DOW CORNING® 732
Multi-Purpose Sealant

FEATURES
- One-component 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 -60°C (-76°F) to +180°C (356°F), with short peaks up to +205°C (401°F)
- Black version: stable and flexible from -60°C (-76°F) to +205°C (401°F), with short peaks up to +230°C (446°F)
- Excellent dielectric properties
- Complies with MIL-A-46106A
- Complies with FDA 177.2600
- Available in white, black or clear

APPLICATIONS
- General industrial sealing and bonding applications.
- Complies with MIL-A-46106A and FDA 177.2600.

TYPICAL PROPERTIES
Specifications writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales representative prior to writing specifications on this product.

<table>
<thead>
<tr>
<th>CTM* ASTM* Property</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>As supplied</td>
<td></td>
<td></td>
</tr>
<tr>
<td>0176 Appearance</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Color(s)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>0364 Extrusion rate¹</td>
<td>g/minute</td>
<td>350</td>
</tr>
<tr>
<td>0098 Skin-over time</td>
<td>minutes</td>
<td>5-10</td>
</tr>
<tr>
<td>0095 Tack-free time</td>
<td>minutes</td>
<td>20</td>
</tr>
<tr>
<td>Physical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity</td>
<td></td>
<td></td>
</tr>
<tr>
<td>0097B D1475 Specific gravity</td>
<td></td>
<td>1.04</td>
</tr>
<tr>
<td>0099 D2240 Durometer hardness, Shore A</td>
<td></td>
<td>25</td>
</tr>
<tr>
<td>0137A D412 Tensile strength</td>
<td>MPa</td>
<td>2.2</td>
</tr>
<tr>
<td>0137A D412 Elongation at break</td>
<td>%</td>
<td>550</td>
</tr>
<tr>
<td>0420 Volume coefficient of thermal expansion</td>
<td>1/K</td>
<td>1.12 x 10⁻³</td>
</tr>
<tr>
<td>Electrical properties, cured 7 days in air at 25°C (77°F) and 50% relative humidity</td>
<td></td>
<td></td>
</tr>
<tr>
<td>0114 D149 Dielectric strength</td>
<td>kV/mm</td>
<td>21.6</td>
</tr>
<tr>
<td>0112 D150 Dielectric constant at 100Hz/100kHz</td>
<td></td>
<td>2.8</td>
</tr>
<tr>
<td>0112 D150 Dissipation factor at 100Hz/100kHz</td>
<td></td>
<td>0.0015</td>
</tr>
<tr>
<td>0112 D150 Volume resistivity</td>
<td>Ohm.cm</td>
<td>1.5 x 10⁻⁸</td>
</tr>
</tbody>
</table>

¹. Extrusion rate: 3.2mm orifice at 0.62MPa.
* CTM: Corporate Test Method, copies of CTMs are available on request.

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

However, for maximum adhesion, the use of DOW CORNING® 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 732 Multi-Purpose 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". 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 less than 45 minutes.

**Cure time**

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) DOW CORNING 732 Multi-Purpose Sealant will cure to a depth of about 3 mm. Very deep sections, especially when access to atmospheric moisture is restricted will take longer to cure completely. Cure time is extended at lower 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 732 Multi-Purpose 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**

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 SAFETY DATA SHEET IS AVAILABLE FROM YOUR LOCAL DOW CORNING SALES REPRESENTATIVE.

**USABLE LIFE AND STORAGE**

When stored at or below 32°C (89.6°F) in the original unopened containers, this product has a usable life of 30 months from the date of production.

As DOW CORNING 732 Multi-Purpose 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 ia easily removed and does not affect the remaining contents.

**PACKAGING**

This product is available in a variety of container sizes. Contact your local Dow Corning sales representative for information about container sizes available in your area.

**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 Health, Environment and Regulatory Affairs specialists available in each area.

For further information, please consult your local Dow Corning representative.

**WARRANTY INFORMATION - PLEASE READ CAREFULLY**

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that Dow Corning's products are safe, effective, and fully satisfactory for the intended end use. Dow Corning's sole warranty is that the product will meet the Dow Corning sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. Dow Corning specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless Dow Corning provides you with a specific, duly signed endorsement of fitness for use, Dow Corning disclaims liability for any incidental or consequential damages. Suggestions of use shall not be taken as inducements to infringe any patent.
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