HERNON®
High Performance Adhesives and Sealants
ISO 9001 Registered

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# Technical Data Sheet
# Silastomer® 336



## Product Description

**Hernon® Silastomer® 336** is a high performance, single component, acetoxy, ready to use silicone. It has a paste-like consistency, which cures to a tough, resilient and durable silicone rubber when exposed to moisture in the air. Since it will not flow of its own weight, **Silastomer® 336** can be applied to vertical, horizontal and overhead joints without sagging or running off. It will adhere to clean metals, glass, most types of wood, silicone resin, vulcanized silicone rubber, natural and synthetic fiber, ceramic, many plastics and painted surfaces.

**Silastomer® 336** provides excellent resistance to moisture, weathering, vibration, ozone and extreme temperatures. It can be applied in surface temperatures of 0°F to above 120°F with no loss in performance. Fully cured **Silastomer® 336** can withstand extended periods at temperatures up to 400ºF.

## Product Benefits

- One component – no mixing
- Room temperature cure
- Non-sagging for use on horizontal, vertical or overhead surfaces
- Excellent high and low temperature resistance
- Excellent weatherability
- Versatile electrical insulation
- Cured rubber is non-toxic
- Good solvent resistance

## Typical Properties (Uncured)

| Property | Value |
|---|---|
| Base | Acetoxy Polysiloxane |
| Color | Black |
| Viscosity | Thixotropic Paste |
| Specific Gravity | 1.007 |
| Extrusion Rate, 0.125 in. Orifice, 50 psi air pressure | 250-500 g/min |
| Sag or slump on 0.125 by 4 in. bead | Nil |
| Application Temperature | 0°F to +120°F (-18C to + 50C) |
| Flash Point | See SDS |

## Typical Properties (Cured)

### Physical Properties

| Property | Value |
|---|---|
| Hardness, Shore A | 18-30 |
| Elongation, % ASTM D412 | ≥ 350 |
| Modulus @ 100% Elongation ASTM D412 | 60-80 psi |
| Tack Free Time at 77ºF, minutes | ≤ 30 |
| Tensile Strength at break ASTM D142, psi | ≥ 175 |
| Peel Strength, Aluminum/ Stainless Steel, ppi | ≥ 15 |
| Full Cure at 77ºF, 0.25 in. bead, hours | 24 |
| Shrinkage, % | ≤ 5 |
| Temperature Range, ºF | -70 to 400 |

### Electrical Properties

| Property | | Value |
|---|---|---|
| Dielectric Strength, KV/mm ASTM D149 | | ≥ 25 |
| Dielectric Constant ASTM D150 | @ 50 Hz<br>1 kHz<br>1 MHz | 2.7<br>2.7<br>2.7 |
| Dissipation Factor ASTM D150 | @ 50 Hz<br>1 kHz<br>1 MHz | 0.0010<br>0.0008<br>0.0002 |
| Volume Resistivity, Ω·cm, ASTM D257 | | $6 \times 10^{14}$ |

## Typical Environmental Resistance

**Silastomer® 336** exhibits excellent performance where a long term, permanently flexible bond is required.

## Surface Preparation

All surfaces should be clean and dry. It is recommended that surfaces to be bonded be solvent wiped with acetone or mineral spirits. Do not use alcohol. Allow surface to dry thoroughly before applying sealant.

## Approvals

When fully cured, **Silastomer® 336** meets requirements:

Certified to **NSF/ANSI Standard 51** Food Equipment Materials
**Mil Spec MIL-A-46106B** Type I
**FDA compliant** with Regulation 21 CFR 175.105 where incidental food contact may be involved.

### Directions for Use

- Ready to use. Requires no mixing or additives.

- Moisture curing begins immediately after the product is exposed to air, therefore assemble parts within a few minutes after the product is dispensed.
- Releases small amount of acetic acid during cure. Use adequate ventilation with extensive use of sealant.

**Clean up**

Excess uncured sealant can be removed from surfaces and tools with Mineral Spirits. Cured Sealant can be cut or scraped away.

## General Information

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Safety Data Sheet (SDS).**

**Storage**

**Silastomer® 336** should be stored in a cool, dry location in unopened containers at a temperature between 45ºF to 85ºF (7ºC to 29ºC) unless otherwise labeled. To prevent contamination of unused material, do not return any material to its original container.

**Dispensing Equipment**

**Hernon®** offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.