

# Dow Corning<sup>®</sup> HM-2520 Assembly Sealant

## FEATURES

- Instant green strength
- 100% silicone
- Low VOC (VOC exempt in CA)
- Safe to handle – nonhazardous composition and by-products
- Neutral cure
- Adheres to most common substrates
- Open time up to 15 minutes
- Pot life up to 24 hours
- Translucent Clear
- Service temperatures from -50 to 300°F (-45 to 150°C)
- Can be used with standard hot melt dispensing equipment
- High tensile strength

## BENEFITS

- Immediate green strength allows parts to be moved immediately
- Long open time, pot life and moderate application temperature (250°F [121°C]) offer a user-friendly application
- High viscosity at room temperature resists flow of material reducing sealant squeeze out and clean up

## COMPOSITION

- Moisture curing, 100 percent silicone, reactive hot-melt sealant

## Hot melt silicone assembly sealant

### APPLICATIONS

Dow Corning<sup>®</sup> HM-2520 Assembly Sealant is designed for use as an assembly sealant. This product utilizes hot melt technology to dispense the material which utilizes silicone technology to achieve instant green strength when dispensed and cures to strong moisture cured silicone sealant.

### 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.

Method	Test	Unit	Result
CTM 0719	Viscosity at 248°F (120°C)	poise	1100
CTM 0086	Nonvolatile Content	percent	>98.5
CTM 0243	Open Time	minutes	15
CTM 0243	Green Strength at 15 minutes	psi	3
CTM 0243	Green Strength at 60 minutes	psi	4
	Cure time, 1/8" bead	days	2
ASTM C 661	Durometer – Shore A	points	33
ASTM D412	Tensile Strength	psi	700
ASTM D412	Elongation	percent	1000
ASTM D412	Modulus at 50% Elongation	psi	36
ASTM C711	Low Temperature Flexibility		pass
CTM 0044	Specific Gravity	uncured	1.12
CTM 0176	Appearance		Translucent
ASTM C 711	Service Temperature Range*	°F	-50 to 300
		°C	-45 to 150
ASTM D4498	Heat-Fail Temp in Shear	°F (°C)	500 (260)

CTM's: (Corporate Test Methods) correspond to standard ASTM tests in most instances. Copies of CTM's are available upon request.

ASTM: American Society for Testing and Materials.

## DESCRIPTION

Dow Corning<sup>®</sup> HM-2520 Assembly Sealant is a 100 percent silicone, neutral-cure sealant formulated to have immediate adhesion which offers assembly improvements and uses in many production applications. Products made with this can be immediately handled. As a viscoelastic material, when cured and then exposed to high temperatures, this product will soften but recovers to its typical properties when cooled down.

## Listings/Specifications

FDA Regulations 21 CFR 177. 2600 for aqueous applications.

National Sanitation Foundation list 51, for use with food equipment.

National Sanitation Foundation, (NSF) List 51 – Food and Equipment materials aqueous and dry solids NSF 61 for use with potable water.

## **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 material safety data sheet is available on the Dow Corning website at [www.dowcorning.com](http://www.dowcorning.com). You can also obtain a copy from your local Dow Corning sales representative or Distributor or by calling your local Dow Corning Global Connection.

## **USABLE LIFE AND STORAGE**

*Dow Corning*<sup>®</sup> HM-2520 Assembly Sealant has a shelf life of 12 months from date of manufacture.

## **LIMITATIONS**

When cured, the HM-2520 is a viscoelastic solid with mechanical properties that vary with temperature. At very low temperatures, this product still offers flexibility but at high temperatures HM-2520 will soften and may have some creep depending on the application.

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 website, [www.dowcorning.com](http://www.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 Dow Corning's 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.

Dow Corning's sole warranty is that the product will meet the Dow Corning sales specifications in effect at the time of shipment.

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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