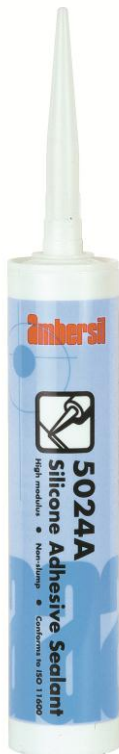


## Technical Data



### **5024A** **SILICONE ADHESIVE SEALANT**



**AMBERSIL SILICONE ADHESIVE SEALANT 5024A** is a high modulus, one part acetoxy curing sealant conforming to ISO 11600 F & G, Class 20HM. In its uncured state, 5024A is a thixotropic paste which can be applied over a wide range of temperatures with no risk of slumping from normal joint widths. The paste cures rapidly on exposure to moist air to form a tough, rubber seal capable of repeated extension and compression during service with excellent resistance to aging, shrinkage, cracking and discolouration. 5024A offers good adhesion to various non-porous substrates such as glass, glazed ceramic tiles and metals (including Aluminium).

Available as a translucent product or in the following colours; Black, White, Grey and Silver Grey.

#### **USES**

5024A is recommended as a general purpose sealing and bonding agent and can be used to produce formed-in-place gaskets or as a space-filling rubber adhesive.

#### **JOINT PREPARATION**

The joint should first be checked to ensure that the dimensions comply with the drawing. The joint faces to be bonded must be free from frost, loose debris, dust, oil and grease. Non-porous surfaces should be cleaned with non-oily solvent (e.g. Ambersil Amberklene FE10). Flaking paint or lacquer should be removed.

#### **JOINT DESIGN**

The mean joint width should not be less than 4 times the total expected movement. For optimum movement accommodation:

- (a) the joint depth or width should not be less than 3mm
- (b) the joint depth should be 3mm up to a joint width of 6mm
- (c) above joint widths of 6mm the joint depth should equal half the width.

#### **BACK-UP MATERIAL**

Back-up strips can be used to control the joint depth and minimise adhesion to the back of the joint. Expanded polyethylene in rectangular or rod form is recommended, but polyurethane and neoprene can also be used. Some rubbers contain plasticisers which may bleed into the silicone sealant and discolour it. A test on these backing materials should be made to ensure staining does not occur.

#### **TECHNICAL DATA**

##### **UNCURED COMPOUND**

Appearance	:	Smooth easily extruded translucent paste
Sag and Flow	:	Nil
Specific Gravity	:	1.03

Skin over time : 8 – 20 minutes  
Cure rate : 3 mm, 1 day. 5 mm, 3 days.

### **CURED COMPOUND**

Results are based on a 3mm sheet cured at ambient conditions for 7 days.

Hardness : 18 Shore A, minimum  
Elongation at break : 450%, minimum  
Tensile Strength : 1.55 MPa, minimum  
Temperature Resistance : -50°C to +204°C (Short term 218°C)

### **PACKAGES**

Ambersil Silicone Adhesive Sealant 5024A is available in non returnable 310ml cartridges.

### **LIMITATIONS**

Ambersil Silicone Adhesive Sealant 5024A is not recommended in situations where abrasion and physical abuse are encountered. It should not be applied to bituminous substrates, substrates based on natural rubber, chloroprene or EPDM or on materials that bleed oils, plasticisers or solvents. Sealant 5024A is not recommended for bonding to porous substrates such as stone or marble or surfaces which could react with acetic acid, e.g. lime based cements and mortars and copper-based or Zinc coated (galvanized) metals. 5024A is unsuitable for aquarium applications.

### **STORAGE**

Store the sealant in a cool dry place out of direct sunlight at temperatures not exceeding 30°C. Under these conditions the sealant in its original unopened package, has a storage life of 18 months.

### **FLAMMABILITY**

Flash Point greater than 100°C (closed cup). Burns at high temperatures to form an ash without dripping.

### **CAUTION**

On direct contact uncured sealant irritates the eyes. In case of contact, remove sealant, flush eyes with plenty of water and seek medical attention.

**HEALTH AND SAFETY** - Health and Safety sheet available separately.

**TECHNICAL SERVICE** - Ambersil provides a technical support service and maintains a constant programme of research and development. We are able to assist customers by specific product development to meet particular requirements.

### **MISREPRESENTATION ACT 1967**

### **TRADE DESCRIPTIONS ACT 1968**

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