

ONE COMPONENT FLOWABLE HIGH STRENGTH SILICONE ADHESIVE/SEALANT

Product Description IS5628E one-component, ready-to-use, adhesive/sealant is a flowable consistency product specially developed for applications where high strength is required. On exposure to atmospheric moisture at room temperature this product cures to a very tough, durable, resilient silicone rubber. IS5628E utilizes an acetoxycure system, releasing small amounts of acetic acid vapours from the sealant during cure.

Key Performance Properties

- One-component, no mixing, easy-to-use
- Flowable
- Room temperature condensation cure
- Very high strength
- High and low temperature resistance (-60°C to +200°C)
- Excellent adhesion to silicone rubbers

Applications

- Bonding silicone HCR gaskets together
- Seam sealer
- Bonding silicone coated fabric.

Typical Product Data

Typical uncured Properties		
Appearance	Translucent, flowable	
Viscosity at 23°C,	Pa·s	175
Tack-free Time at 23°C	Minutes	10
Selfleveling	mm	75
Typical cured Properties (3 days @ 20°C / 50% RH)		
Appearance	translucent elastomeric rubber	
Density	g/cm ³	1.10
Hardness	Shore	33A
Tensile strength	MPa	7.5
Elongation	%	750
Tear strength	kN/m	15

Specifications Typical product data values should not be used as specifications. Assistance and specifications are available by contacting Momentive performance materials Technical Service RTV1 and RTV2.

Instructions for Use

Surface Preparation

IS5628E will bond to clean surfaces without the aid of primers. These surfaces typically include many metals, glass, ceramic, and silicone rubber. A preliminary check should be made to determine bonding effects for each specific application. For difficult-to-bond substrates, use of a primer will usually improve adhesion. Momentive performance materials silicone primers SS4004P, SS4044P and SS4179 are recommended for use with this adhesive/sealant.

Where adhesion is required, surfaces should be thoroughly cleaned with a suitable solvent such as iso propylalcohol (IPA) or methyl ethyl ketone (MEK) to remove dirt, oil and grease. The surface should be wiped dry before applying the adhesive/sealant.

Momentive performance materials Silicone IS5628E adhesive/sealant may be applied directly to clean substrate. Where broad surfaces are to be mated, sealant should be applied in a thin, less than 6 mm diameter, bead or ribbon around the edge of the surface to be bonded.

RTV adhesive/ sealants cure on exposure to moisture in the air at room temperature. The cure begins with the formation of a skin on the exposed surface of the sealant and progresses inward through the material. At 25°C and 50% relative humidity, this product will form a surface skin, which is tack free to the touch in 10 minutes. Once a skin has begun to form, further tooling of the adhesive is not advisable. High temperatures up to 70°C and high humidity will accelerate the cure process; low temperatures and low humidity will slow down the cure. During the initial stages of cure, a noticeable odour caused by the liberation of the acetic acid vapour is produced. This odour will totally disappear as the cure progresses

A 2 mm section of adhesive/sealant will cure through in 24 hours. Since cure time increases with thickness, use of IS5628E should be limited to section thicknesses of 6 mm.

For removing uncured adhesive/ sealants, solvent systems such as naphtha, methyl ethyl ketone (MEK) or trichloroethylene (TCE) are most effective.

After cure, selected chemical strippers, which will dissolve the silicone rubber, are available from other manufacturers. Specific product information may be obtained on request.

Handling and Safety

Material Safety Data Sheets are available upon request from Momentive performance materials. Similar information for solvents and other chemicals used with the Momentive performance materials products should be obtained from your supplier. When solvents are used, proper safety precautions must be observed.

Storage and Warranty Period

The shelf life will be indicated by the 'use before date' on the associated documents with a minimum of 4 months when stored in the original unopened containers below 27°C.

Availability

IS5628E is available in 310 ml cartridges, 20 kg pails and in 200 kg drums.