

AS1621

1 Part RTV silicone adhesive sealant self levelling

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

- Good adhesion to most substrates
- Low corrosive
- Excellent self-levelling and flow characteristics

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.

Revision Date : 02/11/2017

Download Date : 22/01/2019

Property

Uncured product

50g Spread Diameter mm

Appearance

Cure Type

Extrusion Rate g/min

FDA

Max Cure Hrs @ 25 °C

Rheology

Self Bonding

Tack Free Time mins

Viscosity A-Part mPas

Test Method

CFR (21)
177.2600

Brookfield

ASTM D 2240-95

ISO 37

AFS_1540B

BS ISO 2781

BS ISO 34-1

ISO 37

Cured product

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

CTE Linear ppm/°C

CTE Volumetric ppm/°C

Colour

Duro Shore A

Elongation %

Linear Shrinkage %

Max Working Temp +°C

Min Working Temp - °C

Modulus @ 100% Strain MPa

Modulus Youngs MPa

SG

Tear kN/m

Tensile MPa

Thermal Conductivity W/mK

UL 94V-0

Value

145 mm

White viscous liquid

Oxime

834 g/min

No

24 hrs

Flowable

Yes

19 mins

24000 mPas

306 ppm/°C

920 ppm/°C

White

24

410 %

1 %

230 °C

-50 °C

0.36 MPa

0.56 MPa

1.05

3.3 kN/m

2 MPa

0.2 W/mK

No

Storage

Max storage temperature °C

Shelf life

40 °C

12 mths

Electrical properties

Dielectric Constant @ 1kHz ASTM D-150

Dielectric Strength kV/mm ASTM D-149

Dissipation Factor @ 1kHz ASTM D-150

Surface Resistivity ohms ASTM D-257

Volume Resistivity ohms cm ASTM D-257

2.6

>18 kV/mm

0.001

7.5E+15 ohms

1E+16 ohms cm

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