

LIQUIDWELD™ SA398

Sprayable Silicone Adhesive

Product Description

LIQUIDWELD™ SA398 is a one-component, heat curable silicone adhesive designed for spraying. The Adhesive has a long pot life of 6 to 8 hours or longer and works well in manual or automated dispensing equipment. Despite the long work-life the product sets rapidly with heat. The cured silicone adhesive has excellent mechanical properties and bonds silicone rubbers to other silicone rubbers as well as to aluminum, steel, other types of rubber, and many plastics.

Key Features

- Sprayable
- Dries rapidly to a tacky state
- Fast heat cure
- Excellent Adhesion to many different many materials

Main Applications

- Bonds silicone rubber to itself and other surfaces
- Primer for Silicone Rubbers, urethanes, and other thermosetting polymers to plastics, rubbers, and metals

Typical Properties

UNCURED PROPERTIES	
Parameter	
Appearance	Semi-translucent to translucent liquid
Viscosity at 25°C	125 cps
Specific Gravity	0.88 – 0.94

CURED PROPERTIES: (cured 5 minutes at 150°C)	
Specific Gravity	~1.02
Color	Translucent
Shore 00 Hardness	30 - 60
Tensile Strength	240 psi
Tensile Elongation	300%

TYPICAL CURING CONDITIONS:

Can be cured from 65°C (150°F) to 150°C (~300°F). Curing rate will depend on coating thickness and temperature. It will also depend on how much solvent evaporation has occurred during spraying, so the application equipment and details like spraying pressure may have some effect on the curing rate.

As a general guide-lines the suggested curing times below are the minimum times suggested for a 1mm thick layer spray applied and then heat cured:

65°C / (150°F): 20 - 30 minutes

80°C / (176°F): 15 - 20 minutes

95°C / (203°F): 10 - 14 minutes

120°C / (248°F): 5 - 8 minutes

Thicker layers will require a longer curing times. The bonded parts may take up to 24-48 hours after the heat cure is complete to develop their full strength but should have a significant majority of their final strength after heat curing and cooling back to room temperature.

Note: the information above is not for Product Specification Purposes – these are typical values. Please contact us for assistance in writing purchasing specifications.

Please Note: This is a platinum cure system product. The catalyst can be deactivated by exposure to sulfur containing compounds like thiols, sulfides, sulfates, organic rubbers containing sulfur, nitrogen containing compounds like amines, amides, imides, azides, tin metals or compounds, or tin cured RTVs.

Shelf-life and Storage

LIQUIDWELD™ SA398 should be stored in its original, sealed containers in an environment that does not exceed 26.7°C (80°F). Avoid exposure to acids, bases and oxidizers as these may generate flammable vapors. Under these conditions the expected shelf-life of the material is a minimum of 6 months from date of shipment at room temperature. It may be possible to extend the shelf-life using refrigerated storage.

FIRST AID

In case of contact:

Skin – Immediately wash skin thoroughly with mild soap and water. Remove contaminated clothing and wash before reuse. Destroy contaminated shoes and other articles made of leather.

Eyes – Immediately flush eyes with plenty of water for 15 minutes and get prompt medical attention.

Inhalation - Remove person to fresh air. Administer oxygen or artificial respiration if necessary. Call a physician.

Ingestion - Do not induce vomiting. Dilute with plenty of water and contact physician immediately. Never give anything by mouth to an unconscious person.

DISCLAIMER:

IMPORTANT: The following supercedes Buyer's documents. **SELLER / MANUFACTURER MAKES NO REPRESENTATION OR WARRANTY, EXPRESS OR IMPLIED, INCLUDING OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** No statements herein are to be construed as inducements to infringe any relevant patent. Under no circumstances shall Seller / Manufacturer be liable for incidental, consequential or indirect damages for alleged negligence, breach of warranty, strict liability, tort or contract arising in connection with the product(s). Buyer's sole remedy and Seller's sole liability for any claims shall be Buyer's purchase price. Data and results presented are based on controlled or laboratory work and must be confirmed by Buyer by testing for its intended conditions of use. The product(s) has not been tested for, and is therefore not recommended for, uses for which prolonged contact with mucous membranes, abraded skin, or blood is intended; or for uses for which implantation within the human body is intended

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