



**PRODUCT STANDARD**  
SWITCHGEAR ENGINEERING DIVISION

SG 12434 Rev.:00

Page 1 of 3

**MULTI - PURPOSE SEAUNG AND BONDING AS A SPACE-FILLING RUBBER ADHESIVE OR A FORMED-IN-PLACE GASKET**

Ordering Description: SILICONE SEALANT AS PER SPECIFICATION .No. SG 12434

**1. FEATURES :**

- Will not slump, sag or run off surfaces
- Non-flowable; can be applied without slumping or running off
- Good resistance to weathering, moisture and temperature extremes
- Broad temperature range performance; cured material stays flexible for continuous use from -76 to 350°F (-60 to 177°C) and up to 400°F (204°C) for intermittent use. In cases where slightly higher temperature performance is required. continuous use up to 400°F (204°C) and intermittent use up to 450°F (232°C).
- Adheres to a variety of surfaces
- 100 percent silicone rubber
- Shall Meet requirements of many industry standards, OEM applications and Specifications.

**2. COMPOSITION**

- One-part silicone rubber supplied as non slumping paste

**3. USES**

Multi-purpose sealant is designed for a number of diverse sealing and bonding applications. This sealant can be used for:

- Protecting components from moisture from frequent wash downs or weathering
- It cures at room temperature by reaction with moisture in the air to produce a durable. flexible silicone rubber
- Bonding and sealing appliance parts
- Sealing marine cabins and windows
- Filleting and caulking joints in sheet metal stacks, duct work and equipment housings

**4. SPECIFICATIONS:**

- Complies with FDA Regulation 21 CER 177. for incident contact with food
- Shall Meet the requirements of Military specification ML-A-46106

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<b>REV.</b>	00	<b>PRINTS TO:-</b>		<b>APPROVED –</b>		
<b>ALTD.</b>		PDG	1	DIVYA JOSHI		
<b>APPD.</b>		SWM	1	<b>PREPARED</b>	<b>ISSUED</b>	<b>DATE</b>
<b>DATE.</b>		C.FILE	1	RRR	APS	11.06.12



# PRODUCT STANDARD

## SWITCHGEAR ENGINEERING DIVISION

SG 12434 Rev:00

Page 2 of 3

### 5. TYPICAL PROPERTIES

These values are not intended for use in preparing specifications.

METHOD	TEST	UNIT	RESULT
CTM 0062	Flow, sag or slump	inches	Nil
	Colour		clear
CTM 0097	Specific gravity at 77°F (25°C)		1.04
CTM 0364	Extrusion Rate (1/8-inch Orifice, 90 psi air pressure)	g/min.	350
Cure Characteristics – Exposed to Air at 77°F (25°C) and 50% RH			
CTM 0098	Skin-over Time	min.	5-10
CTM 0095	Tack-Free Time	min.	20
	Cure Time, 1/8-inch bead	hours	24
Physical Properties-As Cured 7 days at 77°F (25°C) and 50% RH			
CTM 0099	Durometer Hardness, Share A	points	25
CTM 0137A	Tensile strength	psi	325
CTM 0137A	Elongation	percent	600
CTM 0069	Thermal conductivity	BTU per ft.-°F-hr.	0.11
		Cal / cm -°C-swc	0.44 x 10 <sup>3</sup>
Electrical Properties –As Cured 3 Days at 77°F (25°C) and 50% RH			
CTM 0313	Volume Resistivity	ohm-cm	1.5 x 10 <sup>15</sup>
CTM 0114	Dielectric constant	voltas / mil	550

CTMs (Corporate test methods) correspond to standard ASTM tests in most instance.

### 6. HOW TO USE:

**Surface Preparation:** Clean surfaces using Fluids or other suitable solvent. Make sure the surface is free of any oil, soap or water. Slight abrasion of the surface may improve adhesion. Priming may be required on some surfaces for better adhesion.

**Application:** Sealant is to be supplied in ready-to-use form. It extrudes readily from its container under pressure. Apply sealant in continuous operation by holding the applicator at a 45. angle and pushing the adhesive a head of the nozzle

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# PRODUCT STANDARD

## SWITCHGEAR ENGINEERING DIVISION

SG 12434 Rev:00

Page 3 of 3

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**Cure:** Sealant shall cure at room temperature on exposure to water vapor in the air. Cure time is affected by relative humidity, degree of confinement and cross-sectional thickness of the sealant. Curing shall progress in ward from the surface. At conditions 7TF (25.C) and 50 percent relative humidity, A tack-free skin shall form within 20 minutes. Sections up to 1/8 inch thick become rubbery solids in about 24 hours at room temperature at 50 percent relative humidity. Higher relative humidity will make the sealant cure slightly faster.

**Clean up:** Remove excessive adhesive with a dry paper towel.  
Remove masking as soon as tooling is completed.

### 7. STORAGE AND SHELF LIFE:

Sealant shall have shelf life of 30 months from date of manufacture. When stored in original, unopened containers at or below 77.F (32°C). Containers should be kept sealed when not in use. After container has been opened, a plug of cured material may form in the nozzle or tube tip during storage. When ready to reuse, un screw the nozzle and remove the cured plug. The remaining sealant is ready to use.

**SOURCE:** DOW CORNING MAKE  
SILICONE SEALANT 732

**ALTERNATE:**  
GE MAKE  
GE IS 808  
300 grams CATRIDGE