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DATA SHEET

## Fortafix High Temperature Adhesives

### **Product: HT FLEXSEAL 350 – FORTAFIX RTV SILICONE SEALANT/ ADHESIVE**

#### **Principal Characteristics**

**Flexible elastomeric adhesive sealant to 350°C. Bonds to a wide range of substrate materials.**

HT Flexseal 350 is a Temperature Rated Silicone Adhesive and Sealant used for applications where sealing or fixing a wide range of materials is required - to form a high heat resistant joint or bond.

Non-slump paste.

Maximum Service Temperature: 350°C.

Resistant to weathering and ageing – can be used externally

Resistant to oxidation and many oils, chemicals, and solvents

Suitable for: bonding, gasketing, thick sections, potting & encapsulation.

Suitable for: fixing of materials with different thermal expansion characteristics.

Excellent adhesion - Product offers adhesion to many material substrates - including glass and other glazed surfaces, PVCu, metals, wood and concrete.

#### **Typical Applications**

- Flues
- Ducting
- Electrical Insulation
- Fixing Ceramic Rope
- Gasketing
- Jointing Metals, Glass, Ceramics and Polymers

#### **Health and Safety / Environmental Information**

- See separate MSDS sheet. (MSDS – HT Flexseal 350 RTV Silicone Sealant/ Adhesive).
- RoHS Compliant.

#### **Storage**

Once opened this product is moisture sensitive avoid continuous exposure to air.

Product should be stored in original packaging between 5 - 30°C.

Shelf life – 24 months.

## Guidelines for Use

### Application

Thoroughly clean and degrease surfaces to be bonded or sealed.

A light surface abrasion of the material to be bonded will increase the surface area available for adhesion and improve mechanical key.

Apply the sealant as supplied to all surfaces to be bonded and complete tooling within 5-10 minutes.

Apply moderate pressure to ensure even anchorage and solid contact of the surfaces to be bonded, so that all surfaces are fully wetted.

Clean any unwanted silicone immediately using xylene and a cloth.

Curing starts at the surface and works inward.

Humidity and ambient temperature can alter curing rate.

### Curing Schedule

The curing of this product may vary depending on temperature, humidity, porosity of substrates, glue line thickness and area etc.

A rough guide for typical applications at room temperature and average humidity would be approximately 36-48 hours.

Typical rate of cure: 3-5 mm depth per 24 hours

Typical maximum cure depth: 10 mm

Once cured, the strength of the silicone will continue to increase for up to 7 days.

Curing may be accelerated by the application of gentle heat (do not exceed 70°C).

### VOC Content.

1.1 % (weight percent) of components (11 g/l) considered VOC under the:

DIRECTIVE 2010/75/EU OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 24 November 2010 on industrial emissions (integrated pollution prevention and control) repealing European Council Directive 1999/13/EC with effect from 7 January 2014.

1.5 % (weight percent) of components (16 g/l) considered VOC under the:

DIRECTIVE 2004/42/CE OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 21 April 2004 on the limitation of emissions of volatile organic compounds due to the use of organic solvents in certain paints and varnishes and vehicle refinishing products.

*These VOC assessments are based on the theoretical evaluation of the information provided by our suppliers and the knowledge of our materials. Please note that since we do not specifically analyse our products for total VOC content we cannot guarantee or warrant specific limits.*



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### Characteristics:

#### Uncured Product:

Property	Test Method	Value
Colour		Brick Red
Consistency		Non-slump paste
Cross Linking System		Acetoxy
Specific Gravity (DIN 53479)		1.28 g/ml
Solids Content		100%
Extrusion Rate 3mm orifice @ 60 psi		78 g/minute
Skin Forming Time at 23°C/50% RH		15 minutes
Cure Rate @ 25°C and 60% RH		3mm per 24 hours

#### Cured Product:

Property	Test Method	Value
Tensile Strength	DIN 53505, S3A	1.4 N/mm <sup>2</sup>
Elongation @ Break	DIN 53504, S3A	420%
E Modulus @ 100% Elongation	DIN 53504, S3A	0.6 N/mm <sup>2</sup>
Hardness Shore A	DIN 53505	43°
Tear Strength	ASTM D 624, Form B	7 N/mm <sup>2</sup>
Shrinkage	DIN 53504, S3A	3%
Typical temperature Range		-50° to 300°C
Ignition Temperature DIN 51794		460°C