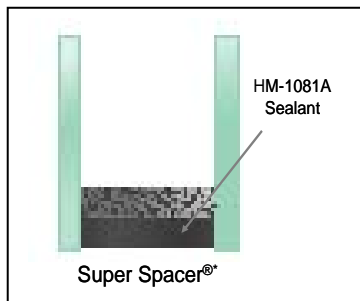
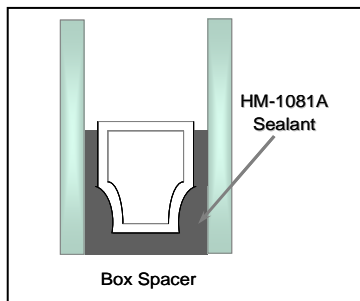




## HM-1081A Product Information

### Product Description

HM-1081A hot melt butyl is a 100% solids, single-component sealant designed for the sealed insulating glass industry. It is formulated from butyl rubber, synthetic polymers and elastomers to give outstanding adhesion to glass and aluminum when fabricated manually. The product is resistant to degradation from ultraviolet light, temperature extremes and water immersion.



### Application Limitations

- HM-1081A is compatible with low E coatings. It should **not** be used in non-edge deleted applications unless approved by the glass supplier.
- HM-1081A is **not** intended for structural glazing applications.

**ADEQUATE TESTS:** The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all of your requirements.

**Table 1**

#### Typical Application Properties

Color	Black or Gray
Shelf Life	One Year
Hand Gun Application Temp. (at tip)	390 - 410°F
Form and Packaging	Drum, Pail, Cake, Tubes

**Table 2**

#### Typical Physical Properties

Raw Material Base	Synthetic Resin
Approximate Pounds per Gallon	9.8
Specific Gravity	1.17
Viscosity @ 400°F	300,000 cP (mPA.s)
MVTR 100°F/98% RH 60 MIL	0.74 g/m <sup>2</sup> /day
Thermal Conductivity	0.22 W/mK
RT, Lap Shear – Aluminum	45 psi

- HM-1081A should only be used in sloped glazing applications after review by a design specialist. It should **not** be used if the IG is unframed or unsupported.

### Applicable Standards

HM-1081A hot melt sealant meets or exceeds the requirements of the following standards:

- ASTM E2190
- CAN/CGSB 12.8

### Surface Preparation

Glass must be cleaned with detergent and hot water when using the HM-1081A hot melt sealant. We suggest following your glass washer or glass supplier's recommended practices for glass washing. Good practices include using hot water (120 - 140°F) and detergent.

*Do we need to edge delete our low-E glass? We have done some limited performance testing with specific types of non-edge deleted low-E glass.*

Your H.B. Fuller representative can supply you with a list of testing types and results.

Contaminants on the spacer stock affect the adhesion of HM-1081A hot melt sealant. Coil and spacer stock should always be covered when stored. Contaminants like oil, dust, corrosion and dirt negatively affect the adhesion of any sealant. Check for cleanliness by taking a clean white cloth and wiping the spacer. Any noticeable particles or oils must be removed prior to manufacturing.

\* Super Spacer® is a registered trademark of Edgetech, Inc.

**H.B. FULLER'S ACCEPTANCE OF ANY ORDERS FOR THIS PRODUCT IS EXPRESSLY CONDITIONAL UPON PURCHASER'S ASSENT TO THE TERMS SHOWN ON THE REVERSE SIDE.**

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## Glazing

All glazing recommendations of the Insulating Glass Manufacturers Alliance (IGMA) should be followed. Contact between HM-1081A hot melt butyl edge seal and any solvent- or oil-containing glazing compound should be avoided. For recommendations on specific glazing designs or use of glazing compounds, contact H.B. Fuller.

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## Equipment Suggestions

Drum unloaders with gun attachments are available. H.B. Fuller is a distributor of application equipment and can help you select the right system for your operation. We also have equipment service capabilities.

The development of semi-automatic equipment for hot butyl has resulted in many new operations using high-speed, high-technology equipment. H.B. Fuller has trained technicians who can help set up and train personnel in the operation of this equipment.

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## Clean Up

Any material can be cleaned up with a common solvent, such as acetone or mineral spirits.

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## Health & Safety Precautions

To minimize the risk of burns, eye protection and thermally protective clothing should be worn when working near a hot melt applicator. To minimize the risk of flammable vapors, do not exceed a melt temperature of 450°F. Prevent the buildup of vapors. Extinguish all sources of ignition during hot melt use. Use only in a well-ventilated area. Consult Material Safety Data Sheet for additional information.

### **WARNING: EXTREME CARE SHOULD BE EXERCISED WHEN WORKING WITH HOT MELTS IN THEIR HOT, FLUID STATE.**

Severe burns will result if skin contact occurs. When moving a hot melt from one location to another, protective gloves should be worn. If skin contact occurs, immediately immerse contact area in cold, clean water for at least 30 minutes. Cover contacted area with a wet, clean compress, and see a physician immediately.

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## Packaging & Shelf Life

HM-1081A hot melt sealant is packaged and shipped in sealed, straight-sided 55-gallon drums and five-gallon pails and cakes. HM-1081A hot melt sealant has a shelf life of one year from the date of manufacture.

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## Disposal

- In most localities, empty pails or drums may be crushed and sent to a local landfill. Since local landfills have the right to refuse any material, check first.
- Check with the local drum recycler to see if they will accept the empty drums for recycling.
- Empty drums or pails also may be discarded as scrap metal for a local scrapping company.
- Check the Material Safety Data Sheet for disposal requirements.

Revised: 21 October 2009

## **LIMITED WARRANTY AND TERMS**

### **H.B. FULLER COMPANY**

H.B. Fuller Company ("Fuller") warrants that, for a Warranty Period of one year (or the period specified on the applicable Technical Data Sheet, whichever is less) from the date of shipment from Fuller to the Initial Purchaser, that this Fuller product was manufactured in accordance with Fuller's specifications in effect on the date of manufacture. These specifications are available upon request. This Warranty does not cover test data, or any defects, damages or other harms caused to any extent or in any way by failure to follow applicable Fuller instructions, if any, or abuse or misuse of the product.

**WARRANTIES DISCLAIMED — THE WARRANTY STATED IN THE PARAGRAPH ABOVE IS IN PLACE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. Fuller EXPRESSLY DISCLAIMS ANY OTHER WARRANTIES, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.** ALTHOUGH Fuller MAY HAVE SUGGESTED THE PRODUCT OR DEVELOPED THE PRODUCT AT THE PURCHASER'S REQUEST, IT IS THE PURCHASER'S RESPONSIBILITY TO TEST AND DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURCHASER'S INTENDED USE AND PURPOSE, AND PURCHASER ASSUMES ALL RISK AND LIABILITY WHATSOEVER REGARDING SUCH SUITABILITY.

**LIMITATIONS OF REMEDIES AND DAMAGES — FOR ANY VALID CLAIM PRESENTED UNDER THE LIMITED WARRANTY, Fuller WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS REPLACEMENT/REFUND REMEDY IS THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY AGAINST Fuller. THE PURCHASER AGREES THAT NO OTHER REMEDY (INCLUDING BUT NOT LIMITED TO LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO PURCHASER FOR CLAIMS ARISING OUT OF ANY USE OF THE PRODUCT REGARDLESS OF THE LEGAL THEORY (CONTRACT, TORT OR OTHER). IN NO EVENT WILL Fuller BE OBLIGATED TO PAY DAMAGES TO PURCHASER IN ANY AMOUNT EXCEEDING THE PRICE THAT THE PURCHASER PAID FOR THE PRODUCT.**

**NO INDEMNITIES** — Except as expressly stated herein, in no event will Fuller be liable to indemnify or to hold Purchaser harmless against any form of liability.

**LIMITATION OF ACTIONS AND VENUE** — Any claim made or action commenced by Purchaser under Fuller's limited warranty as set forth herein must be brought within one year from the date of shipment from Fuller to the Purchaser. Purchaser agrees that all disputes arising from Fuller's sale of product to Purchaser shall be brought, if at all, in and before a court located in the State of Minnesota, to the exclusion of the courts of any other state.

**ARBITRATION** — Purchaser agrees that any claim of less than \$100,000 shall be submitted for binding arbitration before a single arbitrator and shall be governed by the rules and procedures of the American Arbitration Association. The arbitrator and the American Arbitration Association shall be paid by the Purchaser.

**CONDITIONAL ACCEPTANCE** — Fuller's acceptance of Purchaser's order for this product is expressly conditional on Purchaser's assent to terms and conditions set forth herein.