

Technical Data Sheet

Addisil* 6100

Heat-Curing Silicone Adhesive

Product Description **Addisil 6100** silicone adhesive is a one-component heat curable silicone adhesive sealant which will bond to many substrates without a primer and which will cure rapidly at elevated temperatures. This product has a very long working time at room temperature and will not cure completely until exposed to elevated temperatures.

Addisil 6100 is a black, thixotropic paste, which can be applied to vertical or overhead surfaces.

Key Performance Properties

- One component product - no mixing required
- Room temperature storage
- Fast cure at elevated temperature (in a range of 140 °C to 230 °C)
- Primerless adhesion to many types of substrates (e.g. glass, enamel, aluminium, ceramic)
- No formation of cure by-products
- Non-corrosive to metals
- Good performance over a wide temperature range
- Service temperature -50 °C to 250 °C

Typical Product Data

Uncured Properties	Addisil 6100
Colour	black
Density, g/cm ³	1.12
Vertical Flow, @ 30 min., mm	< 2
Cured Properties (cured 10 min. at 175°C)	Addisil 6100
Hardness, Shore A	42
Elongation, %	> 300
Tensile Strength, MPa	9.5
Tear Strength, kN/m	25

Specifications Typical product data values should not be used as specifications. Assistance and specifications are available by contacting Momentive performance materials Technical Service RTV1 and RTV2.

Instructions for Use **Compatibility**

Addisil 6100 silicone adhesive will cure in contact with most clean, dry surfaces. However, certain materials, such as butyl and chlorinated rubber, sulfur-containing materials, amines, and certain metal soap cured RTV silicone rubber compounds can cause cure inhibition. Cure inhibition is characterized by a gummy appearance of Addisil 6100 silicone adhesive at the interface between the adhesive and the substrate to be bonded. It is recommended that a sample patch test be performed with Addisil 6100 silicone adhesive to determine substrate compatibility.

Surface Preparation

The adhesive performance of any polymer system is highly dependent upon proper surface preparation. In order to maximize the adhesion of Addisil 6100 silicone adhesive and minimize the potential for cure inhibition, all parts should be as clean and dry as possible prior to the application of the adhesive.

Bonding

Addisil 6100 silicone adhesives offer good adhesion characteristics to a wide variety of different substrates without the need of a primer. For difficult-to-bond-to substrates, or where more aggressive chemical adhesion is desired, using SS4155 silicone primer, available from Momentive performance materials, may enhance the adhesion. To apply the primer, thoroughly clean the surface and let dry. Then apply a uniform film (0.01-0.02 mm) of SS4155 silicone primer and allow the primer to air-dry for one hour or more.

Curing

Addisil 6100 silicone adhesive requires the use of elevated temperatures in order to achieve full cure.

<u>Temperature</u>	<u>Addisil 6100</u>
150°C	< 5 minutes
175°C	< 2 minutes
200°C	30 seconds

The actual cure time is affected by such things as cross-sectional thickness of the Addisil 6100 silicone adhesive, heat capacity of the overall assembly and efficiency and type of oven used (i.e. convection, infrared).

Handling and Safety

Material Safety Data Sheets are available upon request from Momentive performance materials. Similar information for solvents and other chemicals use with Momentive performance materials Products should be obtained from your suppliers. When solvents are used, proper safety precautions must be observed.

CAUTION

Addisil 6100 silicone adhesive can generate flammable hydrogen gas upon contact with acidic, basic, or oxidizing materials. Such contact should be avoided.

Shelf Life and Storage

The warranted shelf life from the material will be indicated by the "use before date" on the associated documents with a minimum of 4 months when stored in the unopened containers at 27 °C or less.

Availability

Addisil 6100 is available in 200 kg drums, 20 kg pails and 310 ml cartridges.



PRINCIPAL LOCATIONS – Regional Information

North America	World Headquarters 187 Danbury Road Wilton, CT 06897, USA	T 800.295.2392	F 607.754.7517
Latin America	Rodovia Eng. Constâncio Cintra, Km 78,5 Itatiba, SP – 13255-700, Brazil	T +55.11.4534.9650	F +55.11.4534.9660
Europe, Middle East, Africa and India	D-51368 Leverkusen Germany	T 00.800.4321.1000 T +31.164.293.276	F +31.164.241.750
Pacific	Akasaka Park Building - 5-2-20 Akasaka Minato-ku, Tokyo 107-6112 Japan	T +81.3.5544.3100	F +81.3.5544.3101

CUSTOMER SERVICE CENTERS

North America	Charleston, WV 25314, USA E cs-na.silicones@momentive.com		
	<ul style="list-style-type: none"> Specialty Fluids UA, Silanes, Resins, and Specialties RTV Products-Elastomers Sealants and Adhesives & Construction 	T 800.523.5862 T 800.334.4674 T 800.332.3390 T 877.943.7325	F 304.746.1654 F 304.746.1623 F 304.746.1623 F 304.746.1654
Latin America	E cs-la.silicones@momentive.com		
	<ul style="list-style-type: none"> Argentina & Chile Brazil Mexico & Central America Venezuela, Ecuador, Peru, Colombia, & Caribbean 	T +54.11.4862.9544 T +55.11.4534.9650 T +52.55.5899.5135 T +58.212.285.2149	F +54.11.4862.9544 F +55.11.4534.9660 F +52.55.5899.5138 F +58.212.285.2149
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	<ul style="list-style-type: none"> Japan China Korea Singapore 	T +81.276.20.6182 T +86.21.5050.4666 (ext. 1523) T +82.2.6201.4600 T +65.6220.7022	

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