



## DATA SHEET

### Fortafix High Temperature Adhesives

#### Interim Data Sheet:

#### HT BONDFLOW 350 – FORTAFIX RTV SILCONE SEALANT/ ADHESIVE

- Low viscosity liquid
- A pourable/paintable High Temperature Resistant RTV Silicone based sealant/adhesive, based on Fortafix HT Flexseal 350.
- 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 operating temperature of 350°C, when fully cured.

#### Typically Used For

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

#### Principal Characteristics

- Ready to use.
- Pourable liquid - Red Colour
- Maximum Service Temperature: 350°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

<b>Max. Temperature</b>	350°C	<b>Min. Continuous Temperature</b>	- 60°C	<b>Wet Density</b>	0.95 g/cm <sup>-3</sup>
<b>Coverage Rate</b>		<b>Shrinkage</b>	30% - 50%	<b>Tensile Strength</b>	2.00 MPa
<b>Modulus @ elongation</b>	0.94 MPa	<b>Elongation at Break</b>	250%	<b>Packaging</b>	5 litre can

## Health and Safety / Environmental Information

- See separate MSDS sheet. (MSDS – HT BondFlow 350 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 HT350 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.