Technical Data Sheet

AS1604 (1050N)
1 Part low corrosive matt thixtropic adhesive sealant

Introduction

AS1604 is a fast cure 1-part RTV silicone sealant specially formulated for applications requiring a combination of good adhesion, excellent physical and non-corrosive properties. The Oxime based cure system produces excellent physical properties and good adhesion particularly to plastics and many other substrates. Although not totally neutral the cured sealant is very low corrosive in nature.

Key Features

- Resistant to fuels
- Low Corrosive
- Good Primerless adhesion

Use and Cure Information

How to Use

AS1604 is ready for use. If supplied in cartridges it can be applied using either manual or pneumatic dispensers.
It can also be applied from bulk containers using conventional drum dispensing equipment.

Application and Cure

All surfaces to which **AS1604** is to be applied should be clean, dry and free from grease, dirt, and loose material.
Priming of surfaces is not normally required.
If it is being employed as an adhesive, it should be applied to one clean surface and the other clean surface brought into contact with it within 30 to 60 seconds.
The recommended thickness of the sealant joint is 1 to 3mm for optimum bond strength.
Joints should be left undisturbed for at least 24 hours, but preferably longer to effect sufficient depth of cure. Full cure requires 7 days.

Revision date 12/12/2005

Property	Test Method	Value
Uncured Product		
Colour:		**Black**
Appearance:		**Black paste**
Tack Free Time:		**3 minutes ***
3mm Cure Through:		**<12 hours ***
Extrusion Rate:		**260 g / minute**
* measured at 23+/-2°C and 65% relative humidity.		
Cured Elastomer		
(after 7 days cure at 23+/-2°C and 65% relative humidity)		
Tensile Strength:	BS903 Part A2	**2.00 MPa**
Elongation at Break:	BS903 Part A2	**250 %**
Youngs Modulus:		**0.50 MPa**
Modulus at 100% Strain:	BS903 Part A2	**1.15 MPa**
Tear Strength:	BS903 Part A3	**7.0 kN/m**
Hardness:	ASTM D 2240-95	**50° Shore A**
Specific Gravity:	BS 903 Part A1	**1.4**
Linear Shrinkage:		**0.8%**
Thermal Conductivity:		**0.30 W/mK**
Coefficient of Thermal Expansion:		
Volumetric		**837 ppm / °C**
Linear		**279 ppm / °C**
Min. Service Temperature:		**-50 °C**
Max. Service Temperature:	AMB-035	**240 °C**

Electrical Properties

Volume Resistivity:	ASTM D-257	**6.6E+15 Ω.cm**
Dielectric Constant at 1MHz:	ASTM D-150	**3.00**
Dissipation Factor at 1MHz:	ASTM D-150	**2.5E-+3**

Adhesion Testing

Overlap Shear Strength:	ASTM D 1002	kg/cm^2

Customers are advised to carry out their own tests on clean, degreased substrates to ensure satisfactory adhesion is achieved

All values are typical and should not be accepted as a specification.

Health and Safety – Material Safety Data sheets available on request.

Packages – 310 ml cartridges. Arrangements can be made to supply in bulk containers.

Storage and Shelf Life – Expected to be **12** months in original, unopened containers below 40°C.

ACC Silicones Ltd, Amber House,
Showground Road, Bridgwater, Somerset, UK
Tel. +44(0)1278 411400 Fax. +44(0)1278 411444

Treco S.R.L., Via Romagna N.8,
20098 Sesto Ulteriano (MI), Italia.
Tel. 39/02/9880913 Fax. +39/02/98280413

www.acc-silicones.com