Technical Data Sheet

Permatex® Black Silicone Adhesive Sealant

AAM Revised 02/19

PRODUCT DESCRIPTION
Permatex® Black Silicone Adhesive Sealant is a general purpose, single component, room temperature vulcanizing (RTV) compound, designed for the sealing of mechanical assemblies. Upon curing from exposure to moisture in the air, this non-sagging paste forms a tough, flexible, waterproof seal of silicone rubber, which resists aging, weathering and thermal cycling without hardening, shrinking or cracking. **Note: Not recommended for engine gasketing applications.**

PRODUCT BENEFITS
- Low odor formula
- Easy application
- Applied to horizontal or vertical surfaces
- Superior adhesion and flexibility
- Waterproofs
- Insulates
- Unaffected by vibration
- Non-flammable
- Non-toxic

TYPICAL APPLICATIONS
Permatex® Black Silicone Adhesive Sealant is an excellent all-purpose adhesive/sealant for the following materials:
- Metal
- Glass
- Wood
- Plastic
- Silicone resin
- Vulcanized silicone rubber
- Ceramics
- Natural and synthetic fibers
- Painted surfaces

Bonds, seals, repairs, mends and secures:
- Weather stripping
- Windshields
- Windows
- Door frames
- Vinyl tops
- Housings and covers

DIRECTIONS FOR USE

**For Assembly**
1. Remove all previous material from mating surfaces. Permatex®
2. For best results, clean and dry all surfaces with a residue-free solvent, such as Permatex® Brake and Parts Cleaner.
3. Cut nozzle to desired bead size, 1/16" to 1/4" in diameter. An 1/8" bead is usually sufficient for most applications.
4. Remove cap, puncture tube or cartridge seal and attach extension nozzle.
5. Apply a continuous and even bead of silicone to one surface, as shown below:
6. Assemble parts immediately while silicone is still wet. Secure or tighten as required, avoiding excessive squeeze-out.
7. Re-torque will not be necessary after the product has cured.

**For Storage and Cleanup**
1. Allow excess material to extend beyond the extension nozzle to cure, sealing and protecting the remaining product from moisture. For reuse, simply remove the cured product from the tip.
2. Remove uncured product from parts and hand-tools with a dry cloth, if skinned over, break film with a dry cloth to remove as much as possible, and remove the remaining material with Permatex® Gasket Remover (not on painted surfaces) as previously stated.
3. Clean hands with a dry cloth or Permatex® Fast Orange® hand cleaner.

**PROPERTIES OFUNCURED MATERIAL**

<table>
<thead>
<tr>
<th>Property</th>
<th>Typical Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical Type</td>
<td>Oxime silicone rubber</td>
</tr>
<tr>
<td>Appearance</td>
<td>Black non-sag paste</td>
</tr>
<tr>
<td>Odor</td>
<td>Mild</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.42</td>
</tr>
<tr>
<td>Extrusion rate @ 25°C, (grams/min)</td>
<td>&gt;250</td>
</tr>
<tr>
<td>Flash Point TCC °C (°F)</td>
<td>&gt;93 (&gt;200)</td>
</tr>
</tbody>
</table>
**TYPICAL CURING PERFORMANCE**
Permatex® Black Silicone Adhesive Sealant cures on exposure to moisture in the air. The product dries tack free in 1 hour and fully cures in 24 hours. Cure times will vary with temperature, humidity and gap.

**PERFORMANCE OF CURED MATERIAL**
After 7 days at 25°C (77°F), 50% Relative Humidity

<table>
<thead>
<tr>
<th>Typical Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardness (Shore A)</td>
</tr>
<tr>
<td>Elongation, %*</td>
</tr>
<tr>
<td>Tensile Strength, N/mm² (psi)**</td>
</tr>
</tbody>
</table>

*Material will stretch 3.5 times its original length before breaking.
**Amount of force required to break material.

**TYPICAL ENVIRONMENTAL RESISTANCE**

<table>
<thead>
<tr>
<th>Temperature Resistance</th>
<th>Typical Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Continuous, °C (°F)</td>
<td>-59 to 232 (-75 to 450)</td>
</tr>
<tr>
<td>Intermittent, °C (°F)</td>
<td>-59 to 260 (-75 to 500)</td>
</tr>
</tbody>
</table>

**GENERAL INFORMATION**
This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

**ORDERING INFORMATION**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Container Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>81158</td>
<td>3 oz. tube, carded</td>
</tr>
<tr>
<td>81173</td>
<td>11 oz. cartridge</td>
</tr>
</tbody>
</table>

**STORAGE**
Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° and 28°C (46° and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

**NOTE**
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