

TSE3260

Heat resistant, Flowable Silicone Adhesive

Product Description **TSE3260** is a one-component, flowable, heat curable silicone adhesive designed for high temperature applications. TSE3260 adheres well to a variety of substrates, such as metals, plastics, ceramics and glass without the use of a primer.

- Key Performance Properties**
- Ready to use – one component
 - Excellent high temperature resistance – UL746 TI 190°C (UL File No. E56745)
 - Heat accelerated cure
 - Excellent adhesive properties, primerless adhesion to many types of substrates
 - Non corrosive to metals

Applications Sealing and bonding for high temperature applications like Heaters, Steam Irons, Micro Wave Ovens etc.

Typical Product Data

UNCURED PROPERTIES		
Appearance		Reddish brown
Viscosity (23°C)	Pa·s	23
CURED PROPERTIES (1hr@150°C)		
Density	g/cm ³	1.34
Hardness	Shore A	35
Tensile Strength	MPa	1.7
Elongation	%	250
Adhesive Strength	MPa*	0.5
Volume Resistivity	ohm·cm	1x10 ¹⁵
Dielectric Strength	kV/mm	25
Dielectric Constant (60 Hz)		3.3
Dielectric Loss (60Hz)		3.1
Thermal Conductivity	W/m·K	0.18

* = Aluminium lap shear

Instructions for Use **Compatibility**

TSE3260 silicone adhesive will cure in contact with most clean, dry surfaces. However, certain materials such as water, sulfur, nitrogen compounds, organic metallic salts, phosphorus compounds, etc. contained in the surface of the substrate can inhibit curing. Cure inhibition is characterized by a gummy appearance of TSE3260 silicone adhesive at the interface between the adhesive and the substrate to be bonded. A sample patch test should always be conducted before proceeding to determine compatibility.

Surface Preparation

The adhesive performance of any polymer system is highly dependent upon proper surface preparation. In order to maximize the adhesion of TSE3260 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

TSE3260 silicone adhesive offers outstanding adhesion characteristics to a wide variety of different substrates without the need of a primer. Suitable substrates are: Aluminum, Copper, Ni plated, Stainless Steel, PPS, PBT, Epoxy resin, Polyester, Phenolic resin, Heat Cured Silicone Rubber, Glass, Ceramics

No adhesion will be obtained on: PP, PE, Fluorocarbon resin, RTV Silicone Rubber, Sulfur vulcanized rubbers, Fluorocarbon rubber

For difficult-to-bond-to substrates, or where more aggressive chemical adhesion is desired, the adhesion may be enhanced by using SS4155 silicone primer, available from Momentive performance materials. 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

TSE3260 silicone adhesive requires the use of elevated temperatures in order to achieve full cure. Typical cure times and temperatures are as follows:

Temperature	Cure Time
120°C	2 hours
150°C	1 hour
180°C	10 mins.

The actual cure time is affected by such things as cross-sectional thickness of the TSE3260 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 used with the Momentive performance materials products should be obtained from your supplier. When solvents are used, proper safety precautions must be observed.

Storage and Warranty Period The shelf life will be indicated by the 'use before date' on the associated documents with a minimum of 4 months when stored in the original unopened containers between **0° and 10° C**.

Availability TSE3260 is available in 1 kg cans 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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