

illmod® 600

Pre-Compressed Impregnated Foam Seal

Product Description

Illmod® 600 is a UV stable, pre-compressed, self-expanding, flexible joint seal that provides protection against the elements. It is comprised of polyurethane foam that is impregnated with a modified acrylic resin, making it flame-resistant, and treated with a pressure-sensitive adhesive on one side for easy installation. Illmod 600 self-expands to fill the joints and creates a permanently elastic, weathertight seal.

Typical Uses

Typically used as an exterior or interior joint sealant, illmod 600 also can be used as a primary or secondary seal in vertical applications, and as a secondary seal in horizontal applications.

Following are acceptable applications for illmod 600:

- Vertical expansion joints
- Joints in pre-cast concrete, masonry, and brick facades
- Metal roofing panels & insulated metal panels
- Exterior insulation finish systems (EIFS)
- Primary seal in starter track assemblies for window wall

Unique Properties

When used within its application range, illmod 600 is weathertight against driving rain up to 12 lb/ft² psf or 600 Pa. It is vapor permeable yet weathertight and has a flame spread of 0 and a smoke development rating of 5 as tested per ASTM E84.

Features & Benefits

- Proven wind-driven rain resistance since 1965
- Remains permanently flexible
- Low volatility
- Compatible with a wide variety of Tremco Sealants
- Chemically compatible with many types of commercial construction: will not corrode iron, zinc, steel, galvanized steel or copper, and will not chemically harm concrete, lightweight concrete, mortar, brick, natural stones, plexiglas or wood
- Minimal surface preparation required
- No mixing or masking
- Can be applied in various weather and temperature conditions
- Can be painted with any color of water-based, flexible paint
- Easy soap-and-water cleanup: no solvents, no cartridges, no pails
- Compatible with most porous or sensitive substrates

Colors and Packaging

Black and Gray are available. Individual rolls are separated by release paper with multiple rolls per box.

Sizing/Dimensions

Each roll size is pre-cut to a standard joint depth. The number of lineal feet per box varies according to size. Refer to the illmod 600 size chart (page 2) for specific information.

Availability

This product is available from your authorized Tremco distributor.

Coverage Rate

Use the chart on the next page to determine the amount needed for your application.

Joint Design

Use the chart on the next page to determine proper illmod 600 joint width for your joint design. If the joint width is larger than 2-5/8" (67 mm), please consult your local Tremco Sales Representative.

Surface Preparation

Substrates should be clean and sound. Contact surfaces should be smooth, parallel, and free of any loose dirt, dust, or oils. Illmod 600 can be installed onto damp substrates.

Tools Needed

Tape measure, knife or scissors, spatulas or putty knives, wood shims and water spray bottle.

Priming

ExoAir Primer must be used on porous substrates.

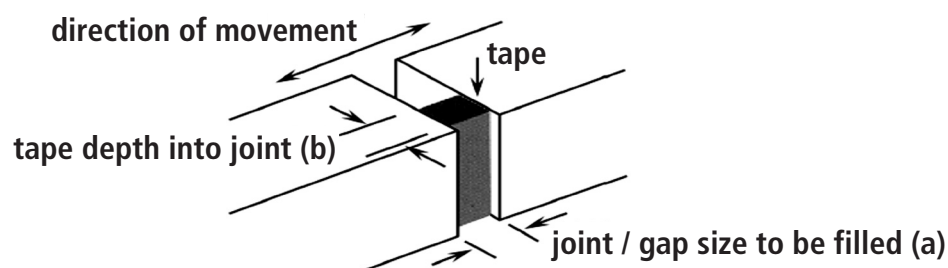
Limitations

To avoid over-compressed or under-compressed applications, use the sizing chart on page 2 to select the proper size product for the size of joint. Ideally, the joint size will fall directly in the middle of the performance range. If further assistance is needed on sizing, please contact your local Tremco Sales Representative.

- Water can de-activate the pressure-sensitive adhesive backing. If needed, use wood shims to hold the product in place during the expanding period.
- Avoid contact of illmod 600 with hydrocarbon solvents and corrosive chemicals.
- Illmod 600 must not be used as a primary seal where standing or ponding water will occur.

illmod 600 Black Sizing Chart (Refer to diagram below.)

Product Code	Joint/Gap Size to Be Filled (a)		Tape Depth into Joint (b)		Roll Length		Rolls/Case	Length/Case
S368320 522	0 to 1/8"	(0-3 mm)	3/8"	(10 mm)	32.5'	(9.9 M)	10	324'
S368332 522	1/8 to 1/4"	(3-7 mm)	1-3/8"	(35 mm)	26.2'	(8 M)	8	210'
S368355 522	3/16 to 3/8"	(5-10 mm)	5/8"	(15 mm)	18.4'	(5.6M)	20	368'
S368356 522	3/16 to 3/8"	(5-10 mm)	1-3/8"	(35 mm)	18.4'	(5.6M)	8	147'
S368357 522	3/16 to 3/8"	(5-10 mm)	4"	(102 mm)	18.4'	(5.6M)	3	55'
7368364 522	5/16 to 5/8"	(8-15 mm)	5/8"	(15 mm)	10.8'	(3.3 M)	20	217'
S368365 522	5/16 to 5/8"	(8-15 mm)	3/4"	(20 mm)	10.8'	(3.3 M)	16	173'
S368366 522	5/16 to 5/8"	(8-15 mm)	1"	(25 mm)	10.8'	(3.3 M)	12	130'
S368367 522	5/16 to 5/8"	(8-15 mm)	1-3/16"	(30 mm)	10.8'	(3.3 M)	10	108'
S368372 522	5/16 to 5/8"	(8-15 mm)	4"	(102 mm)	10.8'	(3.3 M)	3	32'
S368391 522	3/8 to 11/16"	(10-18 mm)	3/4"	(20 mm)	14.8'	(4.5 M)	16	236'
7368392 522	3/8 to 11/16"	(10-18 mm)	1"	(25 mm)	14.8'	(4.5 M)	12	177'
S368393 522	3/8 to 11/16"	(10-18 mm)	1- 1/4"	(32 mm)	14.8'	(4.5 M)	9	133'
S369507 522	1/2 to 7/8"	(13-24 mm)	1"	(25 mm)	17'	(5.2 M)	12	205'
7369508 522	1/2 to 7/8"	(13-24 mm)	1-3/16"	(30 mm)	17'	(5.2 M)	10	171'
S369509 522	1/2 to 7/8"	(13-24 mm)	1-1/2"	(38 mm)	17'	(5.2 M)	8	137'
7369524 522	11/16 to 1-1/4"	(17-32 mm)	1-3/16"	(30 mm)	13.1'	(4 M)	10	131'
S369525 522	11/16 to 1-1/4"	(17-32 mm)	1-1/2"	(38 mm)	13.1'	(4 M)	8	105'
S369526 522	11/16 to 1-1/4"	(17-32 mm)	1-3/4"	(45 mm)	13.1'	(4 M)	7	92'
S369540 522	1 to 1-5/8"	(28-40 mm)	1-1/2"	(38 mm)	8.8'	(2.7 M)	8	71'
7369541 522	1 to 1-5/8"	(28-40 MM)	2"	(50 mm)	8.8'	(2.7 M)	6	53'
S369542 522	1 to 1-5/8"	(28-40 mm)	2-1/3"	(60 mm)	8.8'	(2.7 M)	5	44'
S369543 522	1 to 1-5/8"	(28-40 mm)	3-1/2"	(90 mm)	8.8'	(2.7 M)	3	27'
S360003 522	1-5/8 to 2-1/8"	(42-54 mm)	2"	(50 mm)	6.5'	(2 M)	6	39'
7360103 522	1-5/8 to 2-1/8"	(42-54 mm)	2-3/4"	(70 mm)	6.5'	(2 M)	4	26'
S360203 522	1-5/8 to 2-1/8"	(42-54 mm)	3-1/2"	(90 mm)	6.5'	(2 M)	3	20'
S360002 522	2 1/16 to 2 5/8"	(52-67 mm)	2-1/3"	(60 mm)	6.5'	(2 M)	4	26'
7360102 522	2 1/16 to 2 5/8"	(52-67 mm)	2-3/4"	(70 mm)	6.5'	(2 M)	4	26'
S360202 522	2 1/16 to 2 5/8"	(52-67 mm)	3-1/2"	(90 mm)	6.5'	(2 M)	3	20'



Illmod 600 Gray Sizing Chart (Refer to diagram on preceding page.)

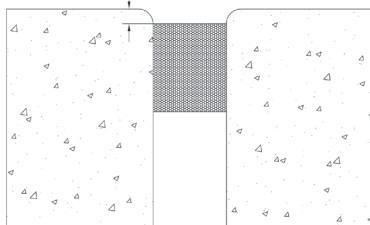
Product Code	Joint/Gap Size to Be Filled (a)	Tape Depth into Joint (b)	Roll Length	Rolls/ Case	Length/ Case
S368368 522	3/8 to 5/8" (8-15 mm)	5/8" (15 mm)	10.8' (3.3 M)	20	217'
S368394 522	3/8 to 11/16" (10-18 mm)	3/4" (20 mm)	14.8' (4.5 M)	16	236'
S368395 522	3/8 to 11/16" (10-18 mm)	1" (25 mm)	14.8' (4.5 M)	12	177'
S368396 522	3/8 to 11/16" (10-18 mm)	1-1/4" (32 mm)	14.8' (4.5 M)	9	133'
S369513 522	1/2 to 7/8" (13-24 mm)	3/4" (20 mm)	17.1' (5.2 M)	15	257'
S369510 522	1/2 to 7/8" (13-24 mm)	1" (25 mm)	17.1' (5.2 M)	12	205'
S369511 522	1/2 to 7/8" (13-24 mm)	1-3/16" (30 mm)	17.1' (5.2 M)	10	171'
S369512 522	1/2 to 7/8" (13-24 mm)	1-1/2" (38 mm)	17.0' (5.2 M)	8	137'
S369527 522	11/16 to 1-1/4" (17-32 mm)	1-3/16" (30 mm)	13.1' (4 M)	10	131'
S369528 522	11/16 to 1-1/4" (17-32 mm)	1-1/2" (38 mm)	13.1' (4 M)	8	105'
S369529 522	11/16 to 1-1/4" (17-32 mm)	1-3/4" (45 mm)	13.1' (4 M)	7	92'

TYPICAL PHYSICAL PROPERTIES

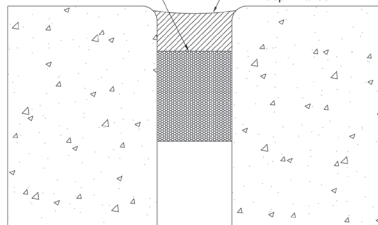
Property	Test Method	Typical Value
Color		Black or Gray
Density	ASTM D3574	5.5 to 6.5 lb/ft ³
Tensile Strength	ASTM D3574	21 psi minimum
Thermal Resistance	ASTM C518	3.3 to 3.6 hr x F x ft ² /Btu
Thermal Conductivity	ASTM C518	0.28-0.30 Btu-in./hr-F-ft ²
Temperature Stability Change		
Short Term (less than 24 hr)		-40 to 248 °F (-40 to 120 °C)
Long Term		-40 to 194 °F (-40 to 90 °C)
Elongation	ASTM D3574	120% +/-20%
Compression Set	ASTM D3574	4.2% maximum
Stain and Bleed	DIN 18 542 ASTM C510	Passes requirements No stain
Resistance to UV and Moisture	DIN 18 542	Passes requirements
Shelf Life		2 years
Resistance to Water Penetration		
Uniform static pressure	ASTM E331	12 psf
Cyclic static pressure	ASTM E331	12 psf
Fire Testing	ASTM E84*	Flame Spread: 0 Smoke Development: 5
Chemical Compatibility	DIN 52 423	No signs of corrosion on zinc, steel, galvanized steel, aluminum, and copper. No adverse chemical effects with concrete, lightweight concrete, brick, natural stones, 06#, plexiglas, or wood.
Hardness (at 80% compression)	Durometer scale A	25 +/-3

*Attachment was in a single joint at 50% compression. Joint material was constructed of calcium silicate board and is representative of field installation of the product.

Recessed 1/8" (3 mm) or within any rounded corners



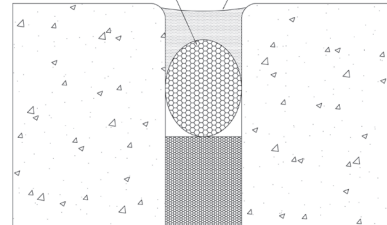
Properly sized illmod 600 as a secondary seal



Liquid applied sealant to industry recognized sealant joint width-to-depth ratios

Friction-fitted, closed-cell backer rod

Liquid applied sealant



illmod 600 as a secondary seal

Application Procedure

1. Measure the width and depth of the joints that are to be sealed.
2. Select the proper size illmod 600 from the chart on page 2 or call Tremco Technical Services for assistance at 866.209.2404.
3. Cut off the first 2" (5 cm) of the roll and discard. Then cut the roll to the appropriate length, leaving an extra 1/2" (13 mm) for every 3' (1 M).
4. Seal the vertical joints starting at the bottom and working up, butting each new piece into the previous. Apply a liberal amount of compatible sealant between the butt joints. Use a putty knife or spatula to ease installation if needed as shown in Figure 1.
5. If the self-adhesive backing is too sticky it can be temporarily neutralized by spraying the illmod 600 with water.
6. For aesthetic purposes it may be useful to recess the seal 1/16" (2 mm) to 1/8" (3 mm) below the surface of the joint.
7. If the joint is wet and the self-adhesive backing becomes ineffective, use the shims to hold the seal in place until it expands enough to support itself (see table).

Tips for Expansion Joint Installations

For horizontal expansion joints in walls, install the illmod 600 to the bottom of the joint and allow the material to expand upward. For intersections (Figure 2), always install illmod 600 in the vertical joints prior to the horizontal. Make sure to leave approximately 1/8" (3 mm) of extra seal as shown in Figure 2 to promote a watertight seal at the intersection.

Technical Services

Tremco Technical Services can help with application techniques, questions and size selection (866.209.2404).

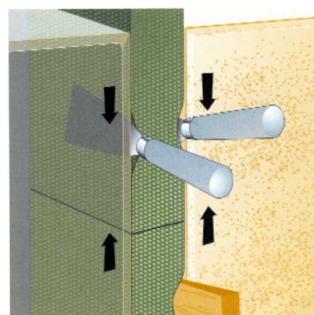


Figure 1

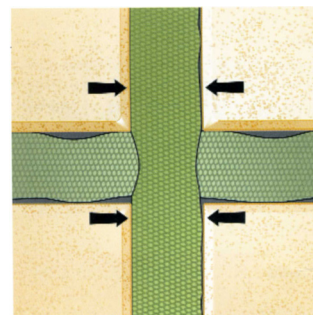


Figure 2

Set-up Time

Illmod 600 will self-expand to fill the joint; its expansion time is relative to the temperature of the illmod 600. After illmod 600 has filled the joint, it will continue to expand until it has reached equilibrium. This process requires additional time depending on temperatures. Give the tape at least seven days after install before an onsite weatherization test.

Cleanup

Any stickiness on hands from the pressure-sensitive adhesive can be washed with soap and water. Please refer to the product MSDS for proper disposal of unused material and wrappings.

Warranty

Tremco warrants its products to be free of defects in materials but makes no warranty as to appearance or color. Since methods of application and on-site conditions are beyond our control and can affect performance, Tremco makes no other warranty, expressed or implied including warranties of MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE with respect to Tremco products. Tremco's sole obligation shall be, at its option, to replace or refund the purchase of the quantity of Tremco products proven to be defective, and Tremco shall not be liable for any loss or damage.

Please refer to our website at www.tremcosealants.com for the most up-to-date Product Data Sheets.

