



US-HS-327

High Strength, Fast Cure Silicone Adhesive Sealant

US-HS-327 is a fast curing, high strength, acetoxysilicone RTV adhesive rubber engineered for applications requiring fast development of physical properties and excellent adhesion. This is a 1-Part silicone that when applied to the substrate allows handling of the bonded assembly within minutes. Works well in manual and automatic dispensing equipment.

Product Features

- Fast Room Temperature cure
- Thixotropic paste
- Excellent unprimed adhesion to metals and glass
- Temperature range -45°C to 260°C

Color: Transparent (custom colors available upon request)

Typical Applications

- Assembly line adhesive
- Form in place gaskets
- Adhesive sealant

Typical Properties

Uncured:

Viscosity, cps: 500,000 Specific Gravity: 1.07 Consistency : thixotropic paste
 Working time, mins: 4 Tack Free Time, mins: 12
 Application Rate, 90 PSI, g/min: 250 (3mm orifice at 0.6 MPa)

BOTH Cured - Room Temperature:

Physical Properties	Tensile Strength, PSI: 600	Elongation, %: 700
	Durometer, Shore A: 34	Dielectric Strength, V/mil: >500
	Dielectric Constant: 2.8	Dissipation Factor: 0.001
	Thermal conductivity: 0.0005	

Method Of Application

Dispense sealant onto part and mate parts. Do not squeeze all of the product out of flange assembly. Allow to cure.

Heat Accelerated Curing

Typical utilization involves dispensing in open air and ambient humidity to result in a high strength adhesive rubber. However, cure speed can be accelerated with hot air to nearly instant cures exhibiting very fast adhesion. A one minute hot air stream exposure, followed by a one minute cool down in a humid environment, results in cured elastomer exhibiting outstanding adhesion.

Packaging: Available in 2.8 & 5.5oz squeeze tubes, 6.25oz sem kit cartridges, 10.3 oz. cartridges, 40 lb. pails and 400 lb. drums. This product is also available in customer defined packaging sizes upon request.

Chemical cure system: Acetoxysilicone cure system

Solids: 98% solids, contains no solvents

Service Temperature: -45°C to 260°C

Adhesion: Primerless adhesion to silicone rubber parts.

Limitations: Allow sealant to fully cure before putting assembly into service. Ensure enough product remains between flanges to be effective in an assembly.

Handling and safety: For maximum shelf life, keep containers sealed when not in use. Keep out of the reach of children. Uncured sealant irritates eyes and skin. Refer to MSDS.

Shelf-life: Sealed containers guaranteed for 1 year from the ship date when stored in a cool dry area below 70°F.