

SilSo Bond 13623 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

- High temperature resistance to +260°C/500°F
- Resistance to 315°C/599°F intermittent exposure
- Excellent flow and self levelling properties
- Good adhesion to many substrates

Application

Applications include but are not limited to, sealing and fixing of domestic irons, shallow potting of electrical connectors for automotive applications.

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

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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.

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Revision No 4

Download Date 19 Jul 2024

Property

Uncured Product

50g Spread Diameter mm

Appearance

Cure Profile

Cure Through to 3 mm Depth

Cure Type

Rheology

Self Bonding

Tack Free Time / Skin Formation at 23°C/73°F

Viscosity

Test Method Value

140 mm

Viscous liquid

23+/-2°C and 50+/-5% humidity

24 hr

Oxime

Flowable

Yes

25 min

Brookfield 9000 cP

Cured Product

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

Color

Red

Density

BS ISO 2781 1.08 g/cm³

Elongation at Break

ISO 37 220 %

Hardness IRHD

BS ISO 48 24

Hardness Shore A

ASTM D 2240-95 25

Linear Coefficient of Thermal Expansion (ppm/°C)

300 ppm/°C

Max Working Temp

250 °C / 482 °F

Min Working Temp

-65 °C / -85 °F

Tensile Strength

ISO 37 0.9 N/mm² / 131 psi

Thermal Conductivity

0.2 W/mK

Volume Coefficient of Thermal Expansion (ppm/°C)

902 ppm/°C

Electrical Properties

Dielectric Strength kV/mm

ASTM D-149 16.1 kV/mm / 409 V/mil

Volume Resistivity (Ohms cm)

ASTM D-257 >1E+13 ohms cm

Storage

Max Storage Temperature

40 °C / 104 °F

Shelf Life

9 mths

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