

AS2500 (RTV330) 1-Part Adhesive Sealants

Introduction

AS2500 is a novel twin pack cartridge, or bulk system, which consists of a top quality acetoxy 1-Part RTV Silicone Sealant and an accelerator in a 10 : 1 ratio. By extruding the system through a static mixer nozzle, the intimately mixed system behaves like a conventional silicone sealant, but has the advantage of very rapid cure - less than 3 hours to almost full cure.

Key Features

- fast assembly
- good adhesion
- low odour - considerable reduction in acetic acid evolution
- will cure anaerobically in approximately 2 hours (not possible with conventional 1-Part RTV sealants)
- similar physical properties to the conventional sealant

Use and Cure Information

How to Use

AS2500 is supplied in a high quality twin cartridge system, the principle component in a 240 ml cartridge and the accelerator in a 24 ml integral cartridge.

To facilitate removal of the nose plug a metal removable disc is located above the locking nut. The simple act of unscrewing the locking nut removes the nose plug. A static mixer nozzle is placed on the outlet and locked into place with the locking nut. (13mm).

The stepped outlet of the static mixer nozzle is normally cut back 2 or 3 steps before fitting the cartridge into the gun dispenser.*

The cartridge is located in the gun and pressed to click into place.

Application and Cure

The sealant system is extruded by applying a steady pressure to the trigger. In the case of the manually operated dispenser, full depression of the trigger should be maintained as long as possible before release and reapplying trigger pressure.

Complete mixing of each component is achieved within the first 50-60% of the nozzle. The extruded sealant should be applied to the job in hand immediately and tooled within 1 minute of application.

The sealant will be tack-free within 10 minutes and almost fully cured within 1 hour, depending on the joint dimensions.

* Excellent dual cartridge dispensers both manual and pneumatic are available from Metix (UK) Limited - they are described as Mixpac^R 200 Dispensers.

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Property

Uncured Product

Colour:	Black
Appearance:	Thixotropic paste
Tack Free Time:	4 minutes *
3mm Cure Through:	1.5 hours *
Extrusion Rate:	304g / 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	2.32 MPa
Elongation at Break:	BS903 Part A2	280 %
Youngs Modulus:		0.65 MPa
Modulus at 100% Strain:	BS903 Part A2	0.91 MPa
Tear Strength:	BS903 Part A3	5.50k N/m
Hardness:	ASTM D 2240-95	39° Shore A
Specific Gravity:	BS 903 Part A1	1.05
Linear Shrinkage:		<1.0%
Thermal Conductivity:		0.20 W/mK
Coefficient of Thermal Expansion:		
Volumetric Linear		876 ppm / °C
Linear		292 ppm / °C
Min. Service Temperature:		-50 °C
Max. Service Temperature:	AFS 1540B	250 °C

Electrical Properties

Volume Resistivity:	ASTM D-257	4.70x10 ¹⁴ Ω.cm
Surface Resistivity:	ASTM D-257	7.77x10 ¹⁵ Ω
Dielectric Strength:	ASTM D-149	18 kV/mm
Dielectric Constant at 1MHz:	ASTM D-150	3.0
Dissipation Factor at 1MHz:	ASTM D-150	2.5x10 ⁻³

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 – 265ml cartridges.

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

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