



# DOW CORNING® 734

## Flowable Adhesive/Sealant

### FEATURES

- One-component adhesive/sealant
- Cures at room temperature when exposed to moisture in the air
- Acetoxy cure system
- Flowable and self-levelling
- Easy to apply
- Cures to a tough, flexible rubber
- Fast tack-free time
- Good adhesion to many substrates
- Stable and flexible from -65°C to +180°C
- Excellent dielectric properties
- Complies with MIL-A-46106B

### Flowable silicone adhesive/sealant

### APPLICATIONS

- General industrial sealing and bonding applications requiring a flowable product.
- Particularly suitable for sealing assemblies with fine joints as well as cable entries and connectors, to ensure that they remain water tight.
- Due to its good adhesion to other silicone rubbers, ideally suited for making field repairs on existing equipment where a part of an existing silicone encapsulant has been removed.

### TYPICAL PROPERTIES

Specification 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.

CTM*	ASTM*	Property	Unit	Value
<b>As supplied</b>				
0176		Appearance		Flowable liquid
		Color		White or clear
0050	D1084	Viscosity at 25°C	mPa.s	45,000
0098		Skin-over time	minutes	7
0095		Tack-free time	minutes	13
0208		Non-volatile content after 24 hours at 70°C	%	95
<b>Physical properties measured on 2mm thick sheet after 7 days cure in air at 25°C and 50% relative humidity</b>				
0022	D792	Specific gravity		1.03
0099	D2240	Durometer hardness, Shore A		27
0137A	D412	Tensile strength	MPa	1.5
0137A	D412	Elongation at break	%	315
0159A	D624	Tear strength - die B	kN/m	3.0
0057		Brittle point	°C	-65
<b>Electrical properties, after 7 days cure in air at 25°C and 50% relative humidity</b>				
0114	D149	Dielectric strength	kV/mm	17
0249	D257	Volume resistivity	Ohm.cm	1x10 <sup>14</sup>
0112	D150	Permittivity at 100Hz		2.7
0112	D150	Permittivity at 100kHz		2.7
0112	D150	Dissipation factor at 100Hz		0.00034
0112	D150	Dissipation factor at 100kHz		0.00019

\* CTM: Corporate Test Method, copies of CTMs are available on request.  
 ASTM: American Society for Testing and Materials.

## 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.

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 734 Flowable Adhesive/Sealant to the prepared surfaces in a uniform thickness of 0.25 to 0.75mm. If the adhesive is to be used to bond two surfaces, apply it only to one surface and allow it to establish a uniform contact before putting the other surface in place. When placing the second, use enough pressure to spread the adhesive and displace any trapped air.

On exposure to moisture, the freshly applied material will "skin over" in about 7 minutes at room temperature and 50% relative humidity. Any tooling should be completed before this skin forms.

### Cure time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) DOW CORNING 734 Flowable 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 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 734 Flowable 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 SAFETY DATA SHEET IS AVAILABLE FROM YOUR LOCAL DOW CORNING SALES REPRESENTATIVE.

### USABLE LIFE AND STORAGE

When stored at or below 32°C in the original unopened containers DOW CORNING 734 Flowable Adhesive/Sealant has a usable life of 24 months from the date of production.

As DOW CORNING 734 Flowable 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 contents.

### PACKAGING

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, food contact 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.