
Product Data

Two-Component Heat Curable Silicone Adhesive

TSE3360

TSE3360 is a two-component, heat curable, non-flowable silicone adhesive designed for sealing and coating. This product adheres well to a variety of substrates, such as metals, plastics, ceramics and glass without the use of a primer.

KEY FEATURES

- ◆ High strength flexible rubber
- ◆ Convenient 1:1 mix ratio by weight
- ◆ Extended pot life - excellent workability
- ◆ Excellent adhesive properties: Primerless adhesion to many types of substrates
- ◆ Non-corrosive to metal
- ◆ Superior electrical properties
- ◆ Resistant to temperature extremes
- ◆ Flame retardant: UL94HB recognized (File No. E56745)

APPLICATIONS

- ◆ Adhesive and sealing for electronic parts such as metals, plastics
- ◆ Coating on plastics and metals by screen printing

TYPICAL PROPERTY DATA

(JIS K 6249)

UNCURED PROPERTIES		(A)	(B)
Appearance		White, semi-flowable	Translucent, non-flowable
Viscosity (23°C)	Pa·s {P}	120 {1,200}	350 {3,500}
Mix ratio by weight		1:1	
Appearance after mixing		White, non-flowable	
Viscosity after mixing (23°C)	Pa·s {P}	640 {6,400}	
Working time (23°C)	h	24	
CURED PROPERTIES (1h @ 150°C)			
Appearance		White, elastic rubber	
Density (23°C)	g/cm ³	1.12	
Hardness (Type A)		42	
Tensile strength	MPa {kgf/cm ² }	5.4 {55}	
Elongation	%	380	
Adhesive strength ^{*1}	MPa {kgf/cm ² }	3.1 {32}	

Linear expansion ^{*2}	1/K	2.0×10^{-4}
Thermal conductivity ^{*2}	W/(m·K)	0.23
Volume resistivity	$\Omega \cdot \text{cm}$	1.0×10^{15}
Dielectric strength	kV/mm	21
Dielectric constant (60Hz)		3.0
Dissipation factor (60Hz)		0.001

*1: Aluminum Lap shear

*2: in-house test method

Typical property data values should not be used as specifications.

ADHESION CAPABILITY

Suitable substrates

- Metals: Aluminum, Copper, Ni plate, Stainless steel
- Plastics: PPS, PBT, Epoxy resin, Polyester, Phenolic resin
- Rubbers: Heat cured silicone rubber
- Inorganics: Glass, Ceramics

Unsuitable substrates

- Plastics: PP, PE, Fluorocarbon resin
- Rubbers: Silicone RTV, Sulfur vulcanized rubbers, Fluorocarbon rubber

HANDLING AND SAFETY

- ◆ Materials such as water, sulfur, nitrogen compounds, organic metallic salts, phosphorus compounds, etc. contained in the surface of the substrate can inhibit curing. A sample patch should always be conducted before proceeding to determine compatibility.
- ◆ All parts should be as clean and dry as possible prior to application.
- ◆ Wear eye protection and protective globes at all time when working with this product.
- ◆ Maintain adequate ventilation in the work area at all times.

STORAGE

- ◆ Store cool dry place out of direct sunlight.
- ◆ Keep out of the reach of children.

PACKAGING

TSE3360(A)

- ◆ 1 kg can available in cases of 10
- ◆ 20 kg pail available

TSE3360(B)

- ◆ 1 kg can available in cases of 10
- ◆ 20 kg pail available

Issued Oct. 2000/2nd revised Oct. 2008

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