



The Adhesive Company

Chem-Calk® 915

ONE-COMPONENT, POLYURETHANE SEALANT, CONTRACTOR GUN GRADE

DATE OF LAST REVISION: 10/07/10

MANUFACTURER

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PRODUCT DESCRIPTION

Bostik® Chem-Calk® 915 sealant is a one-component, contractor construction grade, smooth polyurethane sealant capable of dynamic joint movement totaling 50% of original joint geometry ($\pm 25\%$). The sealant cures to a tough, flexible rubber when exposed to moisture present in the atmosphere.

Chem-Calk® 915 polyurethane sealant has a consistency like toothpaste, its physical properties will remain relatively stable over time and in varying weather conditions. Its physical properties are relatively unchanged over a wide temperature range, -40°F to 150°F (-40°C to 66°C).

Where textured appearance is needed, please use Bostik® Chem-Calk® 916.

APPLICABLE STANDARDS

- ASTM C920, TYPE S, GRADE NS, CLASS 25, USE NT, A AND M.
- US Federal Specification TT-S 00230C (COMB-NBS) for one-component sealants as Class A, non-sag.
- Canadian Specification CAN/CGSB 19.13-M87.
- CARB and SCAQMD Compliant.
- Canadian Specification CAN/CGSB 19.13-M87.
- Miami-Dade County, Florida, NOA No.: 06-1002, 05/14/12.
- Meets VOC Requirements for OTC Regulation.

BASIC USES

- Designed for sealing expansion and control joints in pre-cast concrete panels, for sealing various roofing and siding applications, and for sealing perimeters of doors, windows, and other wall penetrations.
- Sealant cures to form a durable, flexible bond with most building materials in any combination including stone, masonry, ceramic, marble, wood, steel, aluminum, fiber cement board and many other synthetic materials.



TECHNICAL DATA SHEET



**TABLE 1: CHEM-CALK® 915
TYPICAL UNCURED PROPERTIES***

Property	Value	Test Method / Note
Tool/Work Time	60 min.	Bostik Test Method
Skin Time	4 hrs.	Bostik Test Method
Curing Time @ 77°F	2 - 7 days	Varies w/ relative humidity
Flow, Sag or Slump	0.1 inch	Bostik Test Method

**TABLE 2: CHEM-CALK® 915
TYPICAL CURED PROPERTIES***
(After 14 days cure at 77°F and 50% RH)

Property	Value	Test Method / Note
Hardness (Shore A)	42	ASTM D 2240
Modulus @ 100% Elongation	65 psi	ASTM D 412
	45 psi	ASTM D 412
Tensile Strength @ Break	133 psi	ASTM D 412
Elongation @ Break	685%	ASTM D 412
Adhesion Peel	>5 piw	TT-S-00230C / ASTM C 794
Joint Movement Capability	+25%	TT-S-00230C / ASTM C 719
UV Resistance	Pass	ASTM C 793

* Values given above are not intended to be used in specification preparation purposes.

FEATURES & BENEFITS

- Easy gunning Helps reduce installer's fatigue
- Tenacious Bonding to Most Common Building Materials Helps Maintain a Weatherseal to Seal Out the Elements
- Quicker skin and cure times Helps reduce jobsite dirt pickup

APPLICATION LIMITATIONS

- Construction substrates have become complex and diverse by nature and origin. Substrate chemistries and structures can interfere with adhesive performances of the sealant. Adhesion to Substrate Pretest (ASP) is therefore MANDATORY to assess any adhesion and sealing characteristics—see Adhesion to Substrates Pretest section and see Installation Protocol section. This must be done pre-installation to avoid potential failures. Call Technical Service for more information about surface preparation and possible priming.
- Do not apply over damp, contaminated, loose surfaces (See Installation Protocol and Surface Preparation), old sealants or other foreign substances that may impair the adhesion bond. Avoid air entrapment.
- Dampness and substrates with high moisture content will trigger extensive curing of the sealant within a very short period of time. This may cause an excess of bubbling and foaming within the sealant and at the bottom of the bead.

High temperature/humidity can cause the sealant to develop bubbles during the curing process.

Sealant installation is not recommended when the dew point of the substrate is close to ambient temperature or a moisture-vapor transmission condition is present increasing the potential for bubbling to form during cure.

Porous substrates such as, but not limited to, marble, limestone, and granite might absorb components of the Chem-Calk 915 leading to staining of the substrate. **ASP with sufficient aging is mandatory to assess this potential issue.**

- The ultimate performance of Chem-Calk 915 depends on proper joint design and proper application with joint surfaces properly prepared (See Installation Protocol). Chem-Calk 915 is not recommended for joints with dimensions less than or greater than what is recommended below. (See Installation Protocol—Joint Design section.)
- Chem-Calk 915 must not be used to seal narrow joints, fillet joints and face nail holes.
- Smearing and feathering Chem-Calk 915 over joints is not recommended.
- Chem-Calk 915 is not recommended for horizontal joints or traffic-bearing joints where abrasion resistance is required (walkways, driveways, runways, etc.). Please refer to Chem-Calk® 955-SL for this application.
- Chem-Calk 915 is not recommended for continuous immersion in water or any other fluid. When fully cured, avoid exposure, even incidental, to fuels, chlorinated, acid and alkaline solutions. Chem-Calk 915 is not recommended for exterior or interior sealing below the waterline; please refer to Bostik® 940 Fast Set for marine applications.
- Contact of Chem-Calk 915 with asphalts (i.e., back coating of window flashing, etc.) and other filler compounds impregnated with oil, asphalt, tar, etc., may deteriorate the cohesive strength of the substrate and ultimately compromise the seal.
- During the curing of Chem-Calk 915, do not expose to curing silicone sealants, curing Bostik Chem-Calk 2000 or Chem-Calk 2020, alcohol, acids or solvent-based materials.
- Compatibility to copper-based substrates (i.e., flashing) can vary due to, but not limited to, age and joint size. Please consult Technical Service for details.
- Lower relative humidity and temperature will significantly extend the curing time. Confined areas, deep joints and moisture barrier substrates may also affect the full cure time and extend it by many days.
- Chem-Calk 915 may remain tacky for a few hours and attract dust and dirt from the jobsite which may affect the appearance of the sealant. Check tack-free time to prevent dirt pickup.
- Chem-Calk 915 is not recommended for glazing applications. Bond line strength can be affected by UV rays through the clear material (glass, acrylic glass, polycarbonate, etc.).

- Chem-Calk 915 is not an RTV silicone and therefore is suitable for painting with latex based paints. Paint chemistries and flexibility characteristics of the paint films over the sealant may affect wetting, adhesion and integrity of the paint layer; and it is therefore mandatory to pretest the paint or other coating over the Chem-Calk 915 to ensure the successful compatibility between the sealant and the paint/coating after a sufficient amount of time. See your paint manufacturer for specifications or limitations and call our Technical Service for more information. In general, oil-based paints are not recommended because of their poor elastic properties and because of their potential interaction with the sealant chemistry, which may create non-curing conditions for the sealant. Do not paint over the polyurethane sealant until it has fully cured.
- The surface of a Bostik Chem-Calk 915 seal when exposed to UV rays and sunlight will yellow and will not retain its gloss. This phenomenon can occur within a few weeks after exposure. The change of color is limited to the surface layer of the seal and should not compromise the sealing properties of the Chem-Calk 915 if the dimensions of the joint are proper and the sealant is otherwise properly applied. In areas where color retention is critical, please refer to Bostik Chem-Calk 2000 and 2020. Chem-Calk 915 may remain tacky for a few hours and attract dust and dirt from the jobsite which may affect the appearance of the sealant. Check tack-free time to prevent dirt pickup.

INSTALLATION PROTOCOL

Miami-Dade County Considerations:

Mate or join adjacent surfaces prior to the Chem-Calk 915 skinning and subsequent curing, to maximize wetting potential of the sealant to the substrates. Allow full-cure, typically 7 days, prior to any mechanical stress testing procedures. It is recommended that adhesion testing be performed to capture batch control qualities of proposed substrates.

Joint Design:

In general, more joint movement can be accommodated in a thin bead of sealant than a thick bead. Chem-Calk 915 Polyurethane Sealant should be no thicker than 1/2" (12.7mm) and no thinner than 1/4" (6.4mm). In joints between 1/2" and 1", the ratio of sealant width to depth should be approximately 2:1. Sealant depth in joints between 1/4" and 1/2" should be 1/4" deep. Joints with dynamic movement should not be designed in widths less than 1/4".

Surface Preparation:

See limitations about surface preparation. Surfaces must be structurally clean, dry (no frost) and structurally sound, free of contaminants, including, but not limited to, dust, dirt, loose particles, tar, asphalt, rust, mill oil, etc. If substrate is painted or coated, scrape away all loose and weakly bonded paint or coating. Any paint or coating that cannot be removed must be tested to verify adhesion of the sealant or to determine the appropriate surface preparation if needed. (See ASP section on next page for details.)

To remove laitance and any other loose material, clean concrete, stone or other masonry materials with non-alcoholic based solvent by washing, grinding, sandblasting or wire brushing as necessary. Do not use water to clean substrates. Dust must be thoroughly removed after cleaning.

Alcohol is **not** compatible with polyurethanes and its use can cause irreparable damage to the sealant. If alcohol is used as a cleaning solvent, all traces of alcohol must thoroughly be removed prior to the installation of the polyurethane sealant. Lastly, alcohol is not recommended as a tooling medium.

Backer Rods and Bond Breaker Tapes:

Bond breakers including, but not limited to, closed-cell polyethylene backer rods are used to control depth of the sealant bead, provide a firm tooling surface and avoid three-sided adhesion. Where the depth of joint prevents use of backer rods, a polyethylene strip or tape must be used as a bond breaker to prevent 3-sided adhesion. Do not prime or damage the surface of the bond breaker. Refer to instructions given by rod and tape manufacturers for the correct backer rod and tape size related to joint size.

Priming:

In general, application of Chem-Calk 915 does not require priming the substrates. However, some substrates may require a Bostik primer. It is the user's responsibility to check adhesion of the cured sealant on typical test joints at the project site before and also during application as weather conditions may affect the adhesion results (See ASP section on next page.). Refer to Bostik Primer product data sheet or call Technical Service for proper selection and application of Bostik Primers.

Tooling:

Chem-Calk 915 comes ready-to-use. Cut spout or tip to desired bead size. Apply moderate pressure to break seal inside the nozzle. Apply by using a professional caulking gun. Use opened cartridges and sausages the same day they are opened. Apply Chem-Calk 915 Polyurethane Sealant in a continuous operation using positive pressure to the bottom of the joint to properly fill and seal the joint. When applying, avoid air entrapment and overlapping. Tool the sealant before the skin forms with adequate pressure to spread the sealant against the backup material at the bottom and sides of the joint. A dry tool with a concave profile is recommended for that operation. Do not use water or soapy water for this operation. Avoid smearing and feathering of the sealant to allow full performance of the cured seam. Excess sealant should be dry-wiped or joints should be properly taped.

Cleaning:

After dry-wiping uncured sealant from substrates and tools, remaining uncured sealant can be removed by using Xylene, Toluene or similar aromatic solvents. Please refer to the MSDSs provided for these solvents before use. Bostik® Hand Towel and Specialty Sealant Remover can also remove uncured sealant. Cured sealant is usually very difficult to remove without altering or damaging the surface to which the sealant has been misapplied. Cured sealant can be removed by abrasion or other mechanical means (scrapers, putty knives).

Curing Time:

Chem-Calk 915 is a moisture cure, Advanced Polyurethane Sealant. On wood, with ambient air at 50% relative humidity and at 73°F, polyurethane sealants will generally skin within four hours and cure 1/16 of an inch per day. Lower temperature and lower relative humidity will significantly increase the skin time and cure time of a polyurethane sealant.

Painting and Coating:

Chem-Calk 915 is not an RTV silicone and therefore is suitable for painting with latex-based paints. Paint chemistries and flexibility characteristics of the paint films over the sealant may affect wetting, adhesion and integrity of the paint layer, and it is therefore mandatory to pretest the paint or other coating over the Chem-Calk 915 to ensure the successful compatibility between the sealant and the paint/coating after a sufficient amount of time. See your paint manufacturer for specifications or limitations and call our Technical Service for more information. In general, oil-based paints are not recommended because of their poor elastic properties and because of their potential interaction with the sealant chemistry, which may create non-curing conditions for the painted sealant. Do not paint over the polyurethane sealant until it has fully cured.

Maintenance:

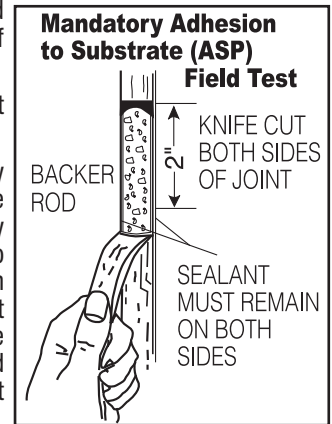
If the sealant becomes damaged, replace the damaged portion by removing the old sealant completely, cleaning the surfaces and reapplying a fresh and appropriate amount of new sealant in accordance with the directions and information contained in this data sheet.

MANDATORY ADHESION TO SUBSTRATES PRETEST— (ASP)

A hand pull test must be run before the job starts and at regular intervals during the job. It must be run on the job site after the sealant is fully cured, usually within 7 to 21 days. (Adhesion may develop fully after at least 14 days.)

The hand pull test procedure is as follows:

1. Make a knife cut horizontally from one side of the joint to the other.
2. Make two vertical cuts approximately two inches long, at the sides of the joint, meeting the horizontal cut at the top of the two-inch cuts.
3. Grasp the two-inch piece of sealant firmly between the fingers and pull down at a 90° angle or more, and try to pull the uncut sealant out of the joint.
4. If adhesion is sufficient, the sealant should tear cohesively in itself.
5. Sealant may be replaced by applying more sealant in the same manner as it was originally applied. Care should be taken to ensure that the new sealant is in contact with the original, and that the original sealant surfaces are clean, so that a proper bond between the new and old sealant will be obtained.



STORAGE • PACKAGING • SHELF LIFE

Shelf life of Chem-Calk 915 must be checked prior to using the product; do not use past its shelf life. Caulk past its shelf life may not perform or adhere as described by this data sheet. High temperature and high relative humidity may reduce significantly the shelf life of polyurethane sealants. If you are unsure of the expiration date of your Bostik product, please call customer service at 1-800-7/BOSTIK (1-800-726-7845) to check if the product is still within its shelf life.

COLORS

White	Stone	Bronze	Tan
Black	Limestone	Med. Bronze	Almond
Light Gray	Aluminum Stone		

AVAILABILITY

Available from authorized Bostik distributors. Go to www.bostik-us.com and check on our distributor locator for the closest distributor in your location or call customer service at 1-800-7/BOSTIK (1-800-726-7845).

HEALTH AND SAFETY

Please refer to the MSDS for First Aid Information. Most current MSDS's can be found on Bostik's website at www.bostik-us.com or call customer service at 1-800-7/BOSTIK (1-800-726-7845).

TECHNICAL SERVICE

TECH SERVICE phone number: 1-800-7/BOSTIK (1-800-726-7845).

Field visits by Bostik personnel, Bostik manufacturer representatives or Bostik authorized distributor personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the jobsite.

WARRANTY (LIMITED WARRANTY) — IMPORTANT NOTICE

All statements, technical information and recommendations set forth herein are based on tests which Bostik believes to be reliable. However, Bostik does not guarantee their accuracy or completeness. The buyer and/or user should conduct its own tests of this product before use to determine proper preparation technique and suitability for proposed application. Any sales of this product shall be on terms and conditions set forth on Bostik's order acknowledgment. Bostik warrants that the product conforms with Bostik written specifications and is free from defects at the time it leaves Bostik's control. BOSTIK DISCLAIMS ALL OTHER WARRANTIES, EXPRESSED AND/OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. THE BUYER'S SOLE REMEDY FOR NONCOMPLIANCE WITH THIS WARRANTY SHALL BE FOR THE REPLACEMENT OF THE PRODUCT OR REFUND OF THE BUYER'S PURCHASE PRICE. IN NO CASE WILL BOSTIK BE LIABLE FOR DIRECT, CONSEQUENTIAL ECONOMIC OR OTHER DAMAGES.

CHEM-CALK® COVERAGE CHARTS

COVERAGE FOR 10.1 FL. OZ. CARTRIDGE (298 mL)

		Width							
		1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"
Depth	1/8"	99	49	33	24	20	16	14	12
	1/4"		24	20	12	10	8	7	6
	3/8"			11	8	6	5	5	4
	1/2"				6	5	4	3	3

LINEAR FEET PER 10.1 FL. OZ. CARTRIDGE

COVERAGE FOR 28 FL. OZ. CARTRIDGE (857 mL)

		Width							
		1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"
Depth	1/8"	288	145	95	71	58	48	40	36
	1/4"		71	58	36	29	23	20	17
	3/8"			32	23	17	16	13	11
	1/2"				17	14	11	10	8

LINEAR FEET PER 28 FL. OZ. CARTRIDGE

COVERAGE FOR 20 FL. OZ. SAUSAGE (600 mL)

		Width							
		1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"
Depth	1/8"	288	145	95	71	58	48	40	36
	1/4"		71	58	36	29	23	20	17
	3/8"			32	23	17	16	13	11
	1/2"				17	14	11	10	8

LINEAR FEET PER 20 FL. OZ. SAUSAGE

COVERAGE CHART FOR 1.5 GALLON PAIL (5.67 L)

		Width							
		1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"
Depth	1/8"	1848	924	615	462	369	308	264	231
	1/4"		412	308	231	185	153	132	116
	3/8"			204	153	123	102	87	77
	1/2"				116	92	77	66	57

LINEAR FEET PER 1.5 GALLON PAIL

COVERAGE CHART FOR 5 GALLON PAIL (18.9 L)

		Width							
		1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"
Depth	1/8"	6150	3100	2050	1540	1230	1025	870	770
	1/4"		1540	1240	770	615	510	440	370
	3/8"			680	510	410	310	290	245
	1/2"				370	305	245	220	185

LINEAR FEET PER 5 GALLON PAIL

PRIMER COVERAGE RECOMMENDATIONS

For one quart of primer, coverage is as follows:

1 unit	5 gallon pail
5 units	1.5 gallon unit
7 gallons	1 gallon unit

NOTE: All values are approximations and can vary due to joint dimension variations, porosity, and texture of substrates. Yield per cartridge is approximate due to variables beyond Bostik's control such as irregular joint configuration and installation technique.

**TABLE 3: CHEM-CALK® 915
ASTM C-794 ADHESION-IN-PEEL
TO COMMON CONSTRUCTION SURFACES***

Surface	Failure Type – %
Mill Finished Aluminum**	Adhesive – 100
Anodized Aluminum	Cohesive – 100
Steel**	Adhesive – 100
Galvanized Steel	Cohesive – 100
Stainless Steel**	Adhesive – 100
Fiberglass	Cohesive – 100
ABS**	Adhesive – 100
Rigid PVC**	Adhesive – 100
Plywood***	Cohesive – 100
Concrete***	Cohesive – 100
Brick	Cohesive – 100
Granite	Cohesive – 100
Marble**	Adhesive – 100
Limestone***	Cohesive – 100

* Values given above are not intended to be used in specification preparation; ** With primer, value is >25, Cohesive – 100; *** Peel values are reduced when unprimed samples are water-immersed.