

DOW CORNING® 732 Multi-Purpose Sealant

FEATURES

- One-component adhesive/sealant
- Cures at room temperature when exposed to moisture in the air
- Acetoxy cure system
- Non-sag, paste consistency
- Easy to apply
- Cures to a tough, flexible rubber
- Good adhesion to many substrates
- Stable and flexible from -60°C (-76°F) to +180°C (356°F), with short peaks up to +205°C (401°F)
- Black version: stable and flexible from -60°C (-76°F) to +205°C (401°F), with short peaks up to +230°C (446°F)
- Excellent dielectric properties
- Complies with MIL-A-46106A
- Complies with FDA 177.2600
- Available in white, black or clear

Multi-purpose silicone adhesive/sealant

APPLICATIONS

- General industrial sealing and bonding applications.
- Complies with MIL-A-46106A and FDA 177.2600.

TYPICAL PROPERTIES

Specifications writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales representative prior to writing specifications on this product.

| CTM* | ASTM* | Property | Unit | Value |
|--|-------|---|----------|-----------------------|
| As supplied | | | | |
| 0176 | | Appearance | | Non-slump paste |
| | | Color(s) | | White, black or clear |
| 0364 | | Extrusion rate ¹ | g/minute | 350 |
| 0098 | | Skin-over time | minutes | 5-10 |
| 0095 | | Tack-free time | minutes | 20 |
| Physical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity | | | | |
| 0097B | D1475 | Specific gravity | | 1.04 |
| 0099 | D2240 | Durometer hardness, Shore A | | 25 |
| 0137A | D412 | Tensile strength | MPa | 2.2 |
| 0137A | D412 | Elongation at break | % | 550 |
| 0420 | | Volume coefficient of thermal expansion | 1/K | 1.12x10 ⁻³ |
| Electrical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity | | | | |
| 0114 | D149 | Dielectric strength | kV/mm | 21.6 |
| 0112 | D150 | Dielectric constant at 100Hz/100kHz | | 2.8 |
| 0112 | D150 | Dissipation factor at 100Hz/100kHz | | 0.0015 |
| 0112 | D150 | Volume resistivity | Ohm.cm | 1.5x10 ¹⁵ |

1. Extrusion rate: 3.2mm orifice at 0.62MPa.

* CTM: Corporate Test Method, copies of CTMs are available on request.

ASTM: American Society for Testing and Materials.

HOW TO USE

Substrate preparation

All surfaces must be clean and dry. Degrease and wash off any contaminants that could impair adhesion. Suitable solvents include isopropyl alcohol, acetone or methyl ethyl ketone.

Unprimed adhesion may be obtained on many substrates such as glass, metals and most common engineering plastics. Substrates to which good adhesion is normally not obtained include PTFE, polyethylene, polypropylene and related materials.

However, for maximum adhesion, the use of DOW CORNING® 1200 OS

Primer is recommended. After solvent cleaning, a thin coat of DOW CORNING 1200 OS Primer is applied by dipping, brushing or spraying. Allow primer to dry for 15 to 90 minutes at room temperature and a relative humidity of 50% or higher.

How to apply

Apply DOW CORNING 732 Multi-Purpose Sealant to one of the prepared surfaces, then quickly cover with the other substrate to be bonded.

On exposure to moisture, the freshly applied material will "skin over". Any tooling should be completed before this skin forms. The surface is easily tooled with a spatula. The Adhesive/Sealant will be tack-free in less than 45 minutes.

Cure time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) DOW CORNING 732 Multi-Purpose Sealant will cure to a depth of about 3 mm. Very deep sections, especially when access to atmospheric moisture is restricted will take longer to cure completely. Cure time is extended at lower humidity levels.

Before handling and packaging bonded components, users are advised to wait a sufficiently long time to ensure that the integrity of the adhesive seal is not affected. This will depend on many factors and should be determined by the user for each specific application.

Compatibility

DOW CORNING 732 Multi-Purpose Sealant releases a small amount of acetic acid during cure. This may cause corrosion on some metallic parts or substrates, especially in direct contact or when the cure is carried out in a totally enclosed configuration which would not allow cure by-products to escape.

HANDLING PRECAUTIONS

PRODUCT SAFETY
INFORMATION REQUIRED FOR

SAFE USE IS NOT INCLUDED.
BEFORE HANDLING, READ
PRODUCT AND SAFETY DATA
SHEETS AND CONTAINER
LABELS FOR SAFE USE,
PHYSICAL AND HEALTH
HAZARD INFORMATION. THE
SAFETY DATA SHEET IS
AVAILABLE FROM YOUR LOCAL
DOW CORNING SALES
REPRESENTATIVE.

USABLE LIFE AND STORAGE

When stored at or below 32°C (89.6°F) in the original unopened containers, this product has a usable life of 30 months from the date of production.

As DOW CORNING 732 Multi-Purpose Sealant cures by reaction with moisture in air, keep the container tightly sealed when not in use. A plug of used material may form in the tip of a tube or cartridge during storage. This is easily removed and does not affect the remaining contents.

PACKAGING

This product is available in a variety of container sizes. Contact your local Dow Corning sales representative for information about container sizes available in your area.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Health, Environment and Regulatory Affairs specialists available in each area.

For further information, please consult your local Dow Corning representative.

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