



Technical Data Sheet

DOWSIL™ 93-076-2 RF Sealant

FEATURES

- Good tensile strength
- High bond strength
- Two part room temperature cure

Two part, high viscosity, high performance silicone elastomer

TYPICAL PROPERTIES

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

| CTM ASTM ¹ | Property | Unit | Result |
|--|---|--------------|----------------|
| As Supplied | | | |
| | Color – base/curing agent | | Gray/turquoise |
| | Mixing ratio by weight (base/curing agent) | | 10/1 |
| Catalyzed, mixed 10:1 base/curing agent by weight | | | |
| | Working time at 25°C | hours | 2 |
| 0364 | Extrusion rate, 2 hours after mixing | grams/minute | 35 |
| Physical properties, cured 24 hours at 25°C and 50% relative humidity | | | |
| 0099 D2240 | Durometer hardness Shore A | 5 day | 46 |
| 0137A D412 | Tensile strength | psi | 680 |
| 0159A | Tear Die B | ppi | 120 |
| | Elongation at break | % | 350 |

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

HOW TO USE

Surface Preparation

DOWSIL™ 93-076-2 RF Sealant adheres well to primed surfaces; typical materials include glass, cured silicone rubber, cork, phenolic, polyester, epoxy, silicone resin laminates and most metals including stainless steel, titanium and aluminum. It may not adhere well to polyethylene or certain plastics and organic materials (including rubber), which bleed or exude plasticizers. Stronger and more uniform bonds are obtained by preparing metal and plastic surfaces with DOWSIL™ P5200 Adhesion Promoter.

For best results:

1. Clean the surface with a chlorinated solvent (see Handling Precautions) and a slightly abrasive pad or a coarse lint-free cloth.
2. Rinse cleaned surface with acetone or methyl ethyl ketone.
3. Apply a thin coat of primer by dipping, brushing or spraying.
4. Allow the primer to dry for at least 1 hour, according to relative humidity.
5. Silicone rubber surfaces should not normally be primed, but only roughened slightly with abrasive paper and rinsed with acetone.

Mixing

The catalyst is added in a ratio of 10 parts of base to 1 part catalyst by weight. For best results, the base should be thoroughly de-aired in standard vacuum equipment for 2 hours at greater than 650 mm of mercury vacuum. The catalyst may then be added to the base in an air-free mixer, such as a Semco Pressure Mixer, model S-1350 or S-1378.

Hand mixing may also be used if, after mixing, the product is de-aired in vacuum for about 30 minutes.

Working and Curing Time

The sealant will set up in 24 hours and achieve optimum physical properties in 5 days.

Curing

Like all tin catalyzed silicone rubbers, DOWSIL 93-076-2 RF Sealant may de-polymerize in thick section when overheated in total confinement. To eliminate all the possibilities of de-polymerization, contact us for alternate product recommendations.

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

When stored at or below 32°C in the original unopened containers, DOWSIL 93-076-2 RF Sealant and Catalyst has a usable life of 9 months from the date of production. Since the catalyst is extremely sensitive to moisture, the container should be covered at all times. Also, frequent opening of the catalyst should be avoided. If catalyst becomes grainy or crystalline, it should not be used.

PACKAGING INFORMATION

DOWSIL 93-076-2 RF Sealant is supplied with its catalyst in 454 gram and 4.1 kg kits.

LIMITATIONS

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

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 or consult your local Dow representative.

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in

substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

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Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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DOWSIL™ 93-076-2 RF Sealant

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