

AS1504

1 Part RTV silicone adhesive sealant paste high temperature

Introduction

This is a 1-part, RTV (Room Temperature Vulcanising) 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' odour, which quickly dissipates after cure. It exhibits good primerless adhesion to many substrates and cures rapidly at room temperature when in contact with atmospheric moisture. This product is not to be recommended for use with copper and its associated alloys or in electronic assemblies.

Key Features

- Flexible from -50 to +300°C
- Good electrical insulation properties
- Excellent adhesion to most substrates

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 and Safety

Safety Data Sheets available on request.

Packaging

ACC Adhesives are available in a variety packaging including cartridges and bulk containers. Please contact our sales department for more information.

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Property	Test Method	Value
Uncured product		
Appearance		Red Paste
Cure Type		Acetoxy
Extrusion Rate g/min		255 g/min
FDA	CFR (21) 177.2600	No
Max Cure Hrs @ 25 °C		7 hrs
Rheology		Paste
Self Bonding		Yes
Tack Free Time mins		4 mins
Cured product		
After 7 days cure at 23° +/-2 °C and 50+/-5% humidity		
CTE Linear ppm/°C		294 ppm/°C
CTE Volumetric ppm/°C		882 ppm/°C
Colour		Red
Duro Shore A	ASTM D 2240-95	35
Elongation %	ISO 37	410 %
Linear Shrinkage %		0.8 %
Max Working Temp +°C	AFS_1540B	300 °C
Min Working Temp - °C		-50 °C
Modulus @ 100% Strain MPa		0.98 MPa
Modulus Youngs MPa		0.71 MPa
SG	BS ISO 2781	1.09
Tear kN/m	BS ISO 34-1	6.3 kN/m
Tensile MPa	ISO 37	2.5 MPa
Thermal Conductivity W/mK		0.2 W/mK
UL 94V-0		No
Storage		
Max storage temperature °C		40 °C
Shelf life		24 mths
Electrical properties		
Dielectric Constant @ 1kHz	ASTM D-150	2.68
Dielectric Strength kV/mm	ASTM D-149	>18 kV/mm
Dissipation Factor @ 1kHz	ASTM D-150	0.002
Surface Resistivity ohms	ASTM D-257	4.04E+14 ohms
Volume Resistivity ohms cm	ASTM D-257	3.95E+16 ohms cm
Adhesion testing		
Lap Shear Stainless Steel 304 kg/cm ²	ASTM D1002	5 kg/cm²

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