

Dow Corning® Silicone AP Adhesive/Sealant

FEATURES

- One-component adhesive/sealant
- Cures at room temperature when exposed to moisture in the air
- Acetoxy cure system
- Non-sag, paste consistency
- Easy to apply
- Good adhesion to many substrates
- Stable and flexible from -50°C (-58°F) to +180°C (+356°F)

General purpose silicone adhesive/sealant

APPLICATIONS

- General industrial sealing, gasketing and bonding applications.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

CTM*	ASTM**	Property	Unit	Result
		As supplied		
0176		Appearance		Non-slump paste
		Colors		Clear, white, gray, black
0364		Extrusion rate, 3mm orifice at 0.62MPa	g/min	450
0098		Skin-over time	minutes	11
0095	MIL-S-8802F	Tack-free time	minutes	21
		Mechanical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity		
0022	D 792	Specific gravity		1.03
0099	D2240	Durometer hardness, Shore A		25
0137A	D412	Tensile strength	MPa	2.2
0137A	D412	Elongation at break	%	540

*CTM: Corporate Test Method, copies of CTMs are available on request.

**ASTM: American Society for Testing and Materials.

HOW TO USE

Substrate preparation

All surfaces must be clean and dry. Degrease and wash off any contaminants that could impair adhesion. Suitable solvents include isopropyl alcohol, acetone or methyl ethyl ketone.

Unprimed adhesion may be obtained on many substrates such as glass, metals and most common engineering plastics. Substrates to which good adhesion is normally not obtained include PTFE, polyethylene, polypropylene and related materials.

For maximum adhesion, the use of *Dow Corning*® 1200 OS Primer is recommended. After solvent cleaning, a thin coat of *Dow Corning* 1200 OS Primer is applied by dipping, brushing or spraying. Allow primer to dry for 15 to 90 minutes at room temperature and in a relative humidity of 50% or higher.

How to apply

Apply a bead of *Dow Corning*® Silicone AP Adhesive/Sealant (see Handling Precautions) to one of the prepared surfaces, then quickly cover with the other substrate to be bonded.

On exposure to moisture, the freshly applied material will "skin-over" in about 11 minutes at room temperature and 50% relative humidity. Any tooling should be completed before this skin forms. The surface is easily tooled with a spatula. The adhesive/sealant will be tack-free in about 21 minutes.

Cure time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) *Dow Corning Silicone AP Adhesive/Sealant* will cure to a depth of about 3mm. Very deep sections, especially when access to atmospheric moisture is restricted, will take longer to cure completely. Cure time is extended at lower humidity levels.

Before handling and packaging bonded components, users are advised to wait a sufficiently long time to ensure that the integrity of the adhesive seal is not affected. This will depend on many factors and should be determined by the users for a specific application.

Compatibility

Dow Corning Silicone AP Adhesive/Sealant releases a small amount of acetic acid during cure. This may cause corrosion on some metallic parts or substrates, especially in direct contact or when the cure is carried out in a totally enclosed configuration which would not allow cure byproducts to escape.

HANDLING PRECAUTIONS

Product safety information required for safe use is not included. Before handling, read product and safety data sheets and container labels for safe use, physical and health hazard information. The material safety data sheet is available on the

Dow Corning Web site at dowcorning.com. You can also obtain a copy from your local Dow Corning sales representative or Distributor or by calling your local Dow Corning Global Connection.

STORAGE

Product should be stored at or below 32°C (90°F) in original, unopened containers. The most up-to-date shelf life information can be found on the XIAMETER Web site in the Product Detail page under Sales Specification.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support Customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our Web site, dowcorning.com or consult your local Dow Corning representative.

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended

end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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