

## AS1402 1 Part Non-Corrosive Neutral Cure Adhesive Sealant (Electronic Grade)

### Description

This is a heat cured, non-corrosive, neutral cure, 1-part, silicone adhesive sealant. It is one in a range of Addition cure products which are solvent free. It exhibits primerless adhesion to many substrates when cured at temperatures above 100°C. It cures to form a very tough resilient silicone elastomer. This product will not corrode copper or its alloys and is suitable for use with electronic components.

### Key Features

- Fast heat cure
- Good adhesion to most substrates
- Non slumping paste
- Translucent

### Application

large metal surface areas

### Use and Cure Information

This product is a ready to use 1-Part system. It is recommended that liquid versions be thoroughly mixed prior to use, particularly thermally conductive products which are supplied in tubs or pails. Ensure that all surfaces of the substrate are clean and degreased. The work area should be free of contaminants such as organic compounds of sulphur, phosphorus, nitrogen and tin, which act as catalyst poisons.

The rate of cure will depend on how long it takes for the sealant to reach the required curing temperature. Small beads of 1 to 2mm diameter, used as formed-in-place gaskets, can be cured quickly with hot air guns e.g. paint stripper types. With larger sections of sealant or when using as an encapsulant, cure times will increase and the use of an oven will be needed. Increasing the temperature will reduce cure times and maximum cure temperature should not exceed 200°C. All times are based on the actual time in an air-circulating oven at the stated temperature. Note: Improved adhesion is achieved by post cure at 120 to 150°C for 1 to 2 hours.

“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.

Revision Date 12 Feb 2024  
Revision No 2  
Download Date 09 Oct 2024

### Property

#### Uncured Product

Appearance

Thixotropic paste

Cure Profile

1 hour at 150°C, 2 hours at 100°C

Cure Type

Addition Heat Cure

Extrusion Rate g/min

440 g/min

Rheology

Paste

Self Bonding

Yes

#### Cured Product

##### After 1 hour at 150°C

100% Modulus (N/mm<sup>2</sup>)

0.54 MPa / 78 psi

Color

Translucent

Density

BS ISO 2781 1.03 g/cm<sup>3</sup>

Elongation at Break

ISO 37 295 %

Hardness Shore A

ASTM D 2240-95 30

Linear Coefficient of Thermal Expansion (ppm/°C)

291 ppm/°C

Linear Shrinkage (%)

2 %

Max Working Temp

200 °C / 392 °F

Min Working Temp

-50 °C / -58 °F

Tear Resistance (N/mm)

BS ISO 34-1 3.1 N/mm / 18 ppi

Tensile Strength

ISO 37 1.5 N/mm<sup>2</sup> / 218 psi

Thermal Conductivity

0.2 W/mK

Volume Coefficient of Thermal Expansion (ppm/°C)

874 ppm/°C

Youngs Modulus (N/mm<sup>2</sup>)

0.38 N/mm<sup>2</sup> / 55 psi

#### Electrical Properties

Dielectric Strength (V/mil)

457 V/mil

Dielectric Strength kV/mm

ASTM D-149 18 kV/mm / 457 V/mil

Volume Resistivity (Ohms cm)

ASTM D-257 >1E+15 ohms cm

#### Adhesion Testing

Lap Shear Aluminium kg/cm<sup>2</sup>

ASTM D1002 8.25 kg/cm<sup>2</sup>

#### Storage

Max Storage Temperature

15 °C / 59 °F

Min Storage Temperature

-5 °C / 23 °F

Shelf Life

6 mths

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