

CI/SfB		Yt4
CAW P22		
Uniclass L675:P743		

## Description

FA940 is a one-component, neutral cure, non-sagging elastic silicone adhesive based on alcoxy technology. The product forms an elastic adhesive offering good compatibility to the reverse side of mirrors according to the requirements of DIN EN 1036-1.

## Colours

Transparent

## Packaging

310 ml cartridge (12 per carton)

## Technical Information

Characteristic	Standard	Classification
Chemical Base		Alcoxy, neutral cure silicone
Specific Gravity	DIN 52451-A	~ 1.03 g/m <sup>3</sup>
Resistance to Flow/Non-Sag	DIN EN ISO 7390 (20 mm profile)	0 mm (non-sagging)
Film Formation Time	Internal test at 23°C/50% RH	~ 10 mins.
Curing Time	Internal test at 23°C/50% RH	~ 2.7 mm/1st day
Volume Shrinkage	DIN EN ISO 10563	~ 2%
Tensile Strength at 100% Elongation	DIN EN ISO 8339 method A	~ 0.5 N/mm <sup>2</sup>
Tensile strength at break	DIN EN ISO 8339 method A	~ 0.6 N/mm <sup>2</sup>
Elongation at Break	DIN EN ISO 8339 method A	~ 110%
Elastic Recovery at 60% Elongation	DIN EN ISO 7389 method A	~ 83%
Shore A Hardness	DIN 53505/ISO 868	~ 30
Application Temperature		+5°C to +40°C
Service Temperature (short term)		-40°C to +120°C
Storage	Store in shaded dry conditions between +5°C and +25°C.	
Shelf Life	12 months when stored as recommended in original unopened containers.	

## Necessary Tools

- Cartridge gun

## Protective Equipment

Use in well ventilated conditions and ensure all recommended protective equipment is worn during handling & use of this product. For full recommendation, refer to safety data sheet.

## Preparation

- Substrates must be clean, dust and grease free, stable and dry. To remove grease or dust from glazed tiles, metal or glass surfaces, use AT200 Cleaner. For sensitive substrates (e.g. reverse side of mirrors or powder coated substrates), use the milder cleaner AT115.



## FA940

### Mirror Adhesive



#### Usage / Purpose

FA940 is ideal for bonding mirrors to vertical surfaces and for bonding sensitive plastics (e.g. PMMA and polycarbonate without causing stress cracking).

#### Key Benefits

- Suitable for bonding mirrors to vertical surfaces
- Low odour
- Non-corrosive and compatible with most construction substrates
- Non-staining on natural stone substrates
- Long term resistance to UV, weathering and ageing

- Compatibility with the reverse side protection layer of the mirror must be checked.

### Priming

- Good adhesion is achieved on many substrates without the use of primer, (e.g. cleaned glass, glazed tiles, enamel).
- Primer recommendations for possible pre-treatment are given in the primer table.

### Primer Table

Bricks, Concrete & Stone	
Concrete	AT101
Metals	
Aluminium	+, AT150, AT120
Aluminium Anodised	+, AT150
Aluminium Powder Coating	Test in every case
Galvanised Steel	AT105, AT120
Stainless Steel	AT105, AT120
Copper	+
Brass	+
Iron	AT105, AT120
Glass	
Glass	+
Plastics	
ABS	AT105
GRP Polyester*	+, AT150
Polycarbonate*	AT150
Polypropylene	AT120
Mirror Backing	AT120
Polystyrene	AT150
Acrylic Glass PMMA	AT150
PVC Rigid*	-

+ = good adhesion can normally be expected without primer.  
 Reference numbers (e.g. AT111) show the type of illbruck primer required to improve adhesion.  
 Where there is no result listed according to substrate please contact technical department.  
 \* = Substrates can vary in their surface properties; therefore, adhesion tests prior to use are recommended.

### Application for Mirror Bonding

- The mirror must meet the requirements of DIN EN 1036-1. Prior to application, the protective coating on the reverse face of the mirror should be checked for damage such as scratches. FA940 should only be used on undamaged substrates. Both mirror and surface to be bonded to must be clean and dry.
- Apply FA940 to the back of the mirror in vertical beads with a maximum length of 200 mm at a distance of 200 mm centres. Leave a gap between ends of beads of approximately 50 mm and consolidate when placing the mirror to achieve approximately 10mm wide x 2-3 mm thickness. The mirror must be bonded within the skin forming time indicated. In order to maintain the required 2-3 mm adhesive thickness, suitable spacers can be used if necessary.
- Do not seal around the perimeter of the mirror with FA940 or any other sealant as this will restrict ventilation, restrict the curing of FA940 and could cause a build-up of moisture behind the mirror which could result in mould developing. Moisture can be present in the wall substrate which can also be entrapped and cause problems.
- During the curing process, and for a minimum of 48 hours, the mirror should be supported to prevent slipping or tipping away from the vertical surface. For particularly large or ceiling mounted mirrors, mechanical support must be provided.

### Cleaning

Fresh, uncured adhesive can be removed with AT115, however cured product can only be removed mechanically by means of a suitable tool.

### Please Note

For mirror bonding, the mirror must comply with DIN EN 1036-1. Application in areas or joints with long term exposure to water, vapour or chemicals is not recommended. The product is not suitable for structural bonding. Contact with bituminous or tar containing surfaces should be avoided since this can lead to discolouration of the surface and material. See comments in application for mirror bonding above relating to perimeter sealing.

### Health & Safety Precautions

Safety data sheet must be read and understood before use.



### Technical Service

Tremco CPG UK Limited has a team of experienced Technical Service Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please call Customer Service on 01942 251400.

### Guarantee / Warranty

Tremco CPG UK Limited products are manufactured to rigid standards of quality. Any product which has been applied (a) in

accordance with Tremco CPG UK Limited written instructions and (b) in any application recommended by Tremco CPG UK Limited, but which is proved to be defective, will be replaced free of charge.

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**Tremco CPG UK Limited**  
 Coupland Road  
 Hindley Green, Wigan WN2 4HT  
 United Kingdom  
 T: +44 1942 251400  
 F: +44 1942 251410

info.uk@tremcocpg.com  
 www.tremcocpg.eu