



PIB PRIMARY SEALANT

EVO  
Stik™

2000  
PRIMARY SEALANT

**PRODUCT** ■ EvoStik™ 2000 is a compounded polyisobutylene hot melt sealant.

**PRODUCT DESCRIPTION** ■ EvoStik 2000 provides excellent adhesion to glass, aluminum, galvanized steel and metal and plastic corner keys. EvoStik 2000 has a very low moisture vapor transmission rate, very low gas permeability, and acts as a thermal break. EvoStik 2000 is easy to apply by standard dispensing equipment. No cleaning or purging of dispensing equipment is required. EvoStik 2000 can also be used as a spacer bar adhesive.



**BASIC USES** ■ EvoStik 2000 is a compounded polyisobutylene hot melt sealant specifically formulated for use in the production of dual seal insulating glass units. It should always be used in conjunction with a suitable secondary seal, such as EdgeStik 3190; the resulting sealed units are then capable of complying with the test requirements laid down in ASTM E774-81 and CAN 2-12.8-M76.

**PRODUCT CHARACTERISTICS**

Color:	Black
Form:	Rubbery solid
Constitution:	Compounded polyisobutylene rubber containing no volatile materials
Packaging:	7 kg cylindrical slugs

**TYPICAL PERFORMANCE**

Recommended Application Temperature:	120°C-150°C or sufficient to produce a consistent even coating
Recommended Coating Weight:	2-4 g per linear meter on both sides of the spacer bar, depending upon spacer profile. If using with hot melt, consult Bostik Technical Services
Moisture Vapor Transmission Weight:	<0.01 g/m <sup>2</sup> per day for a 2mm film at 25°C 100% RH. (ASTM method E96)
Shore "A" Hardness:	20
Relative Density:	1.2 g/cm <sup>3</sup>
Performance:	Exhibits an extremely low moisture vapor transmission rate and excellent adhesion to glass, aluminum and galvanized steel spacer bar

**STORAGE/SHELF LIFE** ■ EvoStik 2000 Primary Seal should be stored in unopened containers in a dry place within the temperature range 5°C to 25°C. Under these conditions the usable life will be at least 12 months from the date of manufacture.

**PREPARATION** ■ EvoStik 2000 exhibits excellent adhesion to cut, ground or polished glass and aluminum and galvanized steel spacer bar. It is essential that all surfaces are clean and dry.

**APPLICATION** ■ EvoStik 2000 is suitable for use on all types of primary seal application equipment. Due to inherent minor differences between machinery, optimum performance is best attained by assessing the coating weight per linear meter on each side of the spacer bar rather than by specific temperature and pressure settings. The coating weight should be within 2 to 4 g per linear meter on each side with the front and back coating weight as close to each other as possible (no greater than 0.5 g difference).

The spacer bar profile also determines the optimum coating weight achievable. A straight-sided spacer bar will require a lower coating weight (2 to 3 g/m) than a spacer bar specifically designed for dual seal systems (see diagram). This type of spacer can accommodate a higher coating weight.



*Straight-sided spacer bar*



*Dual-seal spacer bar*

If the coating weight is below 2 g/m, then incomplete wetting of the glass can result and minor coating imperfections will be exacerbated. If the coating weight is above 4 g/m, then not only could an excess of primary seal exude into the unit cavity, but also the degree of pressing out could be adversely affected leading to inadequate adhesion and/or excessive unit thickness.

It is important that a continuous, even coating is achieved and that any excess primary seal is pushed into the gap where the corner key locates into the spacer. A complete primary seal of the unit is only attained when corner keys are plugged or a bent spacer bar system used. Avoid touching the extruded primary seal as this may adversely affect the wetting out and adhesion of the compressed primary seal. Further advice on particular aspects of application can be obtained from our Technical Service Department.

#### **HEALTH AND SAFETY PRECAUTIONS** ■

Before embarking on any work involving EvoStik 2000, the Safety Data Sheet should be carefully studied by those carrying out the work.

For full precautions in use, first aid instructions and spillage and disposal instructions, see separate Safety Data Sheet.

**IMPORTANT NOTICE** • The information given and recommendations made herein are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and equipment used for application. Any change in any of these variables can affect the product's performance. Buyers are advised to make their own tests to determine whether the product is suitable for their purposes under their own operating conditions. Bostik accepts no responsibility for the performance of the product for any particular customer or any particular use. Bostik does not warrant the product's suitability for any particular application. The product is sold only pursuant to Bostik's terms and conditions of sale and only subject to the limited warranty contained therein. Bostik sells the product without warranty as to merchantability and fitness for a particular purpose, any warranty from course of dealing or usage of trade, or any other warranty, expressed or implied, and buyers and users assume all responsibility and liability for loss or damage arising from the handling and use of Bostik's products. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent. Unless otherwise agreed to in writing, the buyer's sole remedy for noncompliance with any warranty shall be the replacement of the product or refund of the buyer's purchase price. In no case will Bostik be liable for indirect, consequential, incidental, economic or other similar damages.

#### **MANUFACTURER**

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