

# Product Information

## Industrial Assembly and Maintenance

DOW CORNING

# Dow Corning® AS 7096N Sealant Clear

## FEATURES

- One component adhesive/sealant
- Cures at room temperature when exposed to moisture in the air
- Alkoxy cure system
- Non sag, paste consistency
- Easy to apply
- Excellent unprimed adhesion to many substrates
- Stable and flexible form -50°C to +150°C

## BENEFITS

- Non corrosive to metals
- Low odor

## COMPOSITION

- Silicone Adhesive/Sealant
- Contains fungicide

Translucent neutral cure silicone adhesive/sealant

## APPLICATIONS

- Sealing and bonding applications where translucent and non-corrosive cure is required
- Low modulus formulation for high movement capability

## TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

CTM <sup>1</sup>	ASTM <sup>2</sup>	Property	Unit	Result
<b>As supplied</b>				
0097B	D 1475	Color and appearance		Translucent paste
0364C	MIL-S-8802D	Density	g/cm <sup>3</sup>	1.01
0098		Extrusion Rate	g/min	190
		Skin-Over Time (23°C, 50% R.H.)	min	5-10
0095A	MIL-S-8802F	Tack-Free-Time (23°C, 50% R.H.)	min	15-30
<b>Mechanical Properties, cured 7 days in air at 23°C and 50%R.H.</b>				
0137A	D 412	Tensile Strength	MPa	1.0
0137A	D 412	Elongation at break	%	500
0137A	D 412	Modulus at 100%	MPa	0.23
0099	D 2240	Hardness, Shore A		13

<sup>1</sup>CTM : Corporate Test Method, copies of CTM's are available on request.

<sup>2</sup>ASTM : American Society for Testing and Materials.

## DESCRIPTION

*Dow Corning*® AS 7096N Sealant Clear is a clear, low modulus silicone adhesive/sealant designed for applications where non corrosive cure and durable adhesion to a variety of substrates is required.

Unprimed adhesion may be obtained on many substrates such as glass, metals (e.g. zinc, steel, aluminum) and most common engineering plastics (e.g. PVC, polyacrylate, polycarbonate). Adhesion may be less successful on some low energy plastics such as polyethylene, polypropylene and PTFE.

## 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 methylethyl ketone.

However, for maximum adhesion, the use of *Dow Corning*® 1200 OS Primer is recommended. After solvent cleaning, a thin coat of 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

Dow Corning AS 7096N Sealant Clear is ready to use. Apply a bead of Dow Corning AS 7096N 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” in about 5-10 minutes at room temperature and 50% relative humidity. 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 about 15-30 minutes.

### Cure Time

After skin formation, cure continues inward from the surface. In 24 hours at room temperature and 50 % relative humidity, Dow Corning AS 7096N Sealant Clear will cure to a depth of about 2.4 mm. Very deep sections, especially when access to atmospheric moisture is restricted, will take longer to cure completely. Cure time is very much depending on the humidity level. It is extended at lower humidity levels and accelerated at higher levels, respectively (see table below).

<b>Condition</b>	<b>Rel.Cure Speed</b>
23°C, 50%.R.H.	100%
15°C, 40% R.H.	70%
30°C, 60% R.H.	135%
35°C, 70% R.H.	168%

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

## 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.

## STORAGE

Product should be stored between 5 and 30°C in original, unopened containers. The most up-to-date shelf life information can be found on the XIAMETER Web site in the Product Detail page under Sales Specification.

## 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 Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our Web site, [dowcorning.com](http://dowcorning.com) or consult your local Dow Corning representative.

## LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer’s tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

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Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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