Speedline RTV Adhesive/Sealant 73-20 Silicone

Description

Speedline 73-20 RTV Adhesive/Sealant is a one-part, paste-like material that cures to a tough, flexible solid upon moisture/air exposure.

Speedline 73-20 RTV Adhesive/Sealant will not slump under its own weight; it is therefore suitable for applications to overhead or vertical surfaces without detrimental sag, runs or slumps. It provides a strong adhesion to most types of clean PVC (and other plastics), metal, wood, silicone rubber and ceramic surfaces.

Speedline 73-20 RTV Adhesive/Sealant is very resistant to outdoor exposure, moisture, ozone and vibration. It also is resistant to high and low temperatures. It may be applied in sub-zero conditions without loss of its normal properties. It will withstand extended exposure from -76° F (-60° C) up to 450° F (232° C), and for short periods as high as 500° F (260° C).

Speedline 73-20 RTV Adhesive/Sealant is available in colors of aluminum and white, as well as clear.

Use

Speedline 73-20 RTV Adhesive/Sealant is commonly used to:

- Seal joints between layers of plastic or layers of metal and plastic.
- Attach screwless fastenings to metal, wood or plastic.
- Bonded gasketing in heating and re frigeration applications.

Speedline® 73-20 RTV Adhesive Sealant

Type ..... One-part silicone rubber
Form ..... Nonslumping paste
Cure ..... Cures on exposure to water vapor in the air, giving off small amounts of acetic acid
Properties ..... Can be applied to vertical and overhead surfaces without sag or run-off

General Use ..... As a sealing or bonding adhesive or gasketing

Compliance

Speedline 73-20 RTV Adhesive/Sealant complies with the following codes and standards:
MIL-A-46106A, Amend 2, Type 1
Meets the requirements of FDA Regulation No. 21 CFR 177.2600 subject to end use compliance with limitations.
Meets the requirements of USDA for use in Federally inspected meat and poultry plants.

Physical Properties*

Property	Test Method	Value
Specific Gravity @77°F (25°C)	**ASTM 792**	**1.04**
Durometer Hardness, Shore A	**ASTM D412**	**30**
Tensile Strength, psi	**ASTM D412**	**350**
Elongation	**ASTM D412**	**500%**
Brittle Point	**ASTM D746**	**-100°F (-73°C)**

* All tests on 0.075" slab cured 72 hrs. at 77°F (25°C).

Tack Free	**15 min.**
Full Cure	**24 hrs.**
Shelf Life	**12 months**

Application Details:

Speedline 73-20 RTV Adhesive/Sealant is furnished ready for use directly from the container/tube. It is a one-part material that will cure to a tough, flexible rubber once released from its container and exposed to moisture/air. It flows freely from the tube under pressure and can be easily tooled with a metal, plastic or wood tool.

Cure

The curing process of 73-20 RTV Sealant starts with its exposed surface and progresses inward; an initial tack-free skin forms shortly across the exposed surface. At 75° F (24° C) and 50% relative humidity a skin will form in about 20 minutes. Any required tooling should be enacted prior to the skin starting to form; it is also necessary to remove any masking tape if it is used along the edges of the application area. Tooling and the removal of masking tape should be limited to the first 5 or 10 minutes. The curing process is directly affected by the moisture exposure; greater or lesser relative humidity will speed up or slow down the cure process.

Thickness, as well as humidity will affect the total cure time of the material. At room temperature, an ⅛" thick confined bead of 73-20 will solidify to a solid rubber in 24 hours with a final cure within 3 days. A ½" bead might add a day to the cure, though the outer ⅛" would cure at a like rate.

An odor caused by the release of acetic acid will be experienced during the cure period. This unpleasant aroma will disappear with a cure and will not be detectable after a full cure.

Surface Preparation

In preparation for bonding 73-20 RTV Adhesive/Sealant, thoroughly clean all surface areas, removing any grease and loose particles. Additionally cleanse the surface areas with a wipe of acetone. For rubber surfaces, roughen the rubber surface and then wipe with acetone. All surfaces should be dry at the time of application.

Application

Prepare the 73-20 Tube by cutting off the nozzle at an angle providing a desired bead size. Additionally pierce the seal inside the throat of the tube tip.

Push the sealant ahead of the nozzle to maintain a uniform bead. The thickness should be limited to ¼" (6mm) or less. If using an air powered caulking gun, do not exceed 45 psig.

Limit your application to an area that you can complete and yet allow any required tooling or edge detailing. Under normal room temperature, the material will become tack free within twenty minutes, so all tooling, removal of masking tape, etc. should be complete within five to ten minutes.

Caution

This product will form formaldehyde vapor at temperatures above 300° F (150° C) in the presence of air. Formaldehyde is a potential cancer hazard and known to promote skin and respiratory problems. These vapors will irritate eyes, nose and throat. Material should be installed in well ventilated areas. Take precautions to preclude contact with skin and eyes. **Read the further precautions in the Material Safety Data Sheet and those outlined on the material label prior to handling.**

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