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[1]	ASTM[2]	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.

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Typical Properties (Cont.)

CTM[1]	ASTM[2]	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, 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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Health And Environmental Information

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For further information, please see our website, www.consumer.dow.com or consult your local Dow representative.

http://www.consumer.dow.com

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