

ThreeBond 1220H

RTV Silicone

ThreeBond **1220H** is a one component silicone based liquid gasket. It vulcanizes at room temperature (RTV) and forms a rubber-like elastic body offering excellent resistance to vibration and shock. It also has an excellent resistance to heat, automotive oils and fluids and effectively seals joints that are subjected to high temperature.

The resin does not sag.

1. Features

- Alcohol type
- One component solvent free silicone
- Moisture curing
- Service temperature : -60 / +200°C (+250)°C
- Sealing electrical and PCB components

2. Properties

Before curing

Test	Results	Units
Colour	White	-
Viscosity at 25°C	65	Pa.s
Specific gravity at 25°C	1.03	-
Tack free time	10	min

After curing

Test	Results	Units
Hardness	20	shore A
Elongation	500	%
Tensile strength	2.2	MPa
Volume resistivity	2×10^{13}	$\Omega \cdot m$
Dielectric constant at 1 MHz	2.6	-
Dissipation factor at 1 MHz	0.006	
Breakdown voltage	25	kV/mm
Low-Molecular Weight content (LMW) $\sum D_n$ (n=4-10)	200	ppm

Shear strengths

Materials	Shear strength	Units
Aluminium	1.0	MPa
Stainless steel	1.2	MPa
Iron	1.2	MPa
Copper	1.4	MPa
Glass	1.2	MPa
Phenolic resin	1.3	MPa
Epoxy resin	1.4	MPa
Polyester resin	1.0	MPa
Acrylic resin	1.3	MPa
PET	1.3	MPa
PBT	1.0	MPa
PPE	1.2	MPa
PPS	1.4	MPa
PC	1.4	MPa
PA6.6	1.4	MPa
ABS	1.4	MPa

Cured at 25°C, 50%RH for 7 days

Thick film curability

Time	Thickness	Units
30 min	0.5	mm
1h	0.7	
2h	1.0	
3h	1.3	

At 25°C, 50% RH

3. Handling

- Before use, please refer to the safety data sheet.

Data given here were compiled to the best of our knowledge and are based on experiments and tests of our Company. We cannot guarantee the results obtained through the use of our products, and all products are sold and samples given without any warranty, expressed or implied, of fitness for any particular purpose or otherwise and upon condition that the user shall make his own tests to determine the suitability of the product for his purpose.

- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.
- Depending on the materials (dimensions and surface roughness), apply an appropriate and uniform amount of liquid gasket on the surface, then assemble rapidly.
- Tack free time and curing speed will vary depending on room temperature and humidity ratio.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Excess product may be removed using TB2890D cleaner.
- Keep the product in its original container, tightly sealed and store it in a dark, dry and well ventilated place at **10 ~ 25°C**.