

## SilSo Bond 13621 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

### 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

#### 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.

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Revision No        3  
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### Property

#### Uncured Product

Property	Test Method	Value
Appearance		Viscous liquid
Cure Profile		23+/-2°C and 50+/-5% humidity
Cure Through to 3 mm Depth		24 hr
Cure Type		Oxime
Extrusion Rate g/min		834 g/min
Rheology		Flowable
Tack Free Time / Skin Formation at 23°C/73°F		19 min
Viscosity Mixed	Brookfield	24000 cP

#### Cured Product

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

100% Modulus (N/mm2)		0.36 MPa / 52 psi
Color		White
Density	BS ISO 2781	1.05 g/cm3
Elongation at Break	ISO 37	410 %
Hardness Shore A	ASTM D 2240-95	24
Linear Coefficient of Thermal Expansion (ppm/°C)		306 ppm/°C
Linear Shrinkage (%)		1 %
Max Working Temp		230 °C / 446 °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)		920 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
Dielectric Strength kV/mm	ASTM D-149	29 kV/mm / 737 V/mil
Dissipation Factor	ASTM D-150	0.001
Volume Resistivity (Ohms cm)	ASTM D-257	1E+16 ohms cm

#### Storage

Max Storage Temperature	40 °C / 104 °F
Shelf Life	12 mths

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