



**1527B**

1527B is a black, medium viscosity, low odor and good workability RTV silicone. Cures at room temperature when exposed to moisture. Excellent flexibility, adhesive property, electrical insulation, weather resistance, aging resistance and thermal cycle resistance. 1527B passes FDA 21 CFR 177.2600 and is UL94 certified.

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

**Features and Benefits**

- Excellent heat resistance properties
- Wide operating temperature range
- Easy to use for reworkable applications
- Fast setting one component material
- Neutral cure low/no odor
- UL94 rated
- Meets FDA 21 CFR 177.2600

**Technical Data**

Physical Property	Value	Condition/Method
<b>Rheology</b>		
Viscosity	40,000 to 70,000 cPs	
<b>Density</b>		
Specific Gravity	1.10	
<b>Uncured Material Characteristics</b>		
Tack Free Time	5 to 30 min	
Full Cure Time	24 hr ≥ 2mm	23±2°C and 50±5%RH
<b>Cured Material Performance</b>		
Thermal Service Range	-54 to 210°C	
Hardness	28 Shore A	GB/T 531
Tensile Strength	1.5 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
<b>Electrical Properties</b>		
Volume Resistivity	2.0 x 10 <sup>15</sup> Ωcm	GB/T1692
Breakdown Voltage		
<b>Heat Aging Testing</b>		
Elongation at Break	180%	175°C for 168 hr GB/T 528, 23±2°C 50% RH
Tensile Strength	1.5 MPa	GB/T 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

- Appliances
- Ovens
- Cook Tops
- Microwave Ovens
- Glass Bonding
- Solar Cells
- Lighting Systems
- Battery Sealing

## 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 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

Stock No. 15270902, 310ml Cartridge;  
15270905, 18.0kg Pail

## 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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