

Addisil* 6300

Heat-Curing Silicone Adhesive

Product Description **Addisil 6300** silicone coating is a one-component heat curable silicone coating, 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 6300 is a white, flowable material, which can be applied on a textile by knife over roll.

Compliance with FDA regulations

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
- No formation of cure by-products
- Non-corrosive to metals
- Good performance over a wide temperature range

Typical Product Data

Uncured Properties	Addisil 6300
Colour	white
Density, g/cm ³	1.04
Viscosity@20 °C D = 10 1/s cone plate [Pas]	30
Cured Properties (cured 10 min. at 175°C)	Addisil 6300
Hardness, Shore A	30
Elongation, %	300
Tensile Strength, MPa	205
Modulus at 100%, MPa	0.6

The data's are based on silicone material, which was produced in the lab.

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 6300 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 6300 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 6300 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 6300 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 6300 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 6300 silicone adhesive requires the use of elevated temperatures in order to achieve full cure.

<u>Temperature</u>	<u>Addisil 6300</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 6300 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 6300 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 6300 is available in 200 kg drums and 20 kg pails



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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