TECHNICAL DATA SHEET

AS2500
2 part Industrial Adhesive Sealant

Description

This is a novel twin pack system, which consists of a 1-Part RTV Silicone Sealant and an accelerator in a 10:1 mix ratio. By extruding the system through a static mixer nozzle, the intimately mixed material behaves like a conventional silicone sealant, but has the advantage of very rapid cure - less than 3 hours to almost full cure, allowing for very fast assembly. The sealant will cure anaerobically (without atmospheric moisture) in approximately 2 hours which is not possible with a conventional 1-Part RTV sealant.

Key Features

- Very fast room temperature cure
- Good adhesion to most substrates
- Anaerobic cure
- Reduced odour

Application

Applications include but not limited to, assembly, cooking hobs and glass for cooker doors, and automotive FIPG

Use and Cure Information

This product is supplied as a twin pack 10:1 system.

When supplied in bulk containers A & B parts should be mixed at a ratio of 10:1 by volume using an automated machine with a static mixer nozzle. IMPORTANT: Mixed material in the mixer nozzle will cure quickly, therefore a continuous application process will avoid wasted material. A mixer nozzle of at least 9 GXF type elements is recommended for uniform mixing of both components.

The product can also be supplied in a high-quality twin cartridge system, the A part in a 240ml cartridge and the B part in a 24ml integral cartridge. To facilitate removal of the protective, plug a metal removable disc is located above the locking nut. The action of unscrewing the locking nut removes the plug. The static mixer nozzle is placed on the outlet and locked into place using the locking nut. (13mm). The stepped outlet of the static mixer nozzle is normally cut back 2 or 3 steps before fitting the cartridge into the dispensing gun*. The cartridge is then located in the gun and pressed to click into place.

The sealant is extruded by applying a steady pressure to the trigger. In the case of the manually operated dispenser, full depression of the trigger should be maintained for as long as possible before releasing and reapplying trigger pressure. Complete mixing of each component is achieved within the first 50-60% of the nozzle.

All substrate surfaces should be clean and free of grease, the mixed sealant should be applied to one surface and contact made immediately, any additional tooling should be carried out within the tack free time shown opposite. Full cure times will vary slightly depending on the joint dimensions.

* Excellent dual cartridge dispensers both manual and pneumatic are available from Sulzer Mixpac (UK) Limited – Ref DM 200.

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.

Property	Test Method	Value
Uncured Product		
Appearance		**Thixotropic paste**
Color A		**Translucent**
Color B		**Black**
Cure Profile		**23+/-2°C and 50+/-5% humidity**
Cure Through to 3 mm Depth		**1.5 hr**
Cure Type		**Acetoxy**
Extrusion Rate g/min		**304 g/min**
Mix Ratio By Weight		**10:1**
Rheology		**Paste**
Self Bonding		**Yes**
Tack Free Time / Skin Formation at 23°C/73°F		**4 min**
Cured Product		
7 days at 23+/-2°C and 50+/-5% humidity		
100% Modulus (N/mm2)		**0.91 MPa / 132 psi**
CTE Linear ppm/°C		**292 ppm / °C**
CTE Volumetric ppm/°C		**876 ppm/°C**
Color		**Black**
Density	BS ISO 2781	**1.05 g/cm3**
Elongation at Break	ISO 37	**280 %**
Hardness Shore A	ASTM D 2240-95	**39**
Linear Shrinkage (%)		**1 %**
Max Working Temp		**250 °C / 482 °F**
Min Working Temp		**-65 °C / -85 °F**
Tear Resistance (N/mm)	BS ISO 34-1	**5.5 N/mm / 31 ppi**
Tensile Strength	ISO 37	**2.32 N/mm2 / 336 psi**
Thermal Conductivity		**0.2 W/mK**
Youngs Modulus (N/mm2)		**0.65 N/mm2 / 94 psi**
Electrical Properties		
Dielectric Constant	ASTM D-150	**3**
Dielectric Strength (V/mil)		**457 V/mil**
Dielectric Strength kV/mm	ASTM D-149	**18 kV/mm / 457 V/mil**
Dissipation Factor	ASTM D-150	**0.0025**
Volume Resistivity (Ohms cm)	ASTM D-257	**7.77E+15 ohms cm**
Storage		
Max Storage Temperature		**40 °C / 104 °F**
Shelf Life		**12 mths**

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