

# Dow Corning® 730 FS Solvent Resistant Adhesive/Sealant

## FEATURES

- One-component fluorosilicone 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 -65°C (-85°F) to 260°C (500°F)
- Retains its properties under exposure to fuels, oils and solvents

Solvent resistant silicone adhesive/sealant

## APPLICATIONS

- For bonding and sealing applications where resistance to the swelling effects of fuels, solvents and oils is required.
- For assembling and/or repairing of fuel systems and tanks.
- Used for formed-in-place gaskets where irregular shapes and harsh conditions reject ordinary seals.
- For bonding or sealing of components exposed to moisture, vibration, shock, fuels, solvents and oils for long periods of time.

## TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

CTM*	ASTM*	Property	Unit	Result
		<b>As supplied</b>		
0176		Appearance		Non-slump paste White
0364		Colors		White
0098		Extrusion rate <sup>1</sup>	g/minute	321
0095		Skin-over time	Minutes	12
		Tack-free time	Minutes	14
<b>Mechanical properties, cured 7 days in air at 23°C (73°F) and 50% relative humidity</b>				
0022	D792	Specific gravity		1.44
0099	D2240	Durometer hardness, Shore A		40
0137A	D412	Tensile strength	MPa(psi)	3.0(434)
0137A	D412	Elongation at break	%	195
0159A	D624	Tear strength – die B	kN/m(ppi)	11.9(68)
		Brittle point	°C	-65
			°F	-85
0293		Peel strength, aluminum, primed	kN/m(ppi)	6.8(39)
<b>Electrical properties, after 7 days cure in air at 25°C (77°F) and 50% relative humidity</b>				
0171		Arc resistance	Seconds	124
0114	D149	Dielectric strength	Volts/mil	372
0112	D150	Dielectric constant at 100Hz		7.11
0112	D150	Dissipation factor at 100kHz		0.007
0112	D150	Volume resistivity	Ohm.cm	5.1x10 <sup>13</sup>

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

ASTM: American Society for Testing and Materials.

1. Extrusion rate: 3.2mm orifice at 0.62 MPa., 1/8" orifice at 90 psi.

## DESCRIPTION

*Dow Corning*<sup>®</sup> 730 FS Solvent Resistant Adhesive/Sealant is a ready-to-use, solventless, nonslumping fluorosilicone rubber paste that reacts with moisture in the air to form a tough, rubbery solid. It is a fluid-resistant material that is ideally suited for use in many applications where resistance to fumes, splash, and sometimes even total immersion in fuels, oils and solvents is needed.

*Dow Corning* 730 FS Solvent Resistant Adhesive/Sealant features good resistance to weathering, vibration, moisture, ozone, and temperature extremes. It retains its flexibility over a wide temperature.

*Dow Corning* 730 FS Solvent Resistant Adhesive/Sealant can be applied overhead or on vertical surfaces without fear of sagging, slumping or running off.

## USES

*Dow Corning* 730 FS Solvent Resistant Adhesive/Sealant is used primarily for bonding, sealing and caulking applications where resistance to the swelling effects of fuels, oils and solvents is needed. Other potential applications include:

- Sealing seams on various liquid storage tanks
- Sealing fuel lines and tanks
- Providing temporary patch for rubber linings
- Sealing pipe joints on lines carrying solvents
- Providing formed-in-place gaskets for sealing chemical compressors
- Providing formed-in-place gaskets where irregular shapes and harsh conditions reject ordinary seals
- Bonding or sealing components exposed to moisture, vibration, shock, certain fuels, oils and solvents for long periods of time

## 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 many common engineering plastics. Substrates to which good adhesion is normally not obtained include PTFE, polyethylene, polypropylene and related materials.

For maximum adhesion, the use of *Dow Corning*<sup>®</sup> 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* 730 FS Solvent Resistant Adhesive/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" in about 5 minutes at room temperature and 50% relative humidity. 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 about 25 minutes.

### Cure time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) *Dow Corning* 730 FS Solvent Resistant Adhesive/Sealant will cure to a depth of about 3mm. Very deep sections, especially when access to atmospheric moisture is restricted, will take longer to cure completely. Cure time is extended at over 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* 730 FS Solvent Resistant Adhesive/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 material safety data sheet is available on the Dow Corning Web site at [dowcorning.com](http://dowcorning.com). You can also obtain a copy from your local Dow Corning sales representative or Distributor or by calling your local Dow Corning Global Connection.

## USABLE LIFE AND STORAGE

When stored at or below 32°C (90°F) in the original unopened containers, *Dow Corning* 730 FS Solvent Resistant Adhesive/Sealant has a usable life of 18 months from the date of production.

As *Dow Corning* 730 FS Solvent Resistant Adhesive/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 content.

**Table I: Typical Fluid Resistance Values**  
 These values are not intended for use in preparing specifications.

<b>Fluids</b>	<b>Volume Swell, %</b>	<b>Durometer Hardness, pts change</b>
Methanol .....	1.4	-4
JP-5 .....	2.5	-5
Diesel .....	1.5	-5
Isopropanol .....	1.7	-4
JP-8 .....	3.1	-4
<i>Dow Corning</i> <sup>®</sup> OS 20 Fluid .....	3.6	-2

*Dow Corning*<sup>®</sup> 730 FS Solvent Resistant Adhesive/Sealant, cured 7 days before immersion, properties obtained after 7 days immersion at room temperature.

**Table II: Typical Thermal Stability Properties for *Dow Corning*<sup>®</sup> 730 FS Solvent Resistant Adhesive/Sealant**  
 These values are not intended for use in preparing specifications.

	<b>Exposure Time (Days)</b>				
	<b>0</b>	<b>1</b>	<b>3</b>	<b>7</b>	<b>14</b>
<b>Tested at Room Temperature After Exposure at 300°F (149°C)</b>					
Durometer Hardness, Shore A, points	43	44	45	45	47
Tensile Strength, Mpa (psi)	2.99 (434)	3.38 (490)	3.14 (456)	3.03 (439)	2.98 (432)
Elongation, percent	195	195	177	171	159
Tear Strength, kN/m (ppi)	11.91 (68)	26.97 (154)	9.63 (55)	9.11 (52)	8.93 (51)
<b>Tested at Room Temperature After Exposure at 400°F (204°C)</b>					
Durometer Hardness, Shore A, points	43	43	46	47	45
Tensile Strength, Mps (psi)	2.99 (434)	3.03 (439)	2.65 (385)	2.62 (381)	2.25 (327)
Elongation, percent	195	173	140	138	128
Tear Strength, kN/m, (ppi)	11.91 (68)	9.28 (53)	8.76 (50)	8.41 (48)	8.06 (46)

**PACKAGING INFORMATION**

This product is available in standard industrial container sizes. For details please refer to your Dow Corning sales office.

**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 Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our Web site, [dowcorning.com](http://dowcorning.com) or

consult your local Dow Corning representative.

**LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY**

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