

## AS1421 1 Part Non-Corrosive Neutral Cure Adhesive Sealant and Potting Material (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

- UL94 V0 recognised in file No. E334038
- Excellent thermal conductivity
- Fast heat cure
- Adhesion to most substrates

### Application

Electronics

### 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 29 Apr 2021  
Revision No 1  
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### Property

#### Uncured Product

Property	Test Method	Value
Appearance		Grey paste
Cure Profile		16 minutes at 100°C
Cure Type		Addition Heat Cure
Rheology		Paste
Self Bonding		Yes
Viscosity Mixed	Brookfield	140000 - 240000 cP

#### Cured Product

##### After 1 hour at 125°C

Color		Grey
Density	BS ISO 2781	2.18 g/cm3
Elongation at Break	ISO 37	105 %
Hardness Shore A	ASTM D 2240-95	56
Linear Coefficient of Thermal Expansion (ppm/°C)		195 ppm/°C
Max Working Temp		210 °C / 410 °F
Min Working Temp		-50 °C / -58 °F
Tensile Strength	ISO 37	2.2 N/mm2 / 319 psi
Thermal Conductivity		2.1 W/mK
UL 94V-0		Yes
UL File No.		E334038
Volume Coefficient of Thermal Expansion (ppm/°C)		586 ppm/°C
Youngs Modulus (N/mm2)		0.75 N/mm2 / 109 psi

#### Electrical Properties

Dielectric Strength (V/mil)		>457 V/mil
Dielectric Strength kV/mm	ASTM D-149	>18 kV/mm / 0 V/mil
Volume Resistivity (Ohms cm)	ASTM D-257	3.5E+13 ohms cm

#### Adhesion Testing

Lap Shear Aluminium kg/cm <sup>2</sup>	ASTM D1002	7.68 kg/cm <sup>2</sup>
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#### Storage

Max Storage Temperature	10 °C / 50 °F
Min Storage Temperature	-5 °C / 23 °F
Shelf Life	12 mths

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