



# SpECseal 625

TWO PART, POLYSULPHIDE JOINT SEALANT

## DESCRIPTION

**SpECseal 625** is a two part, low modulus, chemically curing polysulphide joint sealant developed specifically for dynamic joints. It is based on a liquid polysulphide polymer which when mixed with the hardener, cures to form a tough rubber like seal.

**SpECseal 625** is available in both gun and pouring grade.

## TYPICAL USES

For sealing and resealing high movement joints in building and civil engineering structures and for sealing joints in structures which are subject to high rapid movements.

## ADVANTAGES

- Tough and resilient seal
- Provides permanent and uniform water tight seal
- Excellent adhesion to most surfaces
- Stays flexible - no brittle or cracking due to UV exposure
- Pouring and gun grades for horizontal, vertical and overhead applications
- Good chemical & weathering resistance
- Non-toxic once cured
- High resistance to ageing
- Water resistance
- Non-trafficable (NT) and trafficable (T) areas

## TECHNICAL DATA

<b>Movement accommodation factor (BS 6093 1993)</b>	25% for butt joints
<b>Pot life</b>	1 hours at 25 °C
<b>Curing time</b>	tack free within 24 hours @ 25 °C
<b>Full cure time</b>	7 days at 25 °C
<b>Hardness (Shore 'A')</b>	20 ± 5 @ 25 °C
<b>Appearance after curing</b>	rubber like solid
<b>Pull-off strength</b>	0.86 N/mm <sup>2</sup>
<b>Tensile strength</b>	0.30 N/mm <sup>2</sup>
<b>Elongation @ break</b>	700%

<b>Volume shrinkage</b>	0.4%
<b>Effect of heat ageing</b>	1.14%
<b>Solids content</b>	100%
<b>VOC (USEPA 24)</b>	1.29 g/l
<b>Specific gravity</b>	1.55 - 1.65
<b>Colour</b>	Grey
<b>Complies with ASTM C920</b>	

## CHEMICAL RESISTANCE

Resistance to UV & Ozone	Excellent
Resistance to staining	Excellent
Suphuric acid	Good
Hydrochloric acid	Good
Nitric acid	Good
Sodium hydroxide	Good
Calcium hydroxide	Good
Ammonium hydroxide	Good
Fuels (solvents)	Good
Oil	Good
Sewage water	Good
Subkha sand	Good

## DESIGN IMPLICATIONS

The width of the joint sealant should be a minimum of four times the anticipated movement. Joints with cyclic movement should have a width to depth ratio of 2:1 but minimum depth of the sealant should be maintained as recommended:

- 10mm for all porous surface
- 20mm for joints exposed to traffic and hydrostatic pressure
- 5mm for impervious surface such as metals, glass, etc.

## APPLICATION

### Joint Preparation

The joint surface must be clean, dry and free from oil, loose mortar, laitance, release agents and other contaminants. A thorough wire brushing, grinding, sand blasting or solvent cleaning may be required to exposed clean, sound surface.

**SpECseal Primer 25** for use on porous and non-porous surfaces.

**SpECseal Primer 25** is a two component primer. The base and hardener components should be mixed together for 2 minutes to produce a uniform consistency.

The primer should be applied to clean, dry surfaces prior to the installation of backer rod or bond breaker tape.

The freshly mixed **SpECseal 625** should be applied after the primer solvent has been released and when it is just touch dry. The sealant should be applied ½ - 2½ hours after priming.

If the primer is left to dry longer than 2½ hours the surfaces must be re-primed prior to applying the sealant.

**SpECcord** or **SpECcell Polyethylene** should be used to control the depth of the joint to the recommended thickness. Where joint design or depth of joint will not permit the use of backing rod, use a bond breaker tape over the cut back joint filler.

### Mixing

**SpECseal 625HD** is the gun grade and is supplied in 2.5 litre composite packs with the base and curing agent placed in the tin ready for mixing.



**SpECseal 625P** is the pouring grade and is supplied in 4 litre packs with the base and curing agent in separate tins ready for mixing.



The components should be mixed for a minimum of 5 minutes to obtain a uniform colour, free from streaks. Mixing should take place using a slow speed drill (300-400rpm) fitted with a **SpECseal** paddle mixer.

Do not part mix.

### Application

Soon after mixing, the **SpECseal 625HD** should be loaded into a **SpEC 600 ml solid barrel gun** using a steel follower plate.



The joint faces should be protected with masking tape to facilitate tooling.

**SpECseal 625** should be poured or gun applied firmly into the joint such that it makes positive contact with the joint faces.

The sealant should then be tooled off to compact it against the joint sides and the masking tape removed immediately after tooling.

## EQUIPMENT CLEANING

Clean equipment with **SpECseal Cleaning Fluid** immediately after the tooling is finished.

## APPLICATION TEMPERATURE RANGE

**Minimum** 0°C  
**Maximum** 90°C

## PACKAGING & YIELD

**SpECseal 625HD** is supplied in 2.5 litre tins .

**SpECseal 625P** is supplied in 4.0 litre tins.

**SpECseal Primer 25** is supplied in one litre 2 part packs.

## USAGE RATES

Length of joint in metres filled/1 litre of **SpECseal 625**

Depth (mm)	Width (mm)				
	10	15	20	25	30
10	10	6.7	5		
15	6.7	4.4	3.3	2.6	2.2
20	5	3.3	2.5	2.0	1.67
25		2.6	2.0	1.6	1.3

## ANCILLARY MATERIALS & EQUIPMENT

**SpECseal Primer 25**

**SpECseal Cleaning Fluid**

**SpECseal paddle mixer**

**SpECseal 600ml solid barrel gun**

**SpECcord closed cell polyethylene back-up cord**

## STORAGE & SHELF LIFE

To maintain the shelf life of 12 months, **SpECseal 625** should be stored in the original sealed containers at temperatures between 5°C and 25°C.

## HEALTH & SAFETY

Contact with skin and eyes should be avoided. It is essential that adequate ventilation is provided and all personnel should avoid inhaling the vapours produced. If working is necessary in confined areas it is strongly recommended that sealed respiratory equipment is utilized.

### Eye Contact

Rinse with copious amounts of clean water and seek medical attention.

### Skin Contact

Rinse with copious amounts of clean water followed by thorough cleaning with soap and water. **DO NOT USE SOLVENTS**

### Ingestion

Seek immediate medical attention. **DO NOT INDUCE VOMITING**

## FLASHPOINT

**SpECseal Primer 25** 48°C

**SpECseal Cleaning Fluid** 34°C

Issue 20: 05/2025

QA-054

Whilst the information and/or specifications given are, to the best of our knowledge, true and accurate, no warranty is given or implied in connection with any recommendations or suggestions made by us, our representatives, agents or distributors as the conditions of use and labour involved are beyond our control.

If it is proven that the product does not perform as described in our TDS, SpEC's liability extends solely to the free replacement of product, once the claim has been accepted after due investigation by SpEC. SpEC will not entertain any claims involving any form of consequential costs or damages such as shipping costs, custom duties, damages to third parties, damages to structures, penalties from delay of a project or any other form of consequential damage.

## SPECIALITY ENGINEERING CHEMICALS

PO Box 61347, Dubai, United Arab Emirates. Telephone: +971 4 883 6662, Fax: +971 4 883 7696

E-mail: [info@spec.ae](mailto:info@spec.ae)

[www.spec.ae](http://www.spec.ae)