



WKT Sealing Compound

General Information

(1) During the application of WKT Sealing Compound the surrounding temperature should be between +5 °C and +40 °C. Lower temperatures lead to a prolonged curing time of both the sealant and especially of the primer, thus increasing the risk of soiling the joint. Higher temperatures – as may be caused by direct, intense sunlight – can interfere with the curing of both the primer and the sealant.

(2) WKT Sealing Compound owes its extraordinary longevity and elasticity among other factors to a silicone component. On surfaces which are to be painted after the sealing work, this may lead to disturbances in the performance of the paint. Therefore special attention should be paid to cleanness while working with WKT Sealing Compound (e.g. by using a vacuum cleaner when sanding). If possible, any painting work on adjoining surfaces should be completed prior to the sealing work on the wooden deck.

(3) It is very important to make sure that during the entire caulking work the wood is kept dry!

Preparatory work

(1) Prior to the caulking work, the wooden deck should be sanded well, so that the planks all lie on one level and show no steps. The same applies to the bottom of the joint, as far as possible.

(2) Each wooden plank should be sunk preferably along both sides by half of the desired joint width, so that the bottom joint meets in the middle (please see drawing).

(3) The choice of the optimum width and depth of the joint depends upon various factors, e.g. width of the planks and type of wood – if uncertain, please consult us.

(4) Any loose bits, e.g. wood shavings or splinters, especially on the joints' flanks must be removed. The wood in the joint area must be dry and clean. It must not be oiled before the sealing work has been completed.

(5) In most cases it is advisable for technical reasons to obtain adhesion only to the flanks of the joints. This can be achieved by placing a strip of bond-breaking tape on the bottom of the joint. The tape should cover the bottom of the joint completely and must not stand up against the flanks of the joint.

Priming with WKT Primer P1

(1) WKT Primer P1 serves to enhance the adhesion of WKT Sealing Compound to the wooden joint (and to many other surfaces, e.g. GRP, epoxy, aluminium)*. Steel/iron surfaces must be coated with an anti-corrosive paint, which must be allowed to dry completely before WKT Primer P1 is applied.

(2) The joint's flanks must be covered thoroughly with WKT Primer P1. To ensure this, we recommend to apply the primer twice allowing each coat to dry

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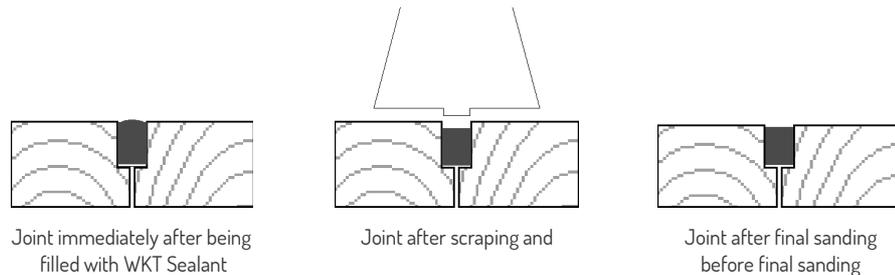


completely. Depending on the surrounding temperature, this will take at least one hour for the first and at least 4 hours for the final coating.

* For stainless steel and brass we recommend our WKT Primer P2 (also suitable for other metals); and for PUR, PVC and many other synthetics our WKT Primer P3.

Application of WKT Sealing Compound

- (1) Remove the ring-pull lid at the bottom of the cartridge.
- (2) Pierce the membrane of the cartridge's nipple.
- (3) Screw the nozzle onto the cartridge. Cut the tip of the nozzle diagonally according to the width of the joint.
- (4) Place the cartridge into a manual or pneumatic gun and extrude the sealant gently, filling the joint from bottom to surface.
- (5) Avoid any impurities through WKT Sealing Compound and Primer P1 on surfaces which are to be painted later on.
- (6) For economical and especially for technical reasons, the joints should be scraped with a special spatula within 10 minutes after application of WKT Sealing Compound (please see drawing). Thus the joint is controlled once more and any faults (e.g. bubbles) may be corrected. At the same time a slightly indented surface of the sealing compound is achieved, which protects the caulking from mechanical stress, such as caused by a sanding machine. If the work is done on a clean deck, the material that collects on the spatula may also be used, for instance for the short joints. As this material has already been in contact with air and quickly begins to form a skin, it is essential to use it immediately.



Curing of WKT Sealing Compound

Very soon after its application, WKT Sealing Compound begins to vulcanize (artificial and extreme heat do not accelerate but rather interfere with this process). As vulcanization is primarily effected through air, the surface of the joint must not be sealed off – e.g. by an oil film – too soon. Also, the joints must not be exposed to mechanical stress before the vulcanization process is completed (4 to 7 days, depending on the depth of the joint).

Shelf life

Under cool and dry conditions: 12 months minimum from date of delivery.

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WKT Sealing Compound

The reliable classic for durable caulking of wooden decks

- » extremely non-ageing and highly resistant to ozone, UV, sea water, heat and cold
- » highly flexible even at very low temperatures (e.g. during winter storage)
- » flows even into narrow joints without enclosing any bubbles
- » cures practically without shrinkage and does not produce any bubbles
- » suitable for all deck repairs/refits – irrespective of the type of caulking originally used
- » free of solvents, heavy metals, isocyanates and oximes
- » Type H: self levelling, for horizontal seams, esp. for wooden deck joints
- » Type S: non-sag, for vertical and for sloping seams, e.g. glazing seams

Technical Properties

Consistency	Type H: self-levelling Type S: thixotropic
Colour	black
Density	1,5 g/cm ³
Shore-A (DIN 53 505)	13
Application temperature	+5 °C to +40 °C
Skin-forming time	appr. 20 minutes
Curing speed	3 mm in 24 h / > 4 mm in 48 h
Shrinkage	< 3 %
Curing speed	appr. 2 mm in the first 24 hours
Modulus (100 %)	ca. 0,24 N/mm ²
Elongation at break	> 400 %
Lap-shear strength	appr. 0.8 N/mm ²
Temperature resistance	-50 °C to +180 °C
Chemical resistance	resistant to greases, oils, diluted alkalics, acids, and to common cleaning agents

Unit

310 ml cartridge, 600 ml sausage (Type H only)

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Under moderate storage conditions: minimum 12 months.

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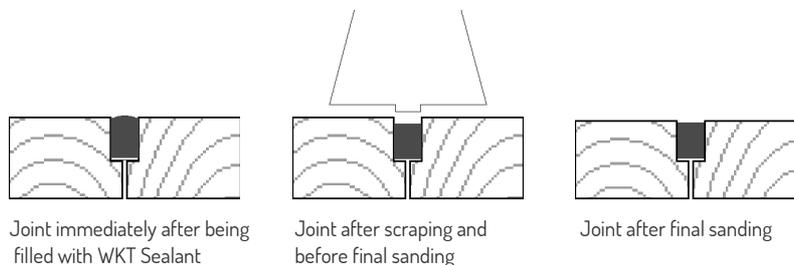
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WKT Primers

WKT Primer P1

WKT Primer P1 is the standard primer for WKT Sealing Compound. It provides reliable adhesion between WKT and various substrates, e.g. wood, aluminium, cooper, zinc, epoxy-resin, polyamide, and polyester (e.g. GRP).

Technical Data

Curing time (at + 20 °C)	on wood: 4 h minimum general: 60 min. minimum
Solvents	acetone, toluene
Density	0,9 g/cm ³
Colour	transparent
Flash point	- 18 °C
Basis	silicon resin

WKT-Primer P2

WKT-Primer P2 is a coupling agent for the preparatory treatment of stainless steel and of various other metals prior to sealing works using WKT Sealing Compound. P2 is also suitable for priming certain synthetics, e.g. polyamide, polyester, polyurethane.

Technical Data

Curing time (at + 20 °C)	60 min. minimum
Solvents	aliphatic hydrocarbons
Density	0,75 g/cm ³
Colour	transparent
Flash point	+ 9 °C
Basis	silicon resin



WKT-Primer EP90

WKT-Primer EP90 is a 2-part anti-corrosive prime coat for untreated steel and iron. It combines secure adhesion with a reliable corrosion protection. Mixing ration: 4:1 (volume).

Technical Data

Curing time (at + 20 °C)	24 hours minimum	
Solvents	xylene, ethyl benzene, butanoll	
Density	Comp. A	1,4 g/cm ³
	Comp. B	0,95 g/cm ³
Colour	Comp. A	red
	Comp. B	transparent
Flash point	Comp. A	+ 26 °C
	Comp. B	+ 25 °C
Basis	epoxy resin	

General recommendations

The consumption of WKT Primers is approx. 30–60 ml per 310 ml cartridge WKT.

For the application of WKT Primers the surrounding temperatures should range between + 5 °C and + 35 °C.

Do not apply WKT Primers in direct sunlight or on hot surfaces.

The substratum must be free of dust, dirt, wax, oil, etc. However, there is no need to degrease wooden surfaces prior to priming works as long as the wood has not been oiled before or is of an extremely oily or resinous type.

On porous materials – especially on wood – we recommend applying WKT Primers twice to ensure that the surfaces are completely coated.

The drying time of a particular primer depends strongly on the surrounding temperature. Therefore, to ensure that the primer is completely dry and fully cured, we recommend to wait longer than the minimum time given above. This applies especially for absorbent surfaces such as wood, which require a drying time of at least four hours for the final coating.

Shelf Life

6 months minimum. in dry and cool conditions:

EP90: 12 months minimum in dry and cool conditions.

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