



Technical Data Sheet

SILASTIC™ 3629 Fabric Coating

A two-part liquid silicone rubber for fabric coating

Features & Benefits

- Solventless
- Flowable
- Fast curing
- Easily pigmentable
- Excellent unprimed adhesion to polyamide fabric
- Soft, flexible and easily folded

Applications

- Designed for application to fabrics using conventional knife coating ranges

Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

Test ¹	Property	Unit	Result		
			Part A	Part B	Mixed 10:1
	Mix ratio		10	1	
CTM 0176B	Appearance		Smooth, flowable white liquid	Liquid clear to hazy	
CTM 0050FE	Viscosity, 10 rpm	mPa.s	120,000	480	80,000
ASTM D792	Specific gravity		1.144	0.965	1.128
	Solids content ²	%			> 98
	Mixed pot life, hours ³				> 9
Cured rubber properties, measured on a 2 mm test sheet, cured 10 minutes, 120°C					
ASTM D2240	Durometer hardness	Shore A	27		
ASTM D412	Tensile strength	Mpa	1.3		
ASTM D412	Elongation	%	275		

1. CTM: Corporate Test Method, copies of CTMs are available on request.
ASTM: American Society for Testing and Materials.
2. 2 g sample heated in an aluminum dish for 2 hours at 170°C.
3. Time for viscosity to double at 40°C.

Description

Mixing

The A and B components are supplied strained and de-aired. Mix parts A and B in a 10:1 +/- 0.05 ratio by weight. Manual weighing and mixing using a propeller mixer is suitable for small volumes.

Meter mix equipment which pumps, is strongly recommended for productivity as it meters and mixes the two components without the incorporation of air. Air entrainment should be avoided by careful choice of mixer blade design and mixing speed. It is not normally necessary to vacuum de-air the mixture prior to use.

How To Use

Removal of SILASTIC™ 3629 Fabric Coating From Surfaces

The uncured mixed product and components can be readily removed by most hydrocarbon solvents. Polar solvents such as alcohols and ketones are not recommended.

Cured product cannot easily be removed by conventional cleaning solvents. Mechanical cleaning or products that digest silicone are recommended.

Coating and Curing

SILASTIC 3629 Fabric Coating can be applied to fabrics by conventional coating techniques such as knife over roll or knife over air.

Since SILASTIC 3629 Fabric Coating has a rapid cure rate at elevated temperatures, it may be successfully cured using ovens originally designed for solvent coating. Longer ovens as used for aqueous coating products are also suitable, and allow for higher line speeds. Although the actual cure conditions depend on a number of factors such as coating thickness, oven efficiency and fabric type, as a guide, SILASTIC 3629 Fabric Coating should be cured for a minimum of 1 minute at 160°C. A lower curing temperature is possible, but dwell time needs to be extended in order to fully cure and achieve good adhesion. The upper temperature limit is dependent on the type of fabric used; for example for polyamide, a maximum of 180°C is suggested. It is not necessary to "zone" the oven since no water or solvent removal is involved.

Cure can be inhibited by contact with certain materials such as amines, sulphur and tin complexes. Water must be excluded from the uncured components and mixture, otherwise foaming may occur.

Pigmentation

This may be done continuously during the mixing and dispensing of the product using a meter-mix unit, or it may be done manually in batch mixing. SILASTIC™ LPX liquid color masterbatches are recommended at addition levels up to 4% based on total weight.

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 WWW.CONSUMER.DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

Usable Life And Storage

It is advised to store this product in dry conditions as water can interfere with the reactivity of part B.

When stored at or below 35°C in the original unopened containers, this product has a usable life of 12 months from the date of production.

Packaging Information

This product is supplied in 200 kg A and 20 kg B drums; 20 kg A and 2 kg B pails; sample size 1.2 kg.

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, www.consumer.dow.com or consult your local Dow representative.

<http://www.silastic.com>

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