

TECHNICAL DATA SHEET

AS1623 1 Part Low Corrosive Industrial Sealant

Description

This is a 1-part, RTV (Room Temperature Vulcanising) silicone adhesive sealant. It is one in a range of Oxime cure products which are solvent free. It exhibits good primerless adhesion to many substrates especially plastics and cures rapidly at room temperature when in contact with atmospheric moisture. This product can be described as low corrosive but would not be recommended for use with copper or its associated alloys.

Key Features

- High temperature resistance to +260°C/500°F
- Resistance to 315°C/599°F intermittent exposure
- Excellent flow and self levelling properties
- Good adhesion to many substrates

Application

Applications include but are not limited to, sealing and fixing of domestic irons, shallow potting of electrical connectors for automotive applications.

Use and Cure Information

This product is a ready for use 1 Part system. If supplied in cartridges it can be applied using either manual or pneumatic dispensing guns. It can also be applied from bulk containers using conventional drum dispensing equipment.

All surfaces to which the sealant is to be applied should be clean, dry and free from grease, dirt, and loose material. Priming of surfaces is not normally required. If using as an adhesive, it should be applied to one clean surface and the other clean surface brought into contact with it within the tack free time stated opposite. For optimum bond strength, the thickness of the sealant joint should be a minimum of 1 mm.

The sealant will cure upon exposure to atmospheric moisture, ideally between 20 to 30 °C and 40% to 70% Relative Humidity. Time taken for cure will depend on the thickness of the joint, humidity and temperature. Joints should be left undisturbed for at least 24 hours, but preferably longer to effect sufficient depth of cure. Full cure requires 7 days.

"For pneumatic dispensing of 310 ml cartridges, the recommended pressure is 2.25 to 3.45 bar (40 to 50 psi). Dispensing pressure above the recommended limits may lead to gas bypassing the piston, causing spluttering at the nozzle and poor bead quality"

Health & Safety

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Safety Data Sheets available on request.

Packaging

CHT Adhesives are available in a variety packaging including cartridges and bulk containers. Please contact our sales department for more information.

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Property	Test Method	Value
Uncured Product		
50g Spread Diameter mm		170 mm
Appearance		Viscous liquid
Cure Profile		23+/-2°C and 50+/-5% humidity
Cure Through to 3 mm Depth		24 hr
Cure Type		Oxime
Rheology		Flowable
Self Bonding		Yes
Tack Free Time / Skin Formation at 23°C/73°F		19 min
Viscosity Mixed	Brookfield	6000 cP
Cured Product		
7 days at 23+/-2°C and 50+/-5% humidity		
Color		Red
Density	BS ISO 2781	1.08 g/cm3
Elongation at Break	ISO 37	180 %
Hardness Shore A	ASTM D 2240-95	24
Linear Coefficient of Thermal Expansion (ppm/°C)		300 ppm/°C
Max Working Temp		250 °C / 482 °F
Min Working Temp		-65 °C / -85 °F
Tensile Strength	ISO 40	1.2 N/mm2 / 174 psi
Thermal Conductivity		0.2 W/mK
Volume Coefficient of Thermal Expansion (ppm/°C)		902 ppm/°C
Electrical Properties		
Dielectric Strength kV/mm	ASTM D-149	16.1 kV/mm / 409 V/mil
Volume Resistivity (Ohms cm)	ASTM D-257	>1E+13 ohms cm
Storage		
Max Storage Temperature		40 °C / 104 °F
Shelf Life		9 mths

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The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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