AS1623

Characterization

AS1623 is a 1-part, RTV 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 and its associated alloys.

Key Features:

-High temperature resistance to 260°C

-High temperature 315°C intermittent

-Excellent flow and self-levelling properties

-Good adhesion to substrates

Technical Data

	AS1623		
Viscosity	6.000	mPas	Brookfield
	Mixture		
Cure Type	Oxime		
FDA	No		CFR (21] 177.2600
Max Cure @ 25°C	24	h	
Spread Diameter (50g)	170	mm	
Rheology	Flowable		
Self Bonding	Yes		
Tack Free Time	19	min	
Colour	Red		
Cured product	**After 7 days cure at 23°C +/- 2°C and 50% +/-5% humidity**		
CTE Linear	300	ppm/°C	
CTE Volumetric	902	ppm/°C	
Duro Shore A	24		ASTM D 2240-95
Working Temp.	-65 – 260	°C	AFS_1540B
Tensile	1.2	MPa	ISO 37
Elongation	180	%	ISO 37
SG	1.08		BS ISO 2781
Thermal Conductivity	0.2	W/mK	

UL 94V-0	No	ppm	
	Electrical properties		
Volume Resistivity	>1E+13	Ohm*cm	ASTM D-257

Storability / Storage

With a proper storage the product will hold for approx. 9 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

AS1623 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.

Edition: July 2019
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