



TECHNICAL LEAFLET

SUNSTAR CHEMICAL (THAILAND) CO., LTD.

One-part Moisture Cure Urethane Sealant PENGUIN CEMENT # 555

Penguin Cement # 555 is a one-part moisture cured urethane-sealing compound designed to directly bond automotive/**bus windshields** and backbites onto the body

a). Characteristics

1. Meets FMVSS212 and 216
2. Fast cure at room temperature
3. High bonding strength and good bonding durability with use of body primer 435-98 and glass primer 435-40 (provided)

b). Applications

1. Flow gun will be used with high pressure drum pump at 59:1 ratio
2. **# 555** is high moisture sensitive; therefore pumping system should be entirely isolated from moisture.
3. Proper primers, 435-98 for painted window opening and 435-40 for glass, should be used

c). Physical Properties

Appearance	: Black Paste
Viscosity (20°C)	: 70-120 Pa.s
Specific Gravity	: 1.30
Non-Volatile Content (%)	: >95.0 %
Sagging	: 0
Tensile Strength (kg/cm ²)	: 50
Tear Strength (kg/cm ²)	: 28
Hardness (160°C, 15 min's)	: 50
Elongation	: 550 %
Cure rate tack-free time (min)	
5°C, 50% RH	: 150
20°C, 65% RH	: 40
35°C, 90% RH	: 9
Bonding Strength in shear (kg/cm ²)	
Initial (28°C/ 7 days)	: 42
Heat Aging 90°C/ 14 days	: 48
Water Immersion 40°C/14 days	: 43

Sunshine Weather-o-meter (1000hrs): 45

d). Usage

Use high-pressure pump and extrude with flow gun.

e). Precautions

1. Keep at cool and dark place
2. In case of skin contact, wash thoroughly with soap and water
3. In case of eye contact, wash out with water for more than 15 mins and immediately get medical care
4. If swallowed, immediately call a doctor

f). Packaging

Cartridge 333ml