

AS1745G

1 Part Non-Corrosive Neutral Cure Adhesive Sealant (Electronic Grade)

Description

This product is part of a range of high performance RTV's. It is a neutral cure silicone sealant specifically designed to meet the physical, chemical and temperature resistant requirements of MIL-A-46146B. It features exceptional physical properties and is compatible with many sensitive substrates including copper, brass, steel, aluminium and FR4, making this an ideal option for many electronic applications where high performance is paramount. The Alkoxy cure system produces a silicone sealant with excellent adhesion to most common substrates.

Key Features

- MIL 46146B physical / chemical requirements
- High mechanical strength
- High temperature resistance
- Non slumping adhesive paste

Application

Aerospace and engineering

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

Health and Safety

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

Uncured Product

Appearance
Cure Profile
Cure Through to 3 mm Depth
Cure Type
Rheology
Self Bonding
Slump
Tack Free Time / Skin Formation at 23°C/73°F

Test Method

Value

Thixotropic paste
23+/-2°C and 50+/-5% humidity
72 hr
Alkoxy Paste
Yes
1 mm/5mins
45 min

Cured Product

7 days at 23+/-2°C and 50+/-5% humidity

Color **Grey**
Density **1.16 g/cm3**
Elongation at Break **830 %**
Hardness Shore A **35**
Linear Coefficient of Thermal Expansion (ppm/°C) **267 ppm/°C**
Max Working Temp **316 °C / 601 °F**
Min Working Temp **-62 °C / -80 °F**
Tear Resistance (N/mm) **42 N/mm / 242 ppi**
Tensile Strength **7.75 N/mm2 / 1124 psi**
Thermal Conductivity **0.2 W/mK**
Volume Coefficient of Thermal Expansion (ppm/°C) **800 ppm/°C**
Youngs Modulus (N/mm2) **0.63 N/mm2 / 91 psi**

Electrical Properties

Dielectric Constant **2.47**
Dielectric Strength (V/mil) **457 V/mil**
Dielectric Strength kV/mm **18 kV/mm / 457 V/mil**
Dissipation Factor **0.0035**
Volume Resistivity (Ohms cm) **8.8E+14 ohms cm**

Adhesion Testing

Lap Shear Aluminium kg/cm² **8.78 kg/cm²**

Storage

Max Storage Temperature **40 °C / 104 °F**
Shelf Life **12 mths**

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

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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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