

AS1502 1 part Industrial Adhesive Sealant

Description

This is a 1-part, RTV (Room Temperature Vulcanizing) silicone adhesive sealant. It is one in a range of Acetoxy cure products which are solvent free. During cure, it liberates a very small amount of acetic acid, giving rise to the familiar 'vinegar' odor, which quickly dissipates after cure. It exhibits good primer-less adhesion to many substrates including but not limited to; aluminum, non ferrous metals, steel, glass, enameled surfaces, fabrics ceramics, thermosetting, thermoplastics and wood and cures rapidly at room temperature when in contact with atmospheric moisture. This product is not to be recommended for use with galvanized metals, ferrous metals, copper and its associated alloys or in electronic assemblies.

Key Features

- Fast curing at room temperature
- FDA indirect food contact CFR 21 177.2600
- EU overall migration EC 1935/2004 framework EN1186-1 and EN1186-3
- Silver grey in colour

Application

Designed for applications including but not limited to, airport runway lights, sealing of industrial kitchens and stainless steel equipment and surfaces.

These products are highly resistant to weathering and aging, largely stable to many solvents, oils, water, sea water, industrial waste gasses, diluted acids, saline solutions detergents, cleaners, propellants and fruit acids.

Use and Cure Information

This product is a ready for use 1 Part system and can be directly dispensed from the original container without mixing. 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, dust, dirt, and loose material. Priming of surfaces is not normally required but in some cases it may be necessary to pretreat the surface. Please check this in each individual case. For degreasing of non-porous surfaces such as metal, and glass, KORASOLV GL is recommended (use undyed crepe paper or similar). 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 stated tack free time. 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 70 °C and >40% humidity. Time taken for cure will depend on the thickness of the joint, humidity and temperature. Increasing the temperature and humidity will accelerate the curing process, do not cure the sealant at or above 70°C as bubbles may form in the sealant and affect the overall physical properties and adhesion. Low temperatures and humidity will retard the curing process. Since curing times progressively increase with the thickness, the sealant depth should be limited to 10 mm. Joints should be left undisturbed for at least 24 hours, but preferably longer to effect sufficient depth of cure. Full cure requires 7 days at thicknesses of 1 - 5 mm and 14 days at thicknesses of 5 - 10 mm.

"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"

Solvents and cleaning agents.

For cleaning of the substrates to be bonded : KORASOLV GL.

For cleaning working tools and for removing fresh uncured material: KORASOLV GL

Care must be taken when cleaning synthetic materials which tend to form stress cracks, for example, polycarbonate and acrylic. Please

Property

Uncured Product

Appearance

Cure Profile

Cure Through to 3 mm Depth

Cure Type

Extrusion Rate g/min

Rheology

Self Bonding

Tack Free Time / Skin

Formation at 23°C/73°F

Test Method Value

Thixotropic paste

23+/-2°C and 50+/-5% humidity

7 hr

Acetoxy

204 g/min

Paste

Yes

4 min

Cured Product

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

CTE Linear ppm/°C

294 ppm / °C

CTE Volumetric ppm/°C

882 ppm/°C

Color

Silver Grey

Density

BS ISO 2781

1.08 g/cm3

Elongation at Break

ISO 37

205 %

Hardness Shore A

ASTM D 2240-95

52

Linear Shrinkage (%)

1 %

Max Working Temp

300 °C / 572 °F

Min Working Temp

-50 °C / -58 °F

Tear Resistance (N/mm)

BS ISO 34-1

6 N/mm / 34 ppi

Tensile Strength

ISO 37

3 N/mm2 / 435 psi

Thermal Conductivity

0.2 W/mK

Youngs Modulus (N/mm2)

1.85 N/mm2 / 268 psi

Electrical Properties

Comparative Tracking Index (volts)

>600 volts

Dielectric Constant

ASTM D-150

3

Dielectric Strength (V/mil)

>457 V/mil

Dielectric Strength kV/mm

ASTM D-149

>18 kV/mm / 0 V/mil

Dissipation Factor

ASTM D-150

0.0025

Volume Resistivity (Ohms cm)

ASTM D-257

8E+15 ohms cm

Adhesion Testing

Lap Shear Aluminium kg/cm²

ASTM D1002

8.79 kg/cm²

Lap Shear Stainless Steel 304 kg/cm²

ASTM D1002

8.58 kg/cm²

Storage

Max Storage Temperature

40 °C / 104 °F

Shelf Life

24 mths

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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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contact our technical service team for advice.

For removal of vulcanized product this can be done by mechanical means or by use of a chemical digester, please contact our technical service team for advice.

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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