



1521

1521 is two-component, room temperature cure silicone system. It has very low ionics and can be used for electronic component applications and electronics potting. Applications include appliance sealing, connector sealing, and junction box potting.

Technology / Base	Poly(dimethyl) Siloxane
Type of Product	Silicone Sealant
Components	Two Part
Curing	Room temperature alcohol cure and secondary moisture cure
Appearance / Color	White
Consistency	Low Viscosity Liquid

Features and Benefits

- UL Certified
- Low viscosity enabling flow and some self leveling
- Electronics potting and encapsulation applications
- Wide operating temperature range
- Excellent dispensability
- Fast setting and fast curing enabling reduced production times

Technical Data

Physical Property	Value	Condition/Method
Rheology		
Viscosity, Part A	7000 cPs	
Viscosity, Part B	25 cPs	
Viscosity	Viscous Liquid	
Uncured Material Characteristics		
Specific Gravity	1.4	
Volume Mix Ratio	4:1	
Weight Mix Ratio	6:1	
Working Time	8 min	
Fixture Time	45 min	
Cure Schedule	7 days at 25°C, 50% R.H.	
Cured Material Properties		
Thermal Service Range	-50 to 150°C	
Hardness	40 Shore A	ISO7619, GB/T531
Tensile Strength	1.2 MPa	ISO37, GB/528, 23±2°C 50% RH
Elongation to Break	110%	ISO37, GB/528, 23±2°C 50% RH
Electrical Properties		
Volume Resistivity	1.0 x 10 ¹⁵ Ωcm	IEC60093, GB/T1692
Breakdown Voltage	23 kV/mm	IEC 60243-1, GB/T1695
Damp Heat Aging Testing		
Volume Resistivity	1.0 x 10 ¹⁵ Ωcm	IEC60093, GB/T1692

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



Typical Applications

- Sealing
- Electrical Potting
- Electrical Connector Sealing
- Electronics Potting

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 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.
- Part A should be blended thoroughly before mixing with Part B in order to disperse filler material evenly.
- Mix Parts A and B evenly according to the applicable mix ratio.
- Apply the mixture to the sealing or potting application. Automated dispensing equipment is recommended for electronics sealing and potting applications.

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. 152110, 14kg

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