



1536

1536 is grey, flowable, one-component, neutral alkoxy-cure silicone sealant. Low-odor, solvent-free, cure at room temperature when exposed to moisture at the atmosphere. With fast tack free time and meets UL94-V0 flame rating. Excellent adhesion to glass, ABS, FR4, and PCBs. Superior resistance to thermal cycling, damp-heat, and damp-freezing. Typical applications include electronics encapsulation, connector staking, electronics potting, circuit board encapsulation, electrical component re-enforcement, electronic component bonding, and sealing.

Technology / Base	Poly(dimethyl) Siloxane
Type of Product	Silicone Sealant
Components	One Part
Curing	Moisture Cure
Appearance / Color	Grey
Consistency	Liquid

Features and Benefits

- Meets UL94-V0 flame rating
- Excellent heat resistance properties
- Excellent thermal cycle, damp heat and damp freezing performance.
- Easy to use for reworkable applications
- Very good electrical insulation properties
- Neutral cure low/no odor

Technical Data

Physical Property	Value	Condition/Method
Rheology		
Viscosity	15,000 to 30,000 cPs	
Density		
Specific Gravity	1.21	
Uncured Material Characteristics		
Tack Free Time	5 to 20 Min	
Full Cure Time	24 hr ≥ 2mm	
Cured Material Performance		
Thermal Service Range	-54 to 210°C	
Hardness	35 Shore A	ISO7619
Tensile Strength	1.5 MPa	ISO37, 23±2°C 50% RH
Elongation to Break	150%	ISO37, 23±2°C 50% RH
Lap Joint Shear Strength Aluminum	0.5 MPa	ISO4587, 23±2°C 50% RH
Electrical Properties		
Volume Resistivity	1.0 x 10 ¹⁴ Ωcm	IEC60093
Breakdown Voltage	15 kV/mm	IEC 60243-1

Test Sample Conditions: 2mm Thickness, Cured at 23±2°C, 50±5%RH for 7 days. Tested at 23±2°C



Typical Applications

- Electrical insulation
- Protects leads from mechanical shock
- Bond and seal enclosures
- Seals ductwork, vents, flues, doors, windows
- Sealing and waterproofing for transformer

Curing Conditions

Cure speed will vary with temperature, relative humidity, depth of material and presence of moisture. Some applications may require special surface preparation. At 23±2°C, 50±5% relative humidity, typical cure depth is 2mm in 24 hours. Requires more time to cure in colder or lower humidity conditions. Contact H.B. Fuller Company technical support for additional curing recommendations.

Storage and Shelf Life

Product shall be ideally store in a cool, dry area in unopened containers. Material should be stored at a temperature of 8-25°C. Do not return unused material back into the container.

General Instructions

- For best performance bond surfaces should be clean, dry and free of any contaminants and oils.
- Apply a continuous and even bead of silicone to one surface.
- Assemble parts immediately. Remove excess material quickly.

Note

The values noted in this data sheet are typical properties only and are not intended to be used as material specifications. For assistance in writing a material specification, please contact H.B. Fuller Company for further details.

Ordering Information

Stock No. 15360202, 310ml Cartridge

Safety and Disposal

For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.

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