Product Information

DOW CORNING

Dow Corning® 93-006-6 RF Aerospace Sealant

FEATURES

- Longer Working Time
- Two part room temperature cure

Two part, high viscosity, non-slump, high performance silicone elastomer

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

CTM ASTM[1]	Property	Unit	Result
As Supplied			
	Color – base/curing agent		Gray/White
0062	Flow	inches	0.15
	Mixing ratio by weight (base/curing agent)		10/1
Catalyzed, mixed 10:1 base/curing agent by weight			
	Working time at 25°C	hours	6
0384	Extrusion Rate, 6 hours after mixing	grams/minute	250
Physical properties, cured at 25°C and 50% relative humidity			
0099	Durometer Shore A	48 hours	40
0137A D412	Tensile Strength	psi	425
	Elongation at break	%	170
	Peel strength, lap shear	psi	325

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

HOW TO USE

Substrate preparation

Dow Corning® 93-006-6 RF Aerospace 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 *Dow Corning*® PR-1200 Primer.

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 650mm of mercury vacuum. The catalyst may then be added to the base in an air-free mixer, such as a Semco Pressure Mixer, model S1350 or S1378.

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

How to apply
The catalyzed material can be cast, troweled or air injected with standard equipment.

Working and curing time
Dow Corning 93-006-6 RF Aerospace Sealant will have a working time of 6 hours and the cure time 48 hours. *Dow Corning* 93-006-6 RF Aerospace Sealant will achieve optimum physical properties in 7 days.

HANDLING PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE ON THE DOW CORNING WEB SITE AT DOW CORNING.COM, OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.

USABLE LIFE AND STORAGE

When stored at or below 32°C (89.6°F) in the original unopened containers, *Dow Corning* 93-006-6 RF Aerospace Sealant has a usable life of 12 months from the date of production.

PACKAGING INFORMATION

Dow Corning 93-006-6 RF is available in 453 gram and 4.5 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 Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our Web site, dowcorning.com or consult your local Dow Corning 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.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

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.

DOW CORNING SPECIFICALLY DISCLAIMS ANY OTHER EXPRESS OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY.

DOW CORNING DISCLAIMS LIABILITY FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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