

## AS1603 1 Part RTV silicone adhesive sealant paste

### Introduction

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 most plastics
- Low odour

### 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

#### Uncured product

Appearance  
Cure Type  
Extrusion Rate g/min  
FDA  
Max Cure Hrs @ 25 °C  
Rheology  
Self Bonding  
Tack Free Time mins

#### Cured product

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

CTE Linear ppm/°C **295 ppm/°C**  
CTE Volumetric ppm/°C **888 ppm/°C**  
Colour **Translucent**  
Duro Shore A **33**  
Elongation % **300 %**  
Linear Shrinkage % **0.8 %**  
Max Working Temp +°C **220 °C**  
Min Working Temp - °C **-50 °C**  
Modulus @ 100% Strain MPa **0.8 MPa**  
Modulus Youngs MPa **0.6 MPa**  
SG **1.07**  
Tear kN/m **4.8 kN/m**  
Tensile MPa **2.15 MPa**  
Thermal Conductivity W/mK **0.2 W/mK**  
UL 94V-0 **No**

### Storage

Max storage temperature °C **40 °C**  
Shelf life **12 mths**

### Electrical properties

Dielectric Constant @ 1kHz **3**  
Dielectric Strength kV/mm **18 kV/mm**  
Dissipation Factor @ 1kHz **0.0025**  
Surface Resistivity ohms **1.36E+15 ohms**  
Volume Resistivity ohms cm **8.7E+15 ohms cm**

### Test Method

CFR (21) 177.2600

ASTM D 2240-95

ISO 37

AFS\_1540B

BS ISO 2781

BS ISO 34-1

ISO 37

ASTM D-150

ASTM D-149

ASTM D-150

ASTM D-257

ASTM D-257

### Value

**Translucent Paste**

**Oxime**

**390 g/min**

**No**

**12 hrs**

**Paste**

**Yes**

**5 mins**

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