

# Application Advice for Low Temperature Conditions

## Introduction

Instructions for the application of ME500 & ME501 Duo Window Membranes when working in low site temperatures. This technical update is written on the basis of 'FAQ's' which hopefully covers the range of most commonly experienced problems.

Please note individual technical data sheets are available for all products listed on our website : [www.tremco-illbruck.co.uk](http://www.tremco-illbruck.co.uk)

## Products

- ME500 Duo Flexible Window Membrane E & W
- ME501 Duo Window Membrane HD
- SP525 Frame & Façade Sealant & Adhesive
- ME901 & 902 Butyl & Bitumen Primer

## FAQ's

- Q What is the minimum temperature at which the above adhesives and primer can be used?
- A +5°C for the adhesive (SP525) & -5°C for the primer (ME901 & ME902) are the recommended minimum temperatures.
- Q What happens if working at lower than the minimum?
- A Below 10°C, adhesion of the butyl self-adhesive strip to the structure and acrylic self-adhesive strip to frame may be impaired and the primer is likely to be required. The condition of the construction or frame substrates must also be considered as at below 3°C, frost particles and condensation can occur which will affect and impair the adhesion. The butyl adhesive will increase in hardness at low temperatures resulting in application difficulties. Also, the curing of the SP525 sealant/adhesive will slow down and could actually stop during prolonged cold weather or repeated temperature cycling in the -5 to +5°C region over night/day periods. Prolonged low temperature cycling could affect actual final adhesion.
- Q Can the Butyl & Bitumen Primer be used to improve the bond of the acrylic and butyl self-adhesive strips?
- A Yes, apply the primer and leave for 15 – 20 minutes then apply the adhesive strip(s) to the primer. This would also be useful on damp (not wet) or slightly dusty surfaces. Dry surface with clean rags or remove dust with a brush if necessary.
- Q Can the substrates be warmed up locally to aid adhesion?
- A If the surface is heated to min. +5°C and this is maintained for approx 24 hours, the adhesive will cure more rapidly. This is likely to be difficult to achieve however.
- Q What precautions are necessary in terms of storage?
- A When using the products in cold weather, do not store at less than +10°C. Storing at higher temperatures will decrease the viscosity and in the case of the butyl strip this will be softer, making application easier.

## Technical Update

### illbruck ME500 Duo Flexible and ME501 Duo HD Window Membranes

- Generally avoid working in temperatures below 5°C.
- Beware of frost or condensation on construction or frame surfaces.
- Store materials at 10°C minimum prior to use.
- Use illbruck ME901 (Brushable) or illbruck ME902 (Aerosol spray) Butyl & Bitumen Primer to aid bonding of the self-adhesive strips. Necessity may be limited to the butyl strip to bond to the structural elements.
- For specific technical advice or site support, please contact our sales office on 01942 251400.



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