



Technical Data Sheet

DOWSIL™ HM-2510 Assembly Sealant

Hot melt silicone assembly sealant

Features & Benefits

- Instant green strength
- 100% silicone
- Low VOC
- Safe to handle – nonhazardous composition and by-products
- Neutral cure
- Adheres to most common substrates
- Open time up to 15 minutes
- Pot life up to 24 hours
- Excellent clarity
- Service temperatures from -58 to 300°F (-50 to 150°C)
- Can be used with standard hot melt dispensing equipment
- Immediate green strength allows parts to be moved immediately
- Long open time, long pot life and moderate application temperature (250°F [121°C]) offer a user friendly application
- High viscosity at room temperature resists flow of material reducing sealant squeeze out and clean up

Composition

- Moisture curing, 100 percent silicone, reactive hot-melt sealant

Applications

- DOWSIL™ HM-2510 Assembly Sealant is designed for use as an assembly sealant. This product utilizes hot melt technology to dispense the material which utilizes silicone technology to achieve instant green strength when dispensed and cures to strong moisture cured silicone sealant.

Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

Test	Property	Unit	Result
CTM ¹ 0719	Viscosity at 248°F (120°C)	poise	1100
CTM 0086	Nonvolatile Content	percent	> 98.5
CTM 0243	Open Time	minutes	15
CTM 0243	Green Strength at 15 Minutes	psi	6
CTM 0243	Green Strength at 60 Minutes	psi	7

1. CTM: Corporate Test Method, copies of CTM's are available on request.

Typical Properties (Cont.)

Test	Property	Unit	Result
CTM 1345	Cure Time, 1/8" Bead	days	2
CTM 0099	Durometer – Shore A	points	38
ASTM ² D412	Tensile Strength	psi	670
ASTM D412	Elongation	percent	1900
ASTM D412	Modulus at 50% Elongation	psi	80
CTM 0044	Specific Gravity, Uncured		1.07
CTM 0176	Appearance		Water clear
ASTM C711	Service Temperature Range	°F	-58 to 300
		°C	-50 to 150
ASTM D4498	Heat- Fail Temp in Shear	°F	482
		°C	250

2. ASTM: American Society for Testing and Materials

Description

DOWSIL™ HM-2510 Assembly Sealant is a 100 percent silicone, neutral cure sealant formulated to have immediate green strength which offers assembly improvements and uses in other production applications. Products made with this can be immediately handled. As a viscoelastic material, when cured and then exposed to high temperatures this product will soften but recovers to its typical properties when cooled down.

Listings/ Specifications

FDA Regulations 21 CFR 177.2600 for aqueous applications.

National Sanitation Foundation list 61 for use with potable water.

National Sanitation Foundation list 51 food and equipment materials for aqueous and dry solids.

Recognized under UL QMFZ2.

Handling Precautions

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. 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 ON THE DOW WEBSITE AT DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

Usable Life and Storage

DOWSIL™ HM-2510 Assembly Sealant has a shelf life of 12 months from date of manufacture when stored in original, unopened containers in a clean and dry environment below 90°F (32°C).

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 has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, dow.com or consult your local Dow representative.

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