



## Technical Data Sheet

### DOWSIL™ HM-2520 Assembly Sealant

Hot melt silicone assembly sealant

#### Features & Benefits

- Instant green strength
- 100% silicone
- Low VOC (VOC exempt in CA)
- Safe to handle – nonhazardous composition and by-products
- Neutral cure
- Adheres to most common substrates
- Open time up to 15 minutes
- Pot life up to 24 hours
- Translucent Clear
- Service temperatures from -50° to 300°F (-45° to 150°C)
- Can be used with standard hot melt dispensing equipment
- High tensile strength
- Immediate green strength allows parts to be moved immediately
- Long open time, pot life and moderate application temperature (250°F (121°C)) offer a user-friendly application
- High viscosity at room temperature resists flow of material reducing sealant squeeze out and clean-up

#### Composition

- Moisture curing, 100 percent silicone, reactive hot-melt sealant

#### Applications

- DOWSIL™ HM-2520 Assembly Sealant is designed for use as an assembly sealant. This product utilizes hot melt technology to dispense the material which utilizes silicone technology to achieve instant green strength when dispensed and cures to strong moisture cured silicone sealant.

#### Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

| CMT <sup>1</sup> | ASTM <sup>2</sup> | Property                     | Unit    | Result |
|------------------|-------------------|------------------------------|---------|--------|
| 0719             |                   | Viscosity at 248°F (120°C)   | poise   | 1100   |
| 0086             |                   | Nonvolatile Content          | percent | > 98.5 |
| 0243             |                   | Open Time                    | minutes | 15     |
| 0243             |                   | Green Strength at 15 Minutes | psi     | 3      |

1. CTM: Corporate Test Methods copies of CTM's are available on request.
2. ASTM: American Society for Testing and Materials.

## Typical Properties (Cont.)

| CTM <sup>1</sup> | ASTM <sup>2</sup> | Property                     | Unit    | Result                  |
|------------------|-------------------|------------------------------|---------|-------------------------|
| 0243             |                   | Green Strength at 60 Minutes | psi     | 4                       |
|                  |                   | Cure Time, 1/8" Bead         | days    | 2                       |
|                  | C661              | Durometer – Shore A          | points  | 33                      |
|                  | D412              | Tensile Strength             | psi     | 700                     |
|                  | D412              | Elongation                   | percent | 1000                    |
|                  | D412              | Modulus at 50% Elongation    | psi     | 36                      |
|                  | C711              | Low Temperature Flexibility  |         | pass                    |
| 0044             |                   | Specific Gravity             | uncured | 1.12                    |
| 0176             |                   | Appearance                   |         | Translucent             |
|                  | C711              | Service Temperature Range    | °F (°C) | -50 to 300 (-45 to 150) |
|                  | D4498             | Heat-Fail Temp in Shear      | °F (°C) | 500 (260)               |

### Description

DOWSIL HM-2520 Assembly Sealant is a 100 percent silicone, neutral-cure sealant formulated to have immediate adhesion which offers assembly improvements and uses in many production applications. Products made with this can be immediately handled. As a viscoelastic material, when cured and then exposed to high temperatures, this product will soften but recovers to its typical properties when cooled down.

### Listings/ Specification

FDA Regulations 21 CFR 177. 2600 for aqueous applications.

National Sanitation Foundation list 51, for use with food equipment.

National Sanitation Foundation, (NSF) List 51 – Food and Equipment materials aqueous and dry solids NSF 61 for use with potable water.

### Handling Precautions

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT [WWW.CONSUMER.DOW.COM](http://WWW.CONSUMER.DOW.COM), OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

### Usable Life And Storage

DOWSIL HM-2520 Assembly Sealant has a shelf life of 12 months from date of manufacture.

### Limitations

When cured, the DOWSIL HM-2520 Assembly Sealant is a viscoelastic solid with mechanical properties that vary with temperature. At very low temperatures, this product still offers flexibility but at high temperatures DOWSIL HM-2520 Assembly Sealant will soften and may have some creep depending on the application.

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

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DOWSIL™ HM-2520 Assembly Sealant

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## **Health And Environmental Information**

To support customers in their product safety needs, Dow has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, [www.consumer.dow.com](http://www.consumer.dow.com) or consult your local Dow representative.

<http://www.consumer.dow.com>

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