



Technical Data Sheet

DOWSIL™ 816 High Temperature Silicone Sealant Red

Temperature resistant silicone sealant

Features & Benefits

- One-part sealant
- 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), with short peaks up to +315°C (+599°F)
- Complies with MIL-A-46106B
- Resistant to ozone and ultra-violet radiation

Applications

- Sealing and bonding applications exposed to high temperatures

Typical Properties

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

CTM ¹	ASTM ²	Property	Unit	Result
As supplied				
0176		Appearance		Non-slump paste
		Color		Red
0364		Extrusion rate	g/minute	330
0098		Skin-over time	minutes	10
0095		Tack-free time	minutes	13
Physical properties measured on 2 mm thick sheet after 7 days cure in air at 23°C (73°F) and 50% relative humidity				
0022	D792	Specific gravity		1.04
0099	D2240	Durometer hardness, Shore A		26
0137A	D412	Tensile strength	MPa	2.2
0137A	D412	Elongation at break	%	560
0293		Peel strength, aluminium, unprimed	kN/m	5.5
0293		Peel strength, low carbon steel	kN/m	5.1

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

Technical Specifications and Standards

Conforms to MIL-A-46106B. Performance related to mildew and fungus resistance has been tested in accordance with the ISO-Norm 846.

How to Use

Substrate Preparation

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 DOWSIL™ 1200 OS Primer is recommended. After solvent cleaning, a thin coat of DOWSIL™ 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 DOWSIL™ 816 High Temperature Silicone Sealant Red 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 10 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.

Cure Time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) DOWSIL™ 816 Silicone 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

DOWSIL™ 816 Silicone 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 byproducts to escape.

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

When stored at or below 32°C (90°F) in the original unopened containers, DOWSIL™ 816 Silicone Sealant has a usable life of 30 months from the date of production.

As DOWSIL™ 816 Silicone 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 Information

DOWSIL™ 816 Silicone Sealant is available in 90 ml tubes, 310 ml cartridges, 20 liter pails and 205 kg drums.

Limitations

This product is not suitable for areas where food contact is likely.

Bleeding can occur on porous substrates such as concrete, marbles, granites and other natural stones. To determine the appropriate product for use on these sensitive substrates, specific testing should be carried out.

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.

Disposal Considerations

Dispose in accordance with all local, state (provincial) and federal regulations. Empty containers may contain hazardous residues. This material and its container must be disposed in a safe and legal manner.

It is the user's responsibility to verify that treatment and disposal procedures comply with local, state (provincial) and federal regulations. Contact your Dow Technical Representative for more information.

Product Stewardship

Dow has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with Dow products - from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

Customer Notice

Dow strongly encourages its customers to review both their manufacturing processes and their applications of Dow products from the standpoint of human health and environmental quality to ensure that Dow products are not used in ways for which they are not intended or tested. Dow personnel are available to answer your questions and to provide reasonable technical support. Dow product literature, including safety data sheets, should be consulted prior to use of Dow products. Current safety data sheets are available from Dow.

dow.com

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