Technical Data Sheet

AS1525 (ESP554-3)
One part flowable acetoxy silicone adhesive

Introduction

AS1525 is a ready-to-use adhesive sealant, which reacts with atmospheric moisture to form a resilient rubber, which remains flexible over a very wide temperature range.

AS1525 liberates a very small amount of acetic acid during cure which gives rise to the familiar "vinegar" odour, which quickly dissipates after cure.

These high specification sealants are ideal for a myriad of engineering applications from production work to fast, effective maintenance and on-the-spot repairs. They are applied directly from the cartridge and cure at room temperature. Under typical ambient conditions they develop a tack free surface in approximately 15 minutes and cure within 24 hours.

Key Features

- **Controlled flow to prevent fabric strike-through**
- **Fast cure through**
- **Specifically formulated for the textile industry**

Use and Cure Information

How to Use

AS1525 is ready for use. It can be applied from bulk containers using conventional drum dispensing equipment

Application and Cure

All surfaces to which the adhesive is to be applied should be clean, dry and free from grease, dirt, and loose material.
Priming of surfaces is not normally required.
If being employed as an adhesive, it should be applied to one clean surface and the other clean surface brought into contact with it within 5 minutes.
For optimum bond strength the thickness of the sealant joint is 1 to 2 mm.
Joints should be left undisturbed for at least 24 hours, but preferably longer to effect sufficient depth of cure. Full cure requires 7 days.
Accelerated curing can be achieved with the exposure to high humidity and increased temperature, the optimum environment for fast cure is 100% humidity and 75°C temperature. AS1525 has been specifically formulated for use in the textile industry; the ingredients in fully cured AS1525 are not known to cause irritation to the human skin.

Property	Test Method	Value
Uncured Product		
Colour:		**Translucent**
Appearance:		**Viscous liquid**
Tack Free Time:		**7 minutes ***
3mm Cure Through:		**<24 hours***
Viscosity		**60000 mPas**
* measured at 23+/-2°C and 55 - 65% relative humidity.		
Cured Elastomer		
(after 7 days cure at 23+/-2°C and 55-65% relative humidity)		
Tensile Strength:	BS903 Part A2	**1.00 MPa**
Elongation at Break:	BS903 Part A2	**190 %**
Youngs Modulus:		**0.35 MPa**
Modulus at 100% Strain:	BS903 Part A2	**0.50 MPa**
Hardness:	ASTM D 2240-95	**30 Shore A**
Specific Gravity:	BS 903 Part A1	**1.01**
Coefficient of Thermal Expansion:		
Volumetric		**892 ppm / °C**
Linear		**297** ppm / °C
Min. Service Temperature:		**-50 °C**
Max. Service Temperature:	AFS 1540B	**250 °C**

Electrical Properties

Volume Resistivity:	ASTM D-257	**1.4E+15 Ω.cm**

Adhesion Testing

Good unprimed adhesion to many substrates including glass stainless steel, aluminium and most plastics.
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 – 20 kg pails. Arrangements can be made to supply in alternative packaging, please discuss with your Regional Sales Manager.

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

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