TECHNICAL DATA SHEET

AS1620
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

- Excellent flow and self levelling properties
- Low corrosion
- Good adhesion to substrates

Application

Applications include but are not limited to, screen printed gaskets automotive, LED SMT Mega screens, coating of the reverse side of the PCB

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 ºC 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.

Revision Date	29 Apr 2021
Revision No	1
Download Date	06 Jun 2023

Property	Test Method	Value
Uncured Product		
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**
Tack Free Time / Skin Formation at 23°C/73°F		**14 min**
Viscosity Mixed	Brookfield	**26000 cP**
Cured Product		
7 days at 23+/-2°C and 60+/-5% humidity		
100% Modulus (N/mm2)		**0.36 MPa / 52 psi**
Color		**Translucent**
Density	BS ISO 2781	**1.04 g/cm3**
Elongation at Break	ISO 37	**400 %**
Hardness Shore A	ASTM D 2240-95	**25**
Linear Coefficient of Thermal Expansion (ppm/°C)		**291 ppm/°C**
Linear Shrinkage (%)		**1 %**
Max Working Temp		**220 °C / 428 °F**
Min Working Temp		**-50 °C / -58 °F**
Tear Resistance (N/mm)	BS ISO 34-1	**3.3 N/mm / 19 ppi**
Tensile Strength	ISO 37	**2 N/mm2 / 290 psi**
Thermal Conductivity		**0.2 W/mK**
Volume Coefficient of Thermal Expansion (ppm/°C)		**872 ppm/°C**
Youngs Modulus (N/mm2)		**0.56 N/mm2 / 81 psi**
Electrical Properties		
Dielectric Constant	ASTM D-150	**2.6**
Dielectric Strength (V/mil)		**>457 V/mil**
Dissipation Factor	ASTM D-150	**0.001**
Volume Resistivity (Ohms cm)	ASTM D-257	**4.9E+15 ohms cm**
Storage		
Max Storage Temperature		**40 °C / 104 °F**
Shelf Life		**12 mths**

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