



2536

2536 is two-component, room temperature fast Bonding silicone system. Typical applications include glass, metal and plastic bonding. It has very good long term adhesion performance in high temperature conditions. 2536 is black RTV-2 silicone, which is fast curing and with good adhesion to a variety of materials. 2536 is a de-alcoholized silicone with the advantages of low odor, no solvent, no corrosion, and it also has excellent electric performance and excellent resistance to all kinds of weather such as UV light, rainwater and hailstone impacting, etc. There is a secondary cure with atmospheric moisture that promotes full cure over 7 days.

Technology / Base	Poly(dimethyl) Siloxane
Type of Product	Silicone Sealant
Components	Two Part
Curing	Room temperature alcohol cure and secondary moisture cure
Appearance / Color	Black
Consistency	Thixotropic Paste

Features and Benefits

- Fast curing
- RoHS compliant and Halogen free
- Non-corrosive, low odor
- Excellent adhesion to a wide variety of substrates including glass, metal and plastics
- Wide operating temperature range
- Very fast setting and fast curing enabling reduced production times

Technical Data

Physical Property	Value	Condition/Method
Rheology		
Viscosity, Part A		
Viscosity, Part B		
Viscosity	Thixotropic Paste	
Uncured Material Characteristics		
Specific Gravity	1.28	
Volume Mix Ratio	10:1	
Weight Mix Ratio	12.2:1	
Working Time	10 min	
Fixture Time	20 to 30 min	
Cure Schedule	24 hours at 25°C, 7 days at (50±5)%RH	
Cured Material Properties		
Thermal Service Range	-40 to 200°C	
Hardness	41 Shore A	GB/T531
Tensile Strength	2.4 MPa	GB/528, 23±2°C 50% RH
Elongation to Break	200%	GB/528, 23±2°C 50% RH
Lap Joint Shear Strength Aluminum	1.3 MPa	GB/T7124, 23±2°C 50% RH
Electrical Properties		
Volume Resistivity	4.0 x 10 ¹⁴ Ωcm	GB/T1692
Breakdown Voltage	20 kV/mm	GB/T1695
Damp Heat Aging Testing		85°C, 85% RH for 1,000 hrs
Volume Resistivity		
Hardness	32 Shore A	GB/T531
Shear Strength	1.0 MPa	GB/T7124, 23±2°C 50% RH
Elongation at Break	180%	GB/528, 23±2°C 50% RH
Tensile Strength	1.8 MPa	GB/528, 23±2°C 50% RH

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



Typical Applications

- Seam sealing
- Bonding to Glass, Plastic and Metals
- Bonding and sealing in appliance applications
- General assembly sealing

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 for a maximum shelf life of 6 months in the original unopened container. Do not return unused material back into the container.

Curing Conditions

Cure speed will vary with temperature, relative humidity, depth of material and presence of moisture. Some applications may require special surface preparation. Contact H.B. Fuller Company technical support for additional curing recommendations.

Safety and Disposal

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

General Instructions

- For best performance bond surfaces should be clean, dry and free of any contaminants and oils.
- Mix Parts A and B evenly according to the applicable mix ratio. Machine meter mix is recommended.
- Apply the mixture to the surface or seam. Automated dispensing equipment is recommended for seam sealing applications.
- Excess materials can be removed after the fixture time.
- It is recommended to schedule a timely purge for the use of mixed material in the static mixer. This is done to avoid inconsistent mixing and to ensure desired performance and properties.
- Material is a secondary moisture-cure type material. It will start to cure immediately after mixing two-components. Moisture in the air will assist to cure material.

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.
253601, 410ml;
25360105, Part A: 220kg, Part B: 18kg

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