



1522

1522 is a two-component condensation cure silicone material which has a fast room temperature curing speed and very good adhesion to many different materials. It has very good long term adhesion performance in high temperature conditions. 1522 is designed for use in a variety of applications where long term temperature cycle resistance, UV exposure, and other harsh exposure conditions exist.

Technology / Base	Poly(dimethyl) Siloxane
Type of Product	Silicone Sealant
Components	Two Part
Curing	Room temperature alcohol cure and secondary moisture cure
Appearance / Color	Black
Consistency	Thixotropic Paste

Features and Benefits

- UL Certified
- Low odor and non-corrosive
- Outstanding weather and aging resistance
- High adhesion to a variety of materials including, glass, aluminum and composites
- Outstanding UV resistance, making it ideal for interior and exterior applications
- Designed for use with automated dispensing equipment

Technical Data

Physical Property	Value	Condition/Method
Rheology		
Viscosity, Part A	7 to 14 sec/20g	Extrusion Rate, ASTM C603
Viscosity, Part B	5 to 11 sec/20g	Extrusion Rate, ASTM C603
Viscosity	Thixotropic Paste	
Uncured Material Characteristics		
Specific Gravity		
Volume Mix Ratio	10:1	
Weight Mix Ratio		
Working Time	10 min	
Fixture Time	< 2 hrs	
Cure Schedule	7 days at 25°C, 50% R.H.	
Cured Material Properties		
Thermal Service Range	-50 to 150°C	
Hardness	42 Shore A	ISO7619, GB/T531
Tensile Strength	2.4 MPa	ISO37, GB/528, 23±2°C 50% RH
Elongation to Break	210%	ISO37, GB/528, 23±2°C 50% RH
Lap Joint Shear Strength Aluminum	1.3 MPa	ISO4587, GB/T7124, 23±2°C 50% RH
Electrical Properties		
Volume Resistivity	1.0 x 10 ¹⁵ Ωcm	IEC60093, GB/T1692
Breakdown Voltage	23 kV/mm	IEC 60243-1, GB/T1695
Damp Heat Aging Testing		85°C, 85% RH for 1000 hr
Volume Resistivity		
Hardness	30 Shore A	ISO7619, GB/T531
Shear Strength	1.0 MPa	ISO4587, GB/T7124, 23±2°C 50% RH
Elongation at Break	180%	ISO37, GB/528, 23±2°C 50% RH
Tensile Strength	1.7 MPa	ISO37, GB/528, 23±2°C 50% RH

Test Sample Conditions: 2mm Thickness, Cured at 23±2°C, 50±5%RH for 7 days. Tested at 23±2°C



Typical Applications

- Interior and Exterior Bonding
- Interior and Exterior Sealing
- Encapsulation
- Electrical Connector Sealing

Storage and Shelf Life

Product shall be ideally store in a cool, dry area in unopened containers. Material should be stored at a temperature of 8-25°C for a maximum shelf life of 12 months in the original unopened container. Do not return unused material back into the container.

Curing Conditions

Cure speed will vary with temperature, relative humidity, depth of material and presence of moisture. Some applications may require special surface preparation. Contact H.B. Fuller Company technical support for additional curing recommendations.

Safety and Disposal

For complete safety and handling information, please refer to the appropriate Safety Data Sheets prior to using this product.

General Instructions

It is recommended that an automated dispensing unit be used to mix material. Use alcohol, mechanical polishing, or an organic solvent to clean the surface of the substrates. For best performance bond surfaces should be clean, dry and free of any contaminants and oils. Before use of material, test product adhesion to the substrate to ensure that the adhesive meets desired adhesion performance properties.

This material is a moisture-cure type material. It will start to cure immediately after mixing two components. Moisture in the air will assist to cure material. It is recommended to schedule a timely purge for the use of mixed material in the static mixer. This is done to avoid inconsistent mixing and to ensure desired performance and properties.

Note

The values noted in this data sheet are typical properties only and are not intended to be used as material specifications. For assistance in writing a material specification, please contact H.B. Fuller Company for further details.

Ordering Information

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