

# TWI-600™ DATA SHEET

## POLYSULFIDE, SYNTHETIC-RUBBER, METAL & WOODEN DECK CAULKING COMPOUND

(Conforms To and Exceeds Specifications: MIL-C-18255D -- Ships)

**TWI-600™** is an elastomeric, two-component, polysulfide, synthetic-rubber based, permanent caulking sealant, specifically designed for physically sealing the joints of wooden, concrete or steel, deck planking & plates.

**TWI-600™** exhibits long service life, extreme elasticity, high adhesion and reliable resistance to extreme weather, UV-light, aging, saltwater, brackish & freshwater, electrolysis, petro-chemicals, aviation, marine and diesel fuels, temperature extremes, vibration, normal structural movement, and topical vehicular traffic.

**TWI-600™** cures in place, at ambient temperatures, to a firm, resilient, elastomeric, permanent seal; effectively bonding to primed wood (**TWI-601™ Primer**), metal, or concrete, as used in normal marine plank or plate deck construction.

**TWI-600™** possesses excellent resilience and tensile characteristics over a wide temperature range; will not peel, crack or degrade, even after years of exposure to harsh environments.

**TWI-600™** is Self-Leveling, and can be easily poured or injected into horizontal (deck) joint seams; A companion sealant, **TWI-500™ (NS)** {See separate Data sheet} is **Non-Sagging**, for vertical (bulkhead) and overhead joints.

### SURFACE PREPARATION

Wooden decking to be sealed should be freshly sanded clean, dry, and free of oil, old caulking compound and other contaminants. The base of the seams should be caulked with standard caulking cotton, when the width of the seam is reduced by plank expansion. It is essential that all wooden surfaces be primed with **TWI-601 Primer™** prior to sealing with **TWI-600™ Deck Caulking Compound**.

### PRIMING

**TWI-601 Primer™** consists of two parts (**A & B**) which must be mixed in a ratio of 100:6 (by weight) prior to application. The mixture should be used within 72-hours after mixing. Two coats of mixed **TWI-601 Primer™** should be brushed on all wooden surfaces to be caulked, allowing 45-minutes between coats. Allow a minimum of 16-hours dry time at 75° before applying **TWI-600™ Deck Caulking Compound**.

### MIXING INSTRUCTIONS

10 parts of **TWI-600™ Base Compound** is mixed with 1 part **TWI-600™ Curing Agent** (10:1 by weight), until completely uniform, and no traces of unmixed base compound or curing agent are visible. Mixing should be done at LOW speed to avoid excessive entrapment of air. Optimum mixing temperature is 75°F ± 5°. Higher temps reduce application life.

### APPLICATION

**TWI-600™** may be applied using a standard or air-operated caulking gun. During application, the caulking gun nozzle tip is drawn along the bottom of the joint seam to completely displace all air with the caulk bead. Advance at a speed which will allow a bead to completely fill the joint.

### TOOL & EQUIPMENT CLEANING

Tools for applying **TWI-600™** may be cleaned using Acetone, M.E.K., Toluene or chlorinated solvent, immediately after use or before material cures.

### PACKAGING

**TWI-600™** and **TWI-601 Primer™** are packaged in 1-gallon cans, 5-gallon pails and 55-gallon drums. Custom packaging is available.

### PHYSICAL PROPERTIES

#### APPLICATION

Base Compound Color ..... Black  
Curing Agent Color ..... Brown Paste  
Mixing Ratio (by weight) ..... 10:1  
Solid Content ..... 96%  
Viscosity ..... 400 poise  
Usable "Pot" Life ..... @ 3 Hours at 75°F/50% RH  
Tack Free Time ..... @ 20 Hours at 75°F/50% RH  
Cure Time ..... @ 72 Hours at 75°F/50% RH

#### PERFORMANCE

Color ..... Black  
Hardness (Rex) ..... 45  
Shrinkage ..... 1%  
Swell (in 100% ISO Octane) ..... 1%  
High Temperature Resistance ..... +250°F  
Low Temperature Flexibility ..... -65°F  
Tensile Strength & Ultimate Elongation  
Initial at 75°F ..... 500 psi/900%  
After 72-hours at 212°F ..... 520 psi/900%

#### Adhesion Strength Under Tension

(Tests conducted on Douglas Fir and Teakwood primed with TWI-601 Primer™)  
100% Cohesive Break Strength/Ultimate Elongation  
Initial at 75°F ..... 250 psi/450%  
After 7 Days at 160°F ..... 230 psi/420%  
After 30 Days (Salt Water Immersion) 220 psi/420%

### **TradeWinds International, Inc.**

1374½ E. Colorado Street, Glendale CA 91205

v: 818-500-1921 ☎ f: 818-500-1474

toll-free: 888-463-3003 ☎ e-mail: tradewinds@usa.com