



DATA SHEET

Fortafix High Temperature Adhesives

Interim Data Sheet:

HT BONDFLOW 300 – FORTAFIX RTV SILCONE SEALANT/ ADHESIVE

- Low viscosity liquid
- A pourable/paintable High Temperature Resistant RTV Silicone based sealant/adhesive, based on Fortafix HT Flexseal 300.
- Designed for use where a flexible bond is required together with high temperature resistance.
- Excellent adhesion between most substrates.
- Suitable for sealing and jointing materials of different thermal expansions
- A maximum continuous operating temperature of 300°C, when fully cured.

Typically Used For

- Jointing Metals, Glass, Ceramics and Polymers
- Gasketing
- Protective Surface Coatings

Principal Characteristics

- Ready to use.
- Pourable liquid - Black Colour
- Maximum Continuous Service Temperature: 300°C.
- Resistant to weathering and ageing – can be used externally.
- Product will exhibit some shrinkage on curing (30% - 50%)
- Maximum cure depth: 10 mm
- Fair/average resistance to mineral oils

Max. Continuous Temperature	300°C	Min. Continuous Temperature	- 60°C	Wet Density	0.95 g/cm ⁻³
Coverage Rate		Shrinkage	30% - 50%	Tensile Strength	2.00 MPa
Modulus @ elongation	0.94 MPa	Elongation at Break	250%	Packaging	5 litre can

Health and Safety / Environmental Information

- See separate MSDS sheet. (MSDS – HT BondFlow 300 RTV Silicone Sealant/ Adhesive).
- RoHS Compliant.

Guidelines for Use

Application – Concrete Joint Sealant

- Ensure all concrete surfaces to be sealed/jointed are clean with a good surface texture.
- Ensure all concrete surfaces to be sealed/jointed are free from surface laitance, oil based release agents, surface dust etc
- Stir product thoroughly before using
- Pour the sealant to a maximum depth of 10 mm
- Protect the joint from freezing and the ingress of excessive moisture (e.g. rain)
- Allow to fully cure (typically allow 3-4 days, although cold weather will extend this period)
- Assess extent of cure of joint – use sharp point or needle, and ensure adhesive film is fully cured through
- Assess shrinkage and calculate amount of Bondflow HT300 required for next application
- Continue as described above until joint is fully sealed
- Clean any unwanted silicone immediately using xylene and a cloth.
- Always work in a well-ventilated area.

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.
- Curing starts at the surface and works inward
- Humidity and ambient temperature can alter curing rate
- Rate and depth of cure is typically 3-4 mm per 24 hours, to a maximum depth of 10 mm
- Once cured, the strength of the silicone will continue to increase for up to 7 days.

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 – 12 months.