



1535

1535 is one-component, silicone adhesive sealant that cures on exposure to atmospheric moisture to form an silicone elastomer. This material offers excellent electrical properties, weather stability, chemical resistance, flame retardancy and thermal conductivity.

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

Features and Benefits

- Good adhesion to most common building substrates, like glass, metal, plastics, FR4, lead frames, etc.
- High thermal conductivity
- Excellent flexibility
- Low odor
- Neutral, non-corrosive
- Flame retardant

Technical Data

Physical Property	Value	Condition/Method
Rheology		
Viscosity	Thixotropic Paste	
Density		
Specific Gravity	2.60	
Uncured Material Characteristics		
Tack Free Time	3 min	
Full Cure Time	24 hr ≥ 2mm	
Cured Material Performance		
Thermal Service Range	-54 to 210°C	
Hardness	82 Shore A	GB/T 531
Tensile Strength	3.5 MPa	GB/T 528, 23±2°C 50% RH
Elongation to Break	180%	GB/T 528, 23±2°C 50% RH
Lap Joint Shear Strength Aluminum	1.5 MPa	GB/T 7124, 23±2°C 50% RH
Thermal Properties		
Thermal Conductivity	1.8 W/mK	ASTM E1461

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



Typical Applications

- Thermal interface material
- Thermal conductive encapsulation
- Protects leads from mechanical shock
- Electronics encapsulation
- Sealing and waterproofing

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 5-25°C and shelf life is a one year in original unopened containers. 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 at once.

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

Safety and Disposal

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

H.B. Fuller Company,
Beijing Tonsan Adhesive Co., LTD.
5 Shuangyuan Rd.
Badachu High-Tech Zone
100041, Beijing, China

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www.hbfuller.com

www.hbfullerengineering.com

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