panel dimensions and the consequent impact on a flexible joint seal.

**In all cases avoid caulking joints at or towards the minimum or maximum anticipated panel service temperatures eg the heat of a summer day or the cold of a winter day. Pay particular attention to joints in the northern and western elevations.**

A joint sealed at or close to the maximum anticipated service temperature will experience all or most of its calculated movement in extension as the element cools (adhesive and cohesive stress on sealant.) Conversely, a joint sealed at or close to the minimum anticipated service temperature will experience all or most of its calculated movement in compression as the element warms (risk of sealant being squeezed from joint)

Figure 2 – Panel Thermal Expansion

Panel Temp	Panel Movement	Joint Movement	Sealant Behaviour
Increase	Expansion	Joint narrows Sealant is compressed	
Decrease	Contraction	Joint widens Sealant is extended	

**Note:** Joints sealed approximately midway between the minimum and maximum anticipated service temperatures will experience an approximately equal amount of expansion and contraction thus minimising the extent of each of the above movement types on the sealant joint.

### 2) Calculating Anticipated Joint Movement

Required information:

- Distance between joints in metres/Length of the building element (Measure.)
- Coefficient of expansion of the building element (consult the manufacturer of the panel)

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3) Anticipated change in temperature of the element in °C (Project the possible change in temperature considering the geographic area - the coldest winter temperature of the element, to the hottest summer temperature, as well as the possibility of the element reaching higher than ambient temperatures eg. a dark coloured panel in the sun)

The below formula can be used to calculate the total joint movement to anticipate.

**Formula:**  $\Delta L = \alpha \times L_o \times \Delta T$

Where:

$\Delta L$  = Change in length of element in metres

$\alpha$  = Coefficient of thermal expansion of element

$L_o$  = Length of element/distance between joints

$\Delta T$  = Change in temperature of the element in °C (max. – min. anticipated service temperatures.)

e.g. An aluminium facade panel with a coefficient of thermal expansion:

$\alpha = 24 \times 10^{-6} \text{ mm/mm}^\circ\text{C}$

$L_o = 3.0\text{m}$  panel length/ distance between expansion joints

$\Delta T = 80^\circ\text{C}$

so:

$\Delta L = 0.000024 \times 3 \times 80$   
 $= 0.00576 \text{ metres} = 5.76 \text{ mm}$

Under this example, over the temperature range of 80°C, a 3m length of aluminium facade panel can be expected to change in length by 5.76mm.

Assuming a joint sealed midway between the minimum and maximum service temperatures i.e. equilibrium temperature, a 10mm joint could be expected to expand to 12.88mm wide (+28.8%) and contract to 7.12mm (-28.8%)

**Note: The sealant movement capability must always exceed the total anticipated joint movement.**

e.g. The 10mm joint in the example above requires a sealant with a total movement capability of > 57.6%, (say 60%). The sealant requires a minimum movement capability of +/- 30%.

If the joint were sealed at or close to the maximum element temperature, then it can be expected that the joint will expand by close to 5.76mm by the time the element reaches its minimum temperature.

The sealant now requires a far greater joint movement capability (57.6%) a sealant with a minimum of +/-60% joint movement.

If the joint were sealed at or close to the minimum element temperature, then it can be expected that the joint will contract by close to the aforementioned 5.76mm.

The sealant now requires a far greater joint compression capability 57.6%, or, the installed joint must be made wider.

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**Note: A lesser number of joints which are further apart (i.e. greater panel length), requires the joints to be wider or a more flexible sealant as the element will expand and contract predictably further distances.**

Given it is not always practically possible to seal joints midway between the minimum and maximum anticipated element temperatures, it is important to ensure that joint widths and panel lengths (distance between free joints) are in consideration of a maximum possible percentage change in joint width which is well within the specified limit of +/-50% of the original joint width.

**Note: When installing panels it is equally important to consider the panel temperature at the time of fixing.**

A panel installed at or close to the minimum or maximum anticipated service temperatures can significantly impact on the intended joint width.

**Accounting for the likelihood of joints being sealed at temperatures above or below equilibrium temperature**

The installed sealant joint width should always make consideration for joints being sealed at or close to the minimum or maximum possible element temperatures.

**Figure 3** Minimum joint width requirements for various panel lengths using FulaFlex Facade

Figures based on:

$$\alpha = 24 \times 10^{-6} \text{ mm/mm/}^{\circ}\text{C}$$

$$\Delta T = 80^{\circ}\text{C}$$

**Consult H.B. Fuller if greater than 80°C service temperature range is anticipated**

**Figure 3 - Joint Width**

Joint Movement Capability: +/-50%

Panel Length (m)	Anticipated Panel Movement (mm)	Min. Joint Width (mm)
1.2 – 2.6	2.30 – 4.99	10
2.6 – 3.0	4.99 – 5.76	10 - 12
3.0 – 3.8	5.76 – 7.29	12 – 15
3.8 – 4.6	7.29 – 8.83	15 – 18
4.6 – 5.0	8.83 – 9.60	18 - 20

### 3) Periodic Cleaning of Panels and Joints

Observe the panel manufacturer recommendations with regard to suitable cleaning agents.

Solvents should not be used to clean the sealed joints, which may cause the surface of the sealant to become sticky and attract dirt.

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### Site Specific Warranties

H.B. Fuller Australia provide project/site specific warranties for FulaFlex Facade. Contact H.B. Fuller Australia for further details.

### Painting

Overpainting is not recommended due to the high joint movement capability of FulaFlex Facade, which will be greater than that of the applied paint. Flexible acrylic-based emulsion coatings can be used over FulaFlex Facade.

Oil based coatings and coatings containing a solvent are likely to remain tacky for an extended period of time and are not recommended to be used over FulaFlex Facade.

### Chemical Resistance

FulaFlex Facade has been tested to the following standards relating to chemical resistance and staining:

ASTM C510 Stain and Colour change - PASS

Long-term chemical resistance to fresh water, salt water, limewater, caustic solutions and cleaning agents. Short-term chemical resistance to petrol, grease and mineral oil. Low resistant to organic acids, concentrated mineral acids or solvents.

The H.B. Fuller Technical Department can test specific chemicals/applications upon request to confirm suitability.

### Clean Up

Best results are obtained by masking prior to sealing to avoid the necessity for clean up. However, if sealant is applied to areas where it is unwanted, clean up uncured sealant using toluene\*, xylene\*, methyl ethyl ketone\*, acetone\* or mineral turpentine\* and a cloth. Take precautions to avoid staining substrates when using solvents. Cured sealant should be removed by abrasion or trimmed with a sharp knife. Do not undercut seal.

### Limitations

- Avoid exposure to high levels of chlorine e.g. pools.
- Do not use in joints deeper than 15 mm.
- Avoid contact with alcohol and other solvent cleaners during cure phase.
- Pre-testing is required on marble or other highly porous stone – substrate finish may be affected.
- Solvent-based coatings may remain tacky.
- Do not use on bituminous surfaces.
- Do not use on materials that bleed oil and plasticisers or solvents, as this will affect adhesion (e.g. most rubbers.)
- Not a fire rated or glazing sealant. Not suitable for glazing use with glass, acrylic or polycarbonate sheets.
- Not suitable for floor applications or foot traffic areas.
- Not suitable for use in roofing lap joint applications where the sealant is feathered down to zero application weight – for such applications consider the use of silicone.
- Not suitable for swimming pools or hot tubs.

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**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 22225588







## TECHNICAL DATA SHEET

### Safety Information

This product is not considered hazardous under the classification of GHS WHS Version 8. Further safety information is available on the product SDS. Avoid contact with skin and eyes. Store in a dry place below 30°C. Keep out of reach of children. An MSDS is available from the H.B. Fuller representative in your state, H.B. Fuller Australia customer service, or downloadable from the H.B. Fuller web site, [www.hbfuller.com.au](http://www.hbfuller.com.au).

### Disclaimer

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**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 2225588

