

TECHNICAL DATA SHEET

DOLPHIN FIX & SEAL SUPER CLEAR

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PRODUCT DESCRIPTION

Dolphin Fix & Seal super clear is a high quality, crystal clear, neutral, elastic, 1-component adhesive based on Hybrid Polymer.

TECHNICAL PROPERTIES



Properties	Test Method	Specifications
Chemical Base		Hybrid Polymer
Cure Mechanism		Moisture
As Supplied @ 25°C, 50% RH		
Color		Transparent
Consistency	-	Homogeneous paste
Density	ASTM D 1475	1.05 ± 0.02 g/ml
Flow Properties	ASTM C 639	0 (non-sag) mm
Tack Free Time*	23°C, 50% R.H	Approx. 04 minutes
Depth Cure* (24 hrs)	Lab Test	2 mm/24h → 3 mm/24h
As Cured – 7 Days @ 25°C, 50% RH		
Hardness** (Shore A)	ASTM D 2240	38 ± 5 Shore A
Elastic recovery**	ISO 7389	> 75 %
Maximum allowed distortion	-	± 20 %
Maximum Tension**	ISO 37	Ca 1,80 N/mm ²
Elongation at break**	ISO 37	350 %
Elastic Modulus 100% **	ISO 37	Ca. 0,60 N/mm ²
Temperature resistance**	-	-40°C to +90°C
Application Temp.	-	5°C to 35°C

Note:

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates.

** This information relates to fully cured product.

(Information on this data sheet is subject to change without prior notice and should not be used for writing specifications)

TYPICAL USES

- Crystal clear formulation
- Excellent adhesion on nearly all surfaces, even if slightly moist
- Very good mechanical characteristics
- Impervious to mould, contains biocide with fungicidal action
- Suitable for sanitary applications
- Good extrudability even at low temperature
- Free of isocyanates, solvents, halogens, and acids
- Can be painted with water-based system
- Permanently elastic after curing

KEY FEATURES

- All common bonding applications, both in and outdoor
- Sealing joints indoors
- Transparent and elastic bonding in construction and building applications
- Invisible bonding of glass and other transparent materials in indoor applications
- Joints in bathrooms and kitchens



WORLD-CLASS
CHEMICALS

Packaging	Color: Transparent Packaging: 290 ml cartridge, 80 ml tube, 600 ml foil bag
Shelf life	15 months in unopened packing in cool and dry storage place at temperatures between +5°C and +25°C.
Chemical resistance	Good resistance to (salt) water, aliphatic solvents, hydrocarbons, ketones, esters, alcohols, diluted mineral acids and alkalis. Poor resistance to aromatic solvents, concentrates acids and chlorinated hydrocarbons
Substrates	All usual building substrates, glass, treated wood, PVC, plastics, metals, stone, concrete Nature: rigid, clean, dry, or slightly moist, free of dust and grease.
Surface Preparation	Porous surfaces should be primed with Primer 150. Prepare non-porous surfaces with an activator or cleaner (see Technical Data Sheet). While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding or sealing. NOTICE: bonding plastics like PMMA (e.g. Plexi® glass), polycarbonate (e.g., Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Dolphin Fix & Seal super clear is not recommended in these applications. Not suitable for PE, PP, PTFE (e.g., Teflon®), bituminous substrates, copper, or copper-containing materials such as bronze and brass. We recommend a preliminary adhesion and compatibility test on every surface.
Joint Dimensions	Min width for bonding: 1 mm Min width for joints: 5 mm Max width for bonding: 3 mm Max width for joints: 10 mm Min depth for joints: 5 mm
Application Method	Application method: with a manual, accu pneumatic or caulking gun. Cleaning: Clean with DOLPHIN Surface Cleaner or with Dolphin Swipex, immediately after use Cured Fix & seal super clear can only be removed mechanically. Finishing: With a soapy solution or Dolphin Finishing Solution before skinning. Repair: With the same material.
Health and Safety recommendations	Take the usual labor hygiene into account. Consult label and material safety data sheet for more information. Dangerous. Respect the precautions for use.



WORLD-CLASS
CHEMICALS

<p>Remarks</p>	<ul style="list-style-type: none"> • Dolphin Fix & Seal super clear is paintable with water-based paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application • The drying time of alkyd resin-based paints may increase • Dolphin Fix & Seal super clear can be applied to a wide variety of substrates, such as plastics like polycarbonate etc. may differ from manufacturer to manufacturer, we recommended preliminary compatibility test • Dolphin Fix & Seal super clear is not suitable for expansion joints • Do not use in applications where continuous water immersion is possible • Dolphin Fix & Seal super clear can discolor under extreme conditions or after very long UV exposure • Dolphin Fix & Seal super clear cannot be used as a glazing sealant • Not suitable for bonding aquariums • Dolphin Fix & Seal super clear cannot be used on natural stone • The sanitary formula should not replace regular cleaning of the joint. Excessive contamination, deposits or soap remaining will stimulate the development of fungi • A total absence of UV can cause a color change of the sealant • Discoloration due to chemicals, high temperatures, UV-radiation may occur. A change in color does not affect the technical properties of the product • Contact with bitumen, tar or other plasticizer releasing materials such as EPDM, neoprene, butyl, etc. is to be avoided since it can give rise to discoloration and loss of adhesion • When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied
<p>Liability</p>	<p>The content of this technical data sheet is the result of tests, monitoring and experience. It is general in nature and does not constitute any liability. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application</p>

*AMI reserves the right to change the properties of its products without notice.

