

### HYLOSIL 654

Non-Meko Oxime Cure Silicone

#### Description

Hylosil 654 is a neutral, non-corrosive, low odour, Room Temperature Vulcanising, (RTV) silicone sealant/adhesive. It is a high performance engineering grade which can be used in the automotive industry and original equipment manufacturing. It can also be used in a variety of applications and is particularly suitable for high strength applications in odour sensitive environments. It is suitable for use at temperatures between -50°C and 250°C (-58°F and 482°F).

Hylosil 654 is an oxime curing silicone but it has been formulated using the latest cross linking technology so that it will not evolve MEKO on curing.

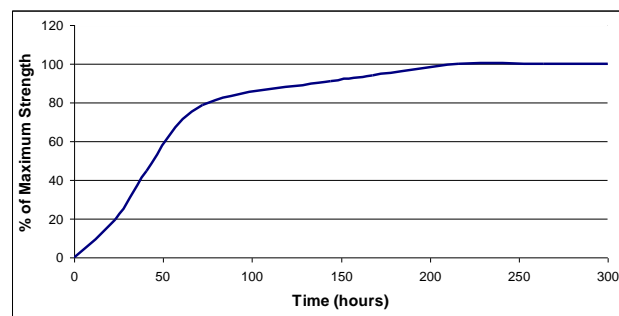
Hylosil 654 is a special purpose adhesive and sealant that can be used for a variety of applications. It has good resistance to oils and aqueous anti-freeze agents

#### General Properties

<b>Colour</b>	Anthracite
<b>Consistency</b>	Non-slump paste
<b>Cross Linking System</b>	Oxime (Non-MEKO)
<b>Specific Gravity (DIN 53479)</b>	1.12 – 1.16
<b>Extrusion Rate 3 mm bead @ 60 psi (BS 3712: Part 1)</b>	150 - 200 g min <sup>-1</sup>
<b>Skin Forming Time at 23°C(73.4°F)/50% RH (BS 5889)</b>	5 -10 minutes

#### Rate of Curing

Tested using aluminium shears with overlap of 25 mm x 25 mm at 22°C (71.6°F) and 60±5% RH.



#### Depth of Cure

3 mm per 24 hours at 22°C (71.6°F) and 60±5% RH.

#### Typical Properties of Cured Material

##### Physical properties

<b>Tensile Strength ISO 37</b>	2.75 N mm <sup>-2</sup>
<b>Elongation % increase @ Break ISO 37</b>	300 – 350 %
<b>E Modulus @ 100% Elongation ISO 37</b>	1.12 N mm <sup>-2</sup>
<b>Hardness ISO 868 (Shore A)</b>	45 <sup>0</sup>

Information given in this publication is based upon technical data gained in our own and other Laboratories and is believed to be true. However the material is used in conditions beyond our control thus we can assume no liability for results obtained or damages incurred through the application of the data present herein.

### Instructions for use

Ensure both surfaces to be bonded are clean, dry and free from contamination such as oil or grease. The compound can be applied to form any size or shape of gasket. Apply a bead directly onto one surface. Once applied, the joint should be assembled without delay.

Care should be taken to ensure any excess compound does not extrude internally and foul any internal oil-ways or other channels and cause blockages. Any excess external product can be wiped away with a damp cloth.

### Typical applications

Gasketing and sealing compound for automotive and engineering applications. The compound readily adheres to most substrates.

### Handling and Safety Properties

Please see product safety data sheet for more information.

The shelf life of Hylosil 654 is 18 months when stored between 5°C and 25°C (41°F and 77°F) in the original unopened containers.

### Packaging

Hylosil 654 is available in 300 ml (10.14fl.oz) cartridges. For other packaging options, please contact our sales department.

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