

## AS1504

### Characterization

AS1504 is a 1-part, RTV 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 form -50 to +300°C
- Good electrical insulation properties
- Excellent adhesion to most substrates

### Technical Data

	AS1504		
	Mixture		
Cure Type	Acetoxy		
FDA	No		CFR (21) 177.2600
Max Cure @ 25°C	7	h	
Rheology	Paste		
Extrusion Rate	255	g/min	
Self Bonding	Yes		
Tack Free Time	4	min	
Colour	Red		
Cured product	After 7 days cure at 23°C +/- 2°C and 50% +/-5% humidity		
CTE Linear	294	ppm/°C	
CTE Volumetric	882	ppm/°C	
Duro Shore A	35		ASTM D 2240-95
Working Temp.	-50 - 300	°C	AFS_1540B
Tensile	2.5	MPa	ISO 37
Elongation	410	%	ISO 37
Modulus Youngs	0.71	MPa	
Modulus @ 100% Strain	0.98	MPa	
Tear	6.3	kN/m	
Linear Shrinkage	0.8	%	

<b>SG</b>	1.09		BS ISO 2781
<b>Thermal Conductivity</b>	0.2	W/m*K]	
<b>UL 94V-0</b>	No	ppm]	
	<b>Electrical properties</b>		
<b>Dielectric Constant</b>	2.68	1kHz	ASTM D-150
<b>Dielectric Strenght</b>	>18	kV/mm	ASTM D-149
<b>Dissipation Factor</b>	0.002	1kHz	ASTM D-150
<b>Surface Resistivity</b>	4.04E+14	Ohm	ASTM D-257
<b>Volume Resistivity</b>	3.95E+15	Ohms*cm	ASTM D-257
	<b>Adhesion testing</b>		
<b>Lap Shear 304 kg/cm<sup>2</sup> Stainless Steel</b>	5	kg/cm <sup>2</sup>	ASTM D1002

## Storability / Storage

With a proper storage the product will hold for approx. 24 months if stored max. at 40°C and protected from frost in a dry place in closed original containers.

The above given values are product describing data. Please consult the 'delivery specification' for binding product specifications. Further data about product properties, toxicological, ecological data as well as data relevant to safety can be found in the safety data sheet.

## Application Technique

### Processing

AS1504 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 the product 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 above. For optimum bond strength, the thickness of the sealant joint should be at least 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.

**It is absolutely important to check the compatibility in preliminary tests if unknown substrates are used.**

## **Safety**

Please observe our EC safety data sheets and the safety remarks on our container labels when handling our products. The dangerous goods regulations and the accident prevention regulations of the professional associations must be particularly observed. Keep the EC safety data sheet of the applied product at hand since it provides you with useful instructions for the safe use and disposal of the product as well as for actions to be taken in case of accidents.

**We reserve the right to modify the product and technical leaflet.**

**Our department for applied technique is always at your service for further information and advice.**

Our technical advice and recommendations given verbally, in writing or by trials are believed to be correct. They are neither binding with regard to possible rights of third parties nor do they exempt you from your task of examining the suitability of our products for the intended use. We cannot accept any responsibility for application and processing methods which are beyond our control.

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