

# Fortasun™ PV-804 Neutral Sealant

High-performance silicone adhesive/sealant

## Features and benefits

- Proven solution in PV industry
- Adhesion to typical PV substrates
- Protects against mechanical shock and thermal cycling stress at components
- UL 94 HB
- UL RTI Elec 140°C (284°F)
- UL RTI Imp 105°C (221°F)
- UL RTI Str 115°C (239°F)
- Outdoor UV/H2O
- One-part, neutral alkoxy-cure silicone sealant

## Applications

- Bonding, sealing, and encapsulating photovoltaic module components

## Typical properties

Specification writers: These values are not intended for use in preparing specifications. Please contact DuPont before writing specifications on this product.

CTM <sup>1</sup>	ASTM <sup>2</sup>	Property	Unit	Result
<b>As supplied</b>				
0176		Color		White or black
		Consistency		Non-slump paste
0364	D2452	Extrusion rate <sup>3</sup>	g/minute	190
0095		Tack-free time <sup>4</sup>	Minutes	30
<b>Physical properties – cured 7 days at 23°C (75°F) and 50% relative humidity</b>				
0022	D0792	Specific gravity at 23°C (75°F)		1.4
0099	D2240	Durometer hardness	Shore A	39
0137A	D412	Tensile strength	MPa	2.6
0137A	D412	Elongation at break	%	620
0159A	D624	Tear Strength – Die B	kN/m	14
<b>Electrical properties – cured 7 days at 23°C and 50% relative humidity</b>				
0114	D149	Dielectric strength	kV/mm	16
0249	D257	Volume resistivity	ohm-cm	1.0x10 <sup>15</sup>

<sup>1</sup>CTMs (Corporate Test Methods) correspond to standard ASTM tests in most instances. Copies of CTMs are available upon request.

<sup>2</sup>ASTM – American Society for Testing and Materials

<sup>3</sup>Extrusion rate measured using 3.18 mm diameter nozzle at 0.62 Mpa.

<sup>4</sup>Tack-free time is the time required for the product to develop a non-tacky surface based on adhesion to a polyethylene film.

## Description

Fortasun™ PV-804 Neutral Sealant is designed to provide long-term bonding and protection against moisture, environmental degradation, mechanical and thermal shock, and vibration where a roomtemperature-curing product is preferred.

## How to use

### Substrate preparation

All surfaces must be clean and dry. Degrease and wash off any contaminants that could impair adhesion. Suitable solvents include isopropyl alcohol, acetone, or methyl ethyl ketone.

Certain plastics may require specific surface treatment to obtain optimum adhesion. Contact your local DuPont technical support for further information.

### How to apply

Apply a bead of Fortasun™ PV-804 Neutral Sealant to one of the prepared surfaces, then quickly cover with the other substrate to be bonded. On exposure to moisture, the freshly applied material will “skin over” in about 10 to 15 minutes at room temperature and 50% relative humidity. Any tooling should be completed before this skin forms. The surface is easily tooled with a spatula. Fortasun™ PV-804 Neutral Sealant will be tack free in about 30 minutes.

### Cure time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity), Fortasun™ PV-804 Neutral Sealant will cure to a depth of about 2 mm. Very deep sections, especially when access to atmospheric moisture is restricted, will take longer to cure completely. Cure time is also extended at lower humidity levels. Before handling and packaging bonded components, users are advised to wait a sufficiently long time to ensure that the integrity of the adhesive seal is not affected. This will depend on many factors and should be determined by the user for each specific application.

## 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 [photovoltaics.dupont.com](http://photovoltaics.dupont.com), or from your DuPont sales application engineer, or distributor, or by calling DuPont customer service.

## Usable life and storage

When stored at or below 30°C (86°F) in the original unopened containers, Fortasun™ PV-804 Neutral Sealant has a usable life of 12 months from the date of manufacture.

Because Fortasun™ PV-804 Neutral Sealant cures by reaction with moisture in air, keep the container tightly sealed when not in use. A plug of used material may form in the tip of a tube or cartridge during storage. This is easily removed and does not affect the remaining contents. In pails, a skin may form on the surface. This should be removed before placing in dispensing equipment.

## Packaging information

Fortasun™ PV-804 Neutral Sealant is available in standard cartridge, pail and drum packaging. Detailed container size information should be obtained from your DuPont contact.

## 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, DuPont 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, [photovoltaics.dupont.com](http://photovoltaics.dupont.com) or consult your local DuPont 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.

The DuPont 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.

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