



**Dynatex®**

**Technical Datasheet**

**DYNA 49204**

Revised Date: June 2011

**Description**

Clear RTV Silicone Adhesive/Sealant is a paste-like, one- component material, which cures to a tough, rubbery solid upon exposure to moisture in the air. Provides transparent, watertight silicone rubber seal for a wide range of applications.

**Bonds and Seals**

- Auto and appliance trim, including metal, fabric ad fabric backed plastics
- Glass, vinyl, wood and rubber
- Trailers, truck cabs

**Use on:**

Windscreens, sunroofs, tail-lights, interior panels, firewalls and dashboards

**Additional Uses**

- Provides formed-in-place gaskets for gear boxes, compressors, and pumps
- Bonding and sealing appliance parts
- Bonding signs and sign letters

**Limitations**

Clear RTV Silicone Adhesive/Sealant will corrode or not adhere to copper, brass (and other copper-containing alloys), magnesium, zinc, galvanised metals (and other zinc-containing alloys). This sealant is not recommended for use on masonry, brick and cementitious substrates.

Clear RTV Silicone Adhesive/Sealant has a good resistance to weathering, vibration, moisture, ozone and extreme temperatures. It may be applied in sub-zero weather without loss of extrusion or physical property characteristics and is effective to - 35°C.

**Typical Properties**

Type	One-Part Silicone Rubber.
Physical Form	Non-Slumping Paste
Cure	Cure at room temperate on exposure to water vapour in the air, giving off a small amount of acetic acid
Operating Temperature	-35°C to 268°C
Special Properties	Meets or exceeds OEM volatility specifications won't foul engine sensors
Primary Uses	Bonding, Sealing, potting, encapsulating and protective coating where parts must perform at high temperatures

**As Supplied**

Specific Gravity @ 25°C	1.04
Extrusion Rate (3.18mm orifice, 90 psi air pressure)	350 g/min
Flow rate (Sag or slump on 3.18 x 101.6mm bead) mm	NIL
Tack-free @ 25°C & 50% RH	10 to 20 Minutes
Cure time @ 25°C & 50% RH (3.18mm thickness),	24 Hours

**Presentation**

Clear RTV Silicone Adhesive/Sealant is available in 108g Tubes.

**ACTIVE & INACTIVE METAL TABLE**

<b>Super Active</b> Very Fast Cure	<b>Active</b> Fast Cure	<b>Inactive</b> Slow Cure	<b>Passive</b> Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



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**As Cured- Physical**

ASTM D2240		Durometer Hardness, Shore A	24 points
ASTM 412	D	Tensile Strength	2.4Mps (350psi)
ASTM 412	D	Elongation	600%
ASTM 746	D	Brittle Point	-73°C

After 3 days at room temperature, this Durometer Hardness levels off to about 30 points.

In applications where Clear RTV Silicone Adhesive/Sealant may be partially or totally confined during cure, the time required for proper cure is generally lengthened by the degree of confinement. It is possible that with absolute confinement cure will not be completed. The result is the softening of the sealant at elevated temperatures. Metal to metal bonds should not overlap more than one inch. Every application involving confinement during cure should be thoroughly tested before commercialising.

**How to Use**

Clear RTV Silicone Adhesive/Sealant is supplied in ready-to-use form. It flows readily from its container under pressure. A spatula or wooden paddle can be used to tool the surface.

Curing time increases with the thickness of the sealant. A 1/2 inch cross section, for example, may require 3 or 4 days for complete solidification. However, the cure will have penetrated the outer 1/8 inch in about 24 hours.

Cure progresses inward from the surface. At conditions of 25°C and 50 percent relative humidity, a tack-free skins form within 20 minutes tooling should be completed within 5 to 10 minutes of application. Alternative periods of application and tooling may be required. If masking tape is used to mask an area it must be removed before the tack-free skin forms.

Adhere to glass, metal or most woods, Clear RTV Silicone Adhesive/Sealant has typical peel strength of 20 pounds per inch, after 72 hours at room temperature.

An odour caused by the liberation of acetic acid is given off during cure. This odour disappears as the cure progresses and is not detectable after cure is complete. Fully cured sealant is non-hazardous.

**Cure Time**

Cure time is affected by relative humidity, degree of confinement and cross-sectional thickness of the sealant. Sections up to 1/8 inch thick become rubbery solids in about 24 hours at room temperature at 20 percent relative humidity. More moisture content reduces cure time slightly. In 24 hours, sections up to 1/8 inch thick cure to a rubber with a Shore A Durometer Hardness of about 25 points.

**Storage**

When stored in original unopened container at or below 32°C, Clear RTV Silicone Adhesive/Sealant has a shelf life of 12 months from date of shipment.

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