

DOW CORNING® 732 Multi-Purpose Sealant

FEATURES

- One-component adhesive/sealant
- Cures at room temperature when exposed to moisture in the air
- Acetoxy cure system
- Non-sag, paste consistency
- Easy to apply
- Cures to a tough, flexible rubber
- Good adhesion to many substrates
- Stable and flexible from -60°C (-76°F) to +180°C (356°F), with short peaks up to +205°C (401°F)
- Black version: stable and flexible from -60°C (-76°F) to +205°C (401°F), with short peaks up to +230°C (446°F)
- Excellent dielectric properties
- Complies with MIL-A-46106A
- Complies with FDA 177.2600
- Available in white, black or clear

Multi-purpose silicone adhesive/sealant

APPLICATIONS

- General industrial sealing and bonding applications.
- Complies with MIL-A-46106A and FDA 177.2600.

TYPICAL PROPERTIES

Specifications writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales representative prior to writing specifications on this product.

CTM*	ASTM*	Property	Unit	Value
As supplied				
0176		Appearance		Non-slump paste
		Color(s)		White, black or clear
0364		Extrusion rate ¹	g/minute	350
0098		Skin-over time	minutes	5-10
0095		Tack-free time	minutes	20
Physical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity				
0097B	D1475	Specific gravity		1.04
0099	D2240	Durometer hardness, Shore A		25
0137A	D412	Tensile strength	MPa	2.2
0137A	D412	Elongation at break	%	550
0420		Volume coefficient of thermal expansion	1/K	1.12x10 ⁻³
Electrical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity				
0114	D149	Dielectric strength	kV/mm	21.6
0112	D150	Dielectric constant at 100Hz/100kHz		2.8
0112	D150	Dissipation factor at 100Hz/100kHz		0.0015
0112	D150	Volume resistivity	Ohm.cm	1.5x10 ¹⁵

1. Extrusion rate: 3.2mm orifice at 0.62MPa.

* CTM: Corporate Test Method, copies of CTMs are available on request.

ASTM: American Society for Testing and Materials.

HOW TO USE

Substrate preparation

All surfaces must be clean and dry. Degrease and wash off any contaminants that could impair adhesion. Suitable solvents include isopropyl alcohol, acetone or methyl ethyl ketone.

Unprimed adhesion may be obtained on many substrates such as glass, metals and most common engineering plastics. Substrates to which good adhesion is normally not obtained include PTFE, polyethylene, polypropylene and related materials.

However, for maximum adhesion, the use of DOW CORNING® 1200 OS

Primer is recommended. After solvent cleaning, a thin coat of DOW CORNING 1200 OS Primer is applied by dipping, brushing or spraying. Allow primer to dry for 15 to 90 minutes at room temperature and a relative humidity of 50% or higher.

How to apply

Apply DOW CORNING 732 Multi-Purpose Sealant to one of the prepared surfaces, then quickly cover with the other substrate to be bonded.

On exposure to moisture, the freshly applied material will "skin over". Any tooling should be completed before this skin forms. The surface is easily tooled with a spatula. The Adhesive/Sealant will be tack-free in less than 45 minutes.

Cure time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) DOW CORNING 732 Multi-Purpose Sealant will cure to a depth of about 3 mm. Very deep sections, especially when access to atmospheric moisture is restricted will take longer to cure completely. Cure time is extended at lower humidity levels.

Before handling and packaging bonded components, users are advised to wait a sufficiently long time to ensure that the integrity of the adhesive seal is not affected. This will depend on many factors and should be determined by the user for each specific application.

Compatibility

DOW CORNING 732 Multi-Purpose Sealant releases a small amount of acetic acid during cure. This may cause corrosion on some metallic parts or substrates, especially in direct contact or when the cure is carried out in a totally enclosed configuration which would not allow cure by-products to escape.

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
SAFETY DATA SHEET IS
AVAILABLE FROM YOUR LOCAL
DOW CORNING SALES
REPRESENTATIVE.

USABLE LIFE AND STORAGE

When stored at or below
32°C (89.6°F) in the original
unopened containers, this product has
a usable life of 30 months from the
date of production.

As DOW CORNING 732 Multi-Purpose Sealant cures by reaction with moisture in air, keep the container tightly sealed when not in use. A plug of used material may form in the tip of a tube or cartridge during storage. This is easily removed and does not affect the remaining contents.

PACKAGING

This product is available in a variety of container sizes. Contact your local Dow Corning sales representative for information about container sizes available in your area.

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 Corning has an extensive Product Stewardship organization and a team of Health, Environment and Regulatory Affairs specialists available in each area.

For further information, please consult your local Dow Corning representative.

WARRANTY INFORMATION - PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that Dow Corning's products are safe, effective, and fully satisfactory for the intended end use. Dow Corning's sole warranty is that the product will meet the Dow Corning sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. Dow Corning specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless Dow Corning provides you with a specific, duly signed endorsement of fitness for use, Dow Corning disclaims liability for any incidental or consequential damages. Suggestions of use shall not be taken as inducements to infringe any patent.

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DOW CORNING AMERICAS

North America

Dow Corning Corporation
Tel.: +1 517 496 6000
Fax: +1 517 496 8026
Toll free from USA:
1 800 248 2481

Canada

Dow Corning Canada, Inc.
Tel.: +1 905 826 9600
Fax: +1 905 858 6005
Toll free from Canada:
1 800 248 2481

Mexico

Dow Corning de Mexico
Tel.: +525 327 1300
Fax: +525 327 1327

South America

Dow Corning do Brasil Ltda.
Tel.: +55 11 3759 4300
Fax: +55 11 3758 5727
Toll free from
Colombia: 9809 12 0276
Venezuela: 880 12112

Argentina

Dow Corning de Argentina
S.A.I.C.
Tel.: +54 11 4814 9600
Fax: +54 11 4816 6119

DOW CORNING ASIA

Australia & New Zealand

Dow Corning Australia Pty Ltd.
Tel.: +61 1300 360 732
Fax: +61 1300 650 785

China (Chengdu)

Dow Corning China Ltd.
Tel.: +86 28 661 9678
Fax: +86 28 661 6756

China (Shanghai)

Dow Corning China Ltd.
Tel.: +86 21 6249 2316
Fax: +86 21 6249 2317

Indonesia, Singapore, Malaysia & Philippines

Dow Corning Singapore Pte Ltd.
Tel.: +65 253 6611
Fax: +65 253 6070

Japan

Dow Corning Toray Silicone
Co Ltd.
Tel.: +81 3 3287 1011
Fax: +81 3 3287 1201

Taiwan (Chungli)

Dow Corning Taiwan Inc.
Tel.: +886 3 462 0534
Fax: +886 3 462 0552

Thailand

Dow Corning (Thailand) Ltd.
Tel.: +66 2 634 7078 to 7088
Fax: +66 2 634 7077

China (Beijing)

Dow Corning China Ltd.
Tel.: +86 10 6500 3051
Fax: +86 10 6504 5652

China (Hong Kong)

Dow Corning Asia
Tel.: +852 2835 0350
Fax: +852 2836 6650

India

Dow Corning India Ltd.
Tel.: +91 22 444 3820
Fax: +91 22 444 3485

Japan

Dow Corning Asia Ltd.
Tel.: +81 3 3287 1141
Fax: +81 3 3287 1088

Korea

Dow Corning Korea Ltd.
Tel.: +82 2 551 7600
Fax: +82 2 551 6800

Taiwan (Taipei)

Dow Corning Taiwan Inc.
Tel.: +886 2 2713 6936
Fax: +886 2 2717 2209

DOW CORNING EUROPE

Germany, Austria, Switzerland & Eastern Europe

Dow Corning GmbH
GERMANY
Tel.: +49 (0)611 - 23 70
Fax: +49 (0)611 - 237 610
E-mail: katja.bechstein@dowcorning.com

France & North Africa

Dow Corning France S.A.
Tel.: +33 (0)4 72 84 13 60
Fax: +33 (0)4 72 84 13 79

Italy & Eastern Mediterranean Countries

Dow Corning S.p.A.
ITALY
Tel.: +39 039 - 60 711
Fax: +39 039 - 68 996 60

Poland

Dow Corning Polska Sp. zo.o.
Tel.: +48 (0)22 645 14 46
Fax: +48 (0)22 645 14 40

United Kingdom, Eire, Nordic Countries, Benelux, South Africa & Middle East

Dow Corning Ltd.
UNITED KINGDOM
Tel.: +44 (0)1 676 52 80 00
Fax: +44 (0)1 676 52 80 01

Spain & Portugal

Dow Corning Ibérica S.A.
SPAIN
Tel.: +34 93 36 36 900
Fax: +34 93 36 36 901