



## US-HS-324

### High Strength, Fast Cure Silicone Adhesive Sealant

**US-HS-324** 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 -40C to +260C

**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: 1.05 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:**

Tensile Strength, PSI: 325  
Elongation, %: 325  
Durometer, Shore A: 30  
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.