

AS1603 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

- Thixotropic paste
- Low corrosive
- Primerless adhesion to many substrates
- Low odour

Application

Suitable for but not limited to aviation and aerospace 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

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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Download Date 12 May 2021

Property	Test Method	Value
Uncured Product		
Appearance		Thixotropic paste
Cure Through to 3 mm Depth		12 hr
Cure Type		Oxime
Drying / Fixing Conditions		23+/-2°C and 50+/-5% humidity
Extrusion Rate g/min		390 g/min
Rheology		Paste
Self Bonding		Yes
Tack Free Time / Skin Formation at 23°C/73°F		5 min
Cured Product		
7 days at 23+/-2°C and 50+/-5% humidity		
100% Modulus (N/mm2)		0.8 MPa / 116 psi
Colour		Translucent
Density	BS ISO 2781	1.07 g/cm3
Elongation at Break (%)	ISO 37	300 %
Hardness Shore A	ASTM D 2240-95	33
Linear Coefficient of Thermal Expansion (ppm/°C)		295 ppm/°C
Linear Shrinkage (%)		0.8 %
Max Working Temp (°C)		220 °C / 428 °F
Min Working Temp (°C)		-50 °C / -58 °F
Tear Resistance (N/mm)	BS ISO 34-1	4.8 N/mm / 28 ppi
Tensile Strength (N/mm2)	ISO 40	2.15 N/mm2 / 312 psi
Thermal Conductivity (W/mK)		0.2 W/mK
Volume Coefficient of Thermal Expansion (ppm/°C)		888 ppm/°C
Youngs Modulus (N/mm2)		0.6 N/mm2 / 87 psi
Electrical Properties		
Dielectric Constant	ASTM D-150	3
Dielectric Strength (V/mil)		457 V/mil
Dielectric Strength kV/mm	ASTM D-149	32 kV/mm / 813 V/mil
Dissipation Factor	ASTM D-150	0.0025
Volume Resistivity (Ohms cm)	ASTM D-257	8.7E+15 ohms cm
Adhesion Testing		
Lap Shear Aluminium kg/cm ²	ASTM D1002	4.15 kg/cm²
Lap Shear Stainless Steel 304 kg/cm ²	ASTM D1002	3.52 kg/cm²

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

CHT make reasonable efforts to ensure that information set out in the technical data sheet is complete, accurate, and up-to-date. CHT do not, however, make any representations, warranties or guarantees (whether express or implied) that information set out in the technical data sheet is complete, accurate, or up-to-date or that the product will be suitable for your requirements. You should carry out your own testing to determine the applicability of such information and whether the product will be suitable. CHT reserve the right to modify the technical data sheet at any time.

The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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Property	Test Method	Value
Storage		
Max Storage Temperature		40 °C / 104 °F
Shelf Life (mths)		12

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