



Glazing

TRANSPARENT ABOUT GLAZING





BOSTIK, SMART ADHESIVES

The new logo and the new house style with the characteristic green gecko is more than just a visual appearance. "Smart Adhesives" is a reflection of our positioning with regard to the development of smart and innovative sealing and bonding solutions that are safe, flexible and efficient.

We develop innovative sealing and bonding solutions that, whatever is constructed, connected or built, are smarter and can adjust better to the forces and challenges in our daily life.

THE GECKO - INSPIRING ADHESION

For centuries, scientists have been inspired by geckos because of their unique bonding mechanism. They can stick to almost any surface, can climb super-fast against smooth polished glass and can easily carry their entire body weight with just one toe.

The Bostik gecko is flexible, easy to adapt to environments, is open to new situations and is courageous. It symbolizes Bostik's smart and innovative sealing and bonding solutions for the challenges which today's market faces.

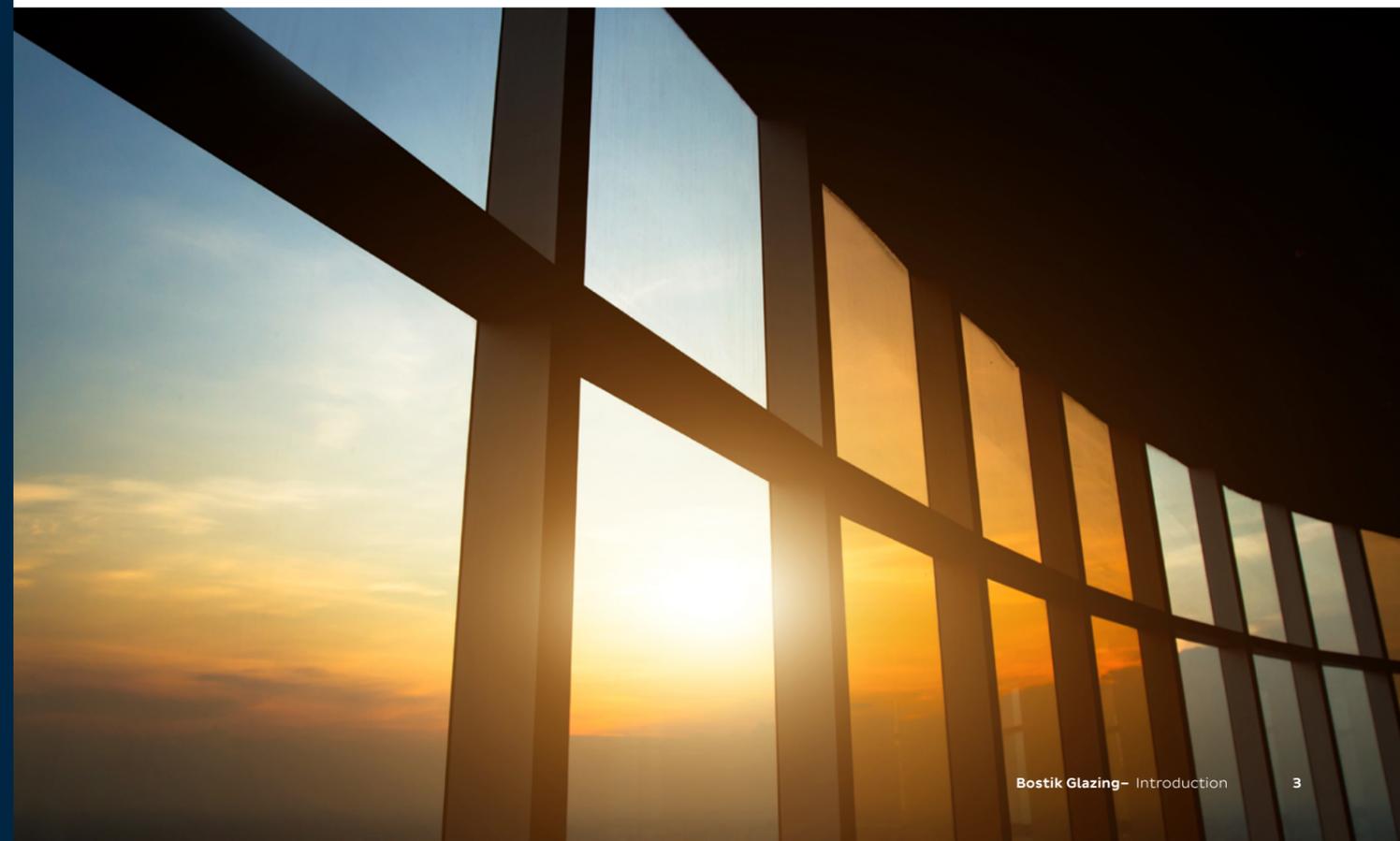
1. Introduction

The basic function of the building envelope is to protect us and our loved ones, from the surrounding environment. This fundamental need for shelter is a concept that is as old as the recorded history of mankind. Where it all started with only walls, a roof and an entrance, much later doors and windows with glass were included as well. From a house to an imposing building, glass is not only an efficient building material to allow daylight to the interior space, but it is also providing weather protection. With today's high-end technological solutions, glass can even provide a high insulation and/or can assure a free environmental friendly heat source for the inside areas. Glass is simply indispensable in our houses and buildings.

By the development of the float glass process in the 1950s, glass is nowadays produced in a fast economical mass. But glass itself can be used and installed in a wide variety of systems. Most common within construction

are of course our windows and skylights. Rapidly growing are the curtain wall and so called structural glazing systems. Nowadays glass is also a great contributor to energy efficient houses and buildings. High performance insulating glazing, double and even triple glazing with warm edge spacers, are becoming more and more a building standard.

Important to understand is when high efficient building elements are put together in the building, that the connection joint needs also special attention. The connection between these high efficient building elements, also need to be weatherproof, airtight and if possible contribute to the lambda-values of the adjacent elements. In short, efficient and/or high performance building elements, also need high performance sealants and adhesives. This is why Bostik is continuously focusing on the development of high end products with the emphasis on durability and sustainability.





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2. Wet and dry glazing

Wet and dry glazing systems

Since glass itself is impervious to water penetration, the waterproofing performance is determined by the glazing method and the way of installation. Waterproofing glazing systems can be executed by so called wet glazing and dry glazing solutions.

Wet glazing means to apply a wet sealant out of a cartridge or aluminum sausages with a professional caulking gun as a waterproofing seal.

Dry glazing systems use pre-formed solid rubber glazing seals. These pre-formed solid rubber glazing seals are extruded in a factory and packed on rolls.

In some occasions wet and dry systems can be used in combination. Both systems do come with advantages and disadvantages. In the table below, we will explain them.

Glazing system	Advantages	Disadvantages
Wet glazing: Applying a sealant over backer rod or glazing tape	High resistance to water and air penetration, Adheres perfectly to glass and adjacent materials and it generates an uninterrupted seal	Requires exterior access for installation, maintenance and glass removal
	Protects the unit edges and laminated glass from water and premature deterioration	Workmanship dependent (surface preparation, weather, etc.)
	Reduces glass movement, "walk", as the sealant acts like an adhesive	Can costs more than dry glazing
	UV resistant	
Dry Glazing: Installing a pre-formed solid rubber glazing seals	Can be installed from the interior	Not as water and airtight
	Less dependent workmanship and weather	can be affected by UV over a longer period of time
		Pre-formed solid rubber glazing seals can shrink, creating openings for water and air penetration
	Generally less costly than wet glazing	Pre-formed solid rubber glazing seals can roll into pocket and place uneven stress on glass
	Glass can "walk"	

3. Certification

CE Classification (Europe)

In today's world globalization and harmonization have become common and familiar terms. This is also true at building standards and regulations. Within Bostik we embrace this movement and strive for a globalized standard which provides transparency and simplicity in sealing and bonding.

ASTM (Americas)

The ASTM C920-18 'Standard Specification for Elastomeric Joint Sealants' covers the properties of a cured single- or multicomponent cold-applied elastomeric joint sealant for sealing, caulking, or glazing operations on buildings, plazas, and decks for vehicular or pedestrian use, and types of construction other than highway, airfield pavements and bridges. A sealant qualifying under this specification shall be classified as to type, grade and class.

GEV-EMICODE EC1 Plus

EMICODE® is a protected product classification system and at the same time an Eco label. Installation materials, adhesives and construction materials are submitted to a strict certification procedure where the quantity of emitted volatile organic compounds

(VOC) is examined. When products come with the EC1 Plus certification, they can be easily adapted in the BREAAAM and LEED schemes. The GEV-EMICODE comes with a variety of classifications from 'EC' till the highest achievable 'EC1 Plus'.

M1 Certification

Various chemicals are emitted from building and interior decoration materials into indoor air. The classification presents emission requirements for the building materials, fixtures and furniture, with and without padding or textile coverings used in ordinary work spaces and residences with respect to good indoor air quality. M1 stands for low emissions.

A+ Certification

A+ is a compulsory French VOC emissions labelling of construction products installed indoors, based on emission testing. This regulation foresees that any covered product placed on the market has to be labelled with emission classes based on their emissions after 28 days, as tested with ISO 16000 and calculated for European reference room. The same holds true for EMICODE, GUT and Blue Angel.

4. The route to a perfect glazing joint

What is a sealant?

A sealant is a soft, pliable material that is used to seal cracks or joints where structural strength is not required. In technical terms, a sealant has a Shore A hardness below 40 and an E-module maximum of 0.7N/mm².

These soft materials can accommodate building and civil engineering structure movement and assure a durable, sustainable and above all functional tightness throughout their operational life.

Sealants need to meet market requirements depending on function and location of the joint. The following information gives more detail on the ASTM and CE Marking required by sealants for use in façade, glazing, sanitary and pedestrian walkway applications.

SEALANT TYPES FOR GLAZING

Silicone sealants¹

Silicone sealants are construction sealants with excellent resistance to weathering and ageing. They are used to seal all types of construction joints. Silicone sealants cure by absorbing moisture from the air to form a silicone rubber seal capable of extreme movement ($\pm 25\%$ for CE Marking and 50% for ASTM).

Silicone advantages¹

- Excellent extensibility
- Excellent recovery
- Extreme resistance to weathering (including UV) and ageing
- Easily applied at all temperatures
- Good to excellent adhesion

PRODUCT	Single sheet glass	Insulating glass top seal	Monumental glass	Laminated (safety) glass	Fire retardant glass	Weather sealing	PMMA & PC	Paintable glass sealing
H950 GLASS'N'SEAL PUTTY PREMIUM			●					●
S950 GLASS'N'SEAL PUTTY SILICONE			●					
S740 GLASS'N'SEAL SILICONE N	●	●				●		
S780 GLASS'N'SEAL PREMIUM	●	●		●		●	●	
H775 GLASS'N'SEAL PREMIUM PAINTABLE	●	●		●				●
S570 GLASS'N'SEAL SILICONE A	●	●		●				
H565 GLASS'N'SEAL MULTI PURPOSE	●	●						
S735 SEAL'N'FLEX CURTAIN WALL	●	●				●		
S320 SEAL'N'FLEX PERIMETER	●	●		●				
S350 SEAL'N'FLEX FRAME SEALANT	●	●						
S340 SEAL'N'FLEX UNIVERSAL	●	●						

Hybrids

Hybrid is the fast growing elastic sealant and adhesive technology. It combines a wide adhesion spectrum, paintability, bubble-free curing and applicability to damp substrates. In addition, hybrids products contain no isocyanates.

Hybrid advantages

- Excellent recovery
- Extreme resistance to weathering (including UV) and ageing
- Good adhesion to most substrates
- Hydrophilic; even adhesion to damp surfaces
- High mechanical resistance
- Human friendly to use
- Paintable²

¹ Compatibility of the edge seals of insulated glass with glazing sealants cannot be guaranteed by Bostik, as the composition of the edge seals can be changed by the glass manufacturer without notice. Any advice concerning the compatibility of glazing sealants to the edge seals of insulation glass is based on experience and therefore not guaranteed.

² Paintability is tested with water based and synthetic paints. Paintability can differ by recipe. Bostik recommends testing compatibility with paint prior to application. When a sealant will be painted (not necessary), we recommend slightly sanding the sealant and the junction surfaces prior to use with Scotch-Brite. For the best results, we recommend painting a few days after application

5. Harmonized Building Standards



CE Classification (Europe)

In today's world, globalization and harmonization become commonly used and familiar terms. This is also true at building standards and regulations. Within Bostik we embrace this movement and strive for a globalized standard which provide transparency and simplicity in sealing and bonding.

One of the most familiar, and for Europe mandatory standards in the sealant industry is the CE Classification, or also known as the standard EN 15651.

EN 15651-2 Sealants for Glazing

EN 15651-2 sets out definitions and requirements for non-structural, elastic joint sealants for sealing glazing in buildings. Included are glazing joints at an angle of 7° to the horizontal. The areas in which these joint sealants are used are:

- Glass to glass
- Glass to frames
- Glass to porous carrier materials

'Class' abbreviations mean:

- LM refers to a 'softer' sealant and stand for low modulus. Low modulus performing sealants can withstand a movement capability of 20 and 25%.
- HM refers to a 'harder' sealants and stand for high modulus. High modulus performing sealants can withstand a movement capability of 20 and 25%.
- CC for cold(er) climate applications.

Application	Movement capability	Class	Elastic recovery	Loss of volume
Type G	± 25%	25LM	≥70%	≤10%
		25HM	≥70%	≤10%
	± 20%	20LM	≥60%	≤10%
		20HM	≤60%	≤10%

ASTM INTERNATIONAL

The ASTM C920-18 'Standard Specification for Elastomeric Joint Sealants' covers the properties of a cured single- or multicomponent cold-applied elastomeric joint sealant for sealing, caulking, or glazing operations on buildings, plazas, and decks for vehicular or pedestrian use, and types of construction other than highway and airfield pavements and bridges. A sealant qualifying under this specification shall be classified as to type, grade and class.

Type

Type S products are those supplied in pre-packaged cartridges or other forms in which no jobsite mixing is required.

Grade

Grade NS products are suitable for installation in joints in vertical surfaces without sagging at temperatures between 40 and 122 deg. F (5 and 50°C).

Use

Uses M, G, and A refer to sealants that remain adhered, within given parameters, to various standard specimens including, respectively, mortar (M), glass (G), and aluminum (A) when tested for cyclic movement and adhesion-in-peel. It is important to understand that the specimens related to these designations are not those specified for the Project but those that comply with restrictive material specifications in the ASTM test methods.

Application	Use	Class	Movement capability
Type S Single Comp.	G Glass	100/50	100% expansion / 50% compression
		50	50% expansion / 50% compression
Type NS Single Comp.	A Alu- minum	35	35% expansion / 35% compression
		25	25% expansion / 25% compression
		12,5	12,5% expansion / 12,5% compression

6. Application areas



**BOSTIK H950
GLASS'N'SEAL PUTTY PREMIUM**
Durable elastic paintable hybrid glazing putty
See page 15 for more details.



**BOSTIK H565
GLASS'N'SEAL MULTI PURPOSE**
High modulus glazing and multi purpose hybrid sealant
See page 18 for more details.



**BOSTIK S740
GLASS'N'SEAL SILICONE N**
Premium matt silicone sealant for glazing and facade joints
See page 16 for more details.



BOSTIK S950 GLASS'N'SEAL PUTTY SILICONE
Durable elastic silicone glazing putty
See page 15 for more details.



**BOSTIK H775
GLASS'N'SEAL PREMIUM PAINTABLE**
High quality glazing & facade sealant
See page 17 for more details.



**BOSTIK S570
GLASS'N'SEAL SILICONE A**
Low modulus acetoxy glazing sealant
See page 17 for more details.



**BOSTIK S780
GLASS'N'SEAL PREMIUM**
Premium grade neutral sealant for glazing & weather sealing
See page 16 for more details.

7. Portfolio

BOSTIK H950 GLASS'N'SEAL PUTTY PREMIUM

Durable elastic paintable hybrid glazing putty

Product description

BOSTIK H950 GLASS'N'SEAL PUTTY PREMIUM is an alternative to the standard glazing linseed oil based putties. BOSTIK H950 GLASS'N'SEAL PUTTY PREMIUM is a hybrid based technology which cures under influence of humidity to form a durable elastic rubber.

Most important characteristics

- Also suitable for stained glass and renovation glass
- Excellent tooling properties
- Fast paintable with water based and synthetic paints
- Adheres perfectly without primer on most, even damp, surfaces
- Permanently elastic
- No shrinkage and bubble free
- Free of isocyanates and solvents



Packaging	Packed per	Colour
290 ml cartridge	12 cartridges per box	white, grey and black

BOSTIK S950 GLASS'N'SEAL PUTTY SILICONE

Durable elastic silicone glazing putty

Product description

BOSTIK S950 GLASS'N'SEAL PUTTY SILICONE is an alternative to the standard glazing putties. BOSTIK S950 GLASS'N'SEAL PUTTY SILICONE is a silicone based technology which cures under influence of humidity to form a durable elastic rubber.

Most important characteristics

- Also suitable for stained glass and renovation glass
- Excellent tooling properties
- Permanently elastic
- High mechanical resistance
- Excellent adhesion to glass and most painted surfaces
- Fast drying
- High UV and weather resistance



Packaging	Packed per	Colour
300 ml cartridge	12 cartridges per box	white, grey and black





BOSTIK S780 GLASS'N'SEAL PREMIUM

Premium grade neutral silicone sealant for glazing & weather sealing

Product description

BOSTIK S780 GLASS'N'SEAL PREMIUM is a low modulus matt finish durable and neutral curing silicone for all kind of glazing application.

Most important characteristics

- Suitable for weather sealing in structural glazing projects
- Compatible with silicone secondary sealants
- Neutral curing system
- Matt finish
- Slow skin formation, perfect toolability
- Suitable for PMMA and PC, no stress cracking
- Excellent UV, water and weather resistant

Certificates

- EN 15651-1: F-EXT-INT-CC 25LM
- EN 15651-2: G-CC 25LM
- A+ French VOC Regulation

Packaging	Packed per	Colour
300 ml cartridge	12 cartridges per box	white, grey and black
600 ml foil pack	12 foil packs per box	white, grey and black

BOSTIK H775 GLASS'N'SEAL PREMIUM PAINTABLE

High quality paintable glazing and facade sealant

Product description

BOSTIK H775 GLASS'N'SEAL PREMIUM PAINTABLE is the perfect paintable solution for glazing joints for interior and exterior. BOSTIK H775 GLASS'N'SEAL PREMIUM PAINTABLE is an all-round applicable sealant in connection joints as well as dilatation joints.

Most important characteristics

- For universal use, interior and exterior
- Fully paintable with synthetic and water based paints
- Ideal sealant for glazing
- Isocyanate and solvent free
- Bubble free curing and shrinkage free
- High weather, water and UV resistance
- Long lasting elastic effect

Certifications

- EN 15651-1: F-EXT-INT-CC 25HM
- EN 15651-2: G-CC 25HM
- A+ French VOC Regulation

Packaging	Packed per	Colour
290 ml cartridge	12 cartridges per box	white, black and anthracite



BOSTIK S740 GLASS'N'SEAL SILICONE N

Premium matt silicone sealant for glazing and facade joints

Product description

BOSTIK S740 GLASS'N'SEAL SILICONE N is a versatile, highly certified neutral silicone sealant for glazing and facade joints.

Most important characteristics

- 100% Meko-free
- Neutral curing, almost odourless
- BREEAM International Compliant
- Perfect bonding without primer on most substrates
- Excellent resistance to UV, water and weather
- Non corrosive towards metals
- Good adhesion to glass, painted wood, ceramic, enamelled, stainless steel and many plastics

Certificates

- EN 15651-1: F-EXT-INT-CC 25LM
- EN 15651-2: G-CC 25LM
- EMI CODE EC1 Plus – very low emission
- BREEAM International Compliant
- Indoor Air Comfort Gold®
- Blue Angel (RAL UZ 123)
- E1 EN 717-1§
- A+ French VOC Regulation

Packaging	Packed per	Colour
300 ml cartridge	12 cartridges per box	white, grey and black
600 ml foil pack	12 foil packs per box	white, grey and black

BOSTIK S570 GLASS'N'SEAL SILICONE A

Low modulus glazing and all-round acetoxy silicone sealant

Product description

BOSTIK S570 GLASS'N'SEAL SILICONE A is a versatile acetoxy silicone sealant for glazing joints, which cures under influence of humidity to form a durable elastic rubber. BOSTIK S570 GLASS'N'SEAL SILICONE A fulfils BREEAM specifications mentioned in chapter 'Health and Wellbeing', Hea 02 Indoor Air Quality, regarding volatile organic compound (VOC) emission levels (products).

Most important characteristics

- Perfect toolability
- Suitable for BREEAM applications
- Perfect adhesion without primer to glass, painted wood, ceramic and enameled substrates
- Excellent resistance to UV, water and weather
- Permanently elastic

Certifications

- EN 15651-1: F-EXT-INT-CC 25HM
- EN 15651-2: G-CC 25HM
- EMI CODE EC1 Plus – very low emission
- A+ French VOC Regulation

Packaging	Packed per	Colour
300 ml cartridge	12 cartridges per box	transparent, white, silver grey and black





BOSTIK H565 GLASS'N'SEAL MULTI PURPOSE
High modulus glazing and multi-purpose hybrid sealant

Product description
BOSTIK H565 GLASS'N'SEAL MULTI PURPOSE is a multi-purpose high modulus hybrid joint sealant for interior and exterior use.

- Most important characteristics**
- Neutral curing
 - Almost odourless
 - Perfect adhesion without primer to most common building materials
 - Good resistance to UV and weather
 - Perfectly paintable with water based paints

- Certificates**
- EN 15651-1: F-EXT-INT-CC 20HM
 - EN 15651-2: G-CC 250M
 - A+ French VOC Regulation

Packaging	Packed per	Colour
290 ml cartridge	12 cartridges per box	white, grey and black

8. Glazing sealants in other segments



More glazing sealants

Bostik also offers sealants in other application segments such as the construction & facade segment, sanitary and the fire protection segment. These special sealants are developed specifically for a dedicated application such as fire protection, the installation of door and window frames etc.

Construction & Facade

Bostik's construction & facade segment contains professional products that have been constructed specifically for general construction needs and application in facade elements. This extensive application segment contains a variety of sealants that are also very well suitable for general glazing sealing needs. For a full portfolio please consult the Construction & Facade segment brochure.

Sanitary

Bostik's sanitary segment contains professional products that have been constructed specifically for application in wetroom areas such as kitchens, bathrooms, showers and toilets. These, mostly silicone sealants also have the ability to seal glazing joints in sanitary areas. For a full portfolio and detailed explanation please consult the Sanitary segment brochure.

9. Accessories

To achieve that perfect glazing joint, Bostik also offers some indispensable accessories. These tools greatly improve the quality of the glazing joint but also helps the applicator to save time.



BOSTIK T500 FINISHING SOAP

Joint sealant finishing additive

Product description

BOSTIK T500 FINISHING SOAP is a ready mixed neutral universal additive for the wet tooling of sealants in joints. BOSTIK T500 FINISHING SOAP is more than 99% Biodegradable.

BOSTIK PE GLAZING TAPE

Self-adhesive reinforced glazing tape

Product description

BOSTIK PE GLAZING TAPE is a self-adhesive reinforced tape that can be used in timber and steel frames.

BOSTIK SPATULA

Professional spatula for tooling sealants

Product description

A set of three wooden spatula for easy tooling and finishing of sealant joints.



10. Explanation of the icons

The brand new packaging of the Glazing range comes with icons that tell something about the properties of the product. Below we explain in detail what these icons mean.



Outside & inside use

The product can be used outside and inside.



25% flexible

The cured product is has a flexibility of 25%.



Showcase

The product can be used in showcases and large shop windows.



Excellent application

The product has excellent application properties.



Paintable

The product has excellent overpaintable properties.



Glazing

The product can be used for sealing glass in windows.



Classic glazing

The product can be used for sealing glass in classic (monumental) windows.



UV resistant

The product has excellent resistance against ultra violet beams.



11. Special Applications

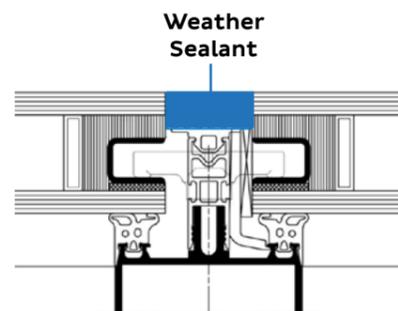
Weather Sealing

Bostik is not producing and supplying one and two component silicones for silicone structural glazing (SSG). Within Bostik's glazing portfolio, you can find a high performing neutral curing silicone that can be used for weather sealing.

Because the adhesion surface is the edge of the glass. Glass is known as one of the highest UV transmitters, so to choose for a high performing neutral curing silicone sealants is the best solution man can make. **BOSTIK S780 GLASS'N'SEAL PREMIUM** is such a solution.

In two and four sided silicone structural glazing systems as well as in spider glazing facades, glass units needs to be sealed with high performing silicones to make the joint, same as the glass unit, impervious to water penetration.

The best solution in these applications is to choose for the highest certificate available. EN 15651-2: G-CC 25LM or EN 15651-2: G-CC 25LM or ASTM C-920 S, G, Class 50 or Type S, G, Class 100/50.



PMMA & PC

PMMA and PC are abbreviations for Poly Methyl Methacrylate and Poly Carbonate. These materials are often used in combination with safety glass of as durable solution for fragile glass systems. Downside is that both PMMA as well as PC can show stress cracking.

Stress cracking is considered a leading cause of failure in plastics. Stress cracking is the premature embrittlement and cracking of the plastic due to simultaneous action of stress and contact with a chemical agent.

Bostik is recommending as glazing joint in PMMA and PC glazing systems the **BOSTIK S780 GLASS'N'SEAL PREMIUM**. Due to its long track record, it is a safe product to use in these projects.



Stress Cracking caused by improper product use

Sealing Monumental Glass

In order to guarantee the authenticity and thus the appearance of a monumental building, during a renovation or maintenance of a historical building, the use of monumental glass is chosen often. This type of glass comes with the 'old-fashioned' appearance caused by a light haze and subsidence in the glass panes. In the old days the production of glass panes was a completely manual process. To assure a durable and weather and UV-resistant connection between the historically window frames and the costly monumental glass, modern glazing putties are used of which Bostik has got two solutions in its portfolio. Both highly UV-resistant, durable and long-lasting, easy to apply and tool and most important, both solutions will fully cure and dry in line with modern sealants, 2-3 mm per 24 hours.

Bostik is recommending as durable glazing putty in historically glazing systems the **BOSTIK H950 GLASS'N'SEAL PUTTY PREMIUM** (paintable) or the **BOSTIK S950 GLASS'N'SEAL PUTTY SILICONE** (not paintable).

Interior glass systems

For interior glass systems, Bostik is able to offer highly transparent or black silicones. Depending on the type of application and the project specifications. New in our portfolio is the **BOSTIK H505 SEAL'N' BOND CRYSTAL**, which might tick all your boxes to deliver your perfect finish.



12. Technical Training

Bostik professional product portfolio

The rest of the Bostik professional product portfolio you can find at bostik.com and read more about them in the product application brochures

End-users expect up-to-date knowledge and technical support from shop-employees. Bostik supports with training programs focusing on products and applications. We co-develop training programs with producers and resellers to combine the knowledge of sealants and adhesives with knowledge on dedicated Bostik products.



Better results through Knowledge

Glazing is a serious market segment which deserves a dedicated approach. Bostik constantly gathers knowledge about glazing systems upstream and downstream, from chemical supplier to end-user. The collection of this knowledge is a continuous process and provides us with the latest insights.

Centre of Excellence

In our recently built Centre of Excellence we share knowledge within the Bostik group, with our customers and with end-users. We are pleased to receive our partners and end-users to provide them with the latest knowledge and new insights. This new information enables our partners to achieve higher efficiency and better results.





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