**Product Information**

**Silicone Sealant**

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**Dow Corning® HM-2500 Assembly Sealant**

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**FEATURES**

- Instant Green Strength
- 100% Silicone
- Low VOC (exempt in CA)
- Safe to handle – nonhazardous composition and by-products
- Neutral Cure RTV
- Adheres to most common substrates
- Open time up to 15 minutes
- Pot life up to 24 hours
- Service temperatures from –50 to 300°F (-45 to 150°C)
- Can be used with standard hot melt dispensing equipment
- Excellent clarity

**APPLICATIONS**

*Dow Corning® HM-2500 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.*

<table>
<thead>
<tr>
<th>Method</th>
<th>Test</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>CTM 0719</td>
<td>Viscosity at 250°F (120°C)</td>
<td>Poise</td>
<td>2100</td>
</tr>
<tr>
<td>CTM 0086</td>
<td>Nonvolatile Content</td>
<td>Percent</td>
<td>&gt;98.5</td>
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<tr>
<td>CTM 0243</td>
<td>Open Time</td>
<td>Minutes</td>
<td>15</td>
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<tr>
<td>CTM 0243</td>
<td>Green Strength at 15 min</td>
<td>Psi</td>
<td>18</td>
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<tr>
<td>CTM 0243</td>
<td>Green Strength at 60 min</td>
<td>Psi</td>
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<tr>
<td></td>
<td>Cure Time, 1/8” bead</td>
<td>Days</td>
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<tr>
<td>ASTM C661</td>
<td>Durometer – Shore A</td>
<td>Points</td>
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<td>ASTM D412</td>
<td>Tensile Strength</td>
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<td>ASTM D412</td>
<td>Elongation</td>
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<td>CTM 0044</td>
<td>Specific Gravity</td>
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<td>CTM 0176</td>
<td>Appearance</td>
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<td>ASTM C711</td>
<td>Service Temperature Range</td>
<td>°F (°C)</td>
<td>-50 to 300 (-45 to 150)</td>
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<tr>
<td>ASTM D4498</td>
<td>Heat- Fail Temp in Shear</td>
<td>°F (°C)</td>
<td>470 (245)</td>
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</table>

CTM: Corporate Test Method, copies of CTM’s are available on request.

**DESCRIPTION**

*Dow Corning® HM-2500 Assembly Sealant* is a 100 percent silicone, neutral cure sealant formulated to have an immediate green strength to offer assembly improvements and other production applications. Products made with this product 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.

**COMPOSITION**

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

**LISTINGS/SPECIFICATIONS**

- FDA Regulations 21 CFR 177.2600 for aqueous applications.
- National Sanitation Foundation, (NSF) List 51 – Food and equipment materials aqueous and dry solids.
- NSF 61 for use with potable water.
- Recognized under UL QMFZ2.
HOW TO USE
Preparation
Surfaces should be clean and dry before sealant application.

Application
*Dow Corning® HM-2500 Assembly Sealant* is from 5 gallon pails or 55 gallon drums with a platen-type hot-melt pump. Application temperature is typically 250°F (120°C).

When the melt temperature has been reached, application with automated or hand-assisted dispensing equipment can begin. Once applied to the substrate the parts should be assembled with 15 minutes. Once applied, this product reacts with the atmospheric moisture to form a weather resistant, flexible, silicone sealant. Exposure of opened containers with air should be minimized.

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. You can also obtain a copy from your local Dow Corning sales representative or Distributor or by calling your local Dow Corning Global Connection.

Material is applied at 250°F (120°C). Use common personal protective equipment to prevent contacting the hot material with skin or eye.

USABLE LIFE AND STORAGE
When stored at or below 90°F (32°C) in the original unopened containers, this product has a usable life of 12 months from the date of production. Refer to product packaging for “Use by Date”.

PACKAGING
This product is available in 50 gram cartridges, 304 ml cartridges, 18 kg pails, 27 kg pails and 205 kg drums.

LIMITATIONS
*Dow Corning® HM-2500 Assembly Sealant* is not intended for use:
- In spaces totally confined from atmospheric moisture during cure
- In continuous water immersion
- On surface that might bleed oils, plasticizers or solvents

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

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