Technical Data Sheet

DOWSIL™ AS 7096N Sealant Clear

Translucent neutral cure silicone adhesive/sealant

Features & Benefits

- 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
- Non-corrosive to metals
- Low odor

Composition

- 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.

CTM[1]	ASTM[2]	Property	Unit	Result
As Supplied				
		Color and appearance		Translucent paste
0097B	D 1475	Density	g/cm^3	1.01
0364C	MIL-S-8802D	Extrusion Rate	g/min	190
0098		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
Mechanical Properties, Cured 7 Days in Air at 23°C and 50% R.H.				
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

1. CTM: Corporate Test Method; copies of CTMs are available on request
2. ASTM: American Society for Testing and Materials

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Description

DOWSIL™ 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.

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.

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.

However, for maximum adhesion, the use of DOWSIL™ 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
DOWSIL™ AS 7096N Sealant Clear is ready to use. Apply a bead of DOWSIL™ AS 7096N Clear 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, DOWSIL™ AS 7096N 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).

Condition	Rel.Cure Speed
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 IN THIS DOCUMENT. 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 ON THE DOW WEBSITE AT DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

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Usable Life and Storage

Product should be stored between 5 and 30°C in original, unopened containers.

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 has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, dow.com, or consult your local Dow representative.

Disposal Considerations

Dispose in accordance with all local, state (provincial) and federal regulations. Empty containers may contain hazardous residues. This material and its container must be disposed in a safe and legal manner.

It is the user's responsibility to verify that treatment and disposal procedures comply with local, state (provincial) and federal regulations. Contact your Dow Technical Representative for more information.

Product Stewardship

Dow has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with Dow products — from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

Customer Notice

Dow strongly encourages its customers to review both their manufacturing processes and their applications of Dow products from the standpoint of human health and environmental quality to ensure that Dow products are not used in ways for which they are not intended or tested. Dow personnel are available to answer your questions and to provide reasonable technical support. Dow product literature, including safety data sheets, should be consulted prior to use of Dow products. Current safety data sheets are available from Dow.

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