

One Part, Fast Cure RTV Silicone Peel-able Sealant/Mask

PRODUCT DESCRIPTION

Incure Pyra-Sil™ 894 is a one-part, self-levelling, clean peel-able coating for temporary protection applications. Ideal for applications with working (pot-life) of less than 8 mins, it cures to a Tack-Free surface in 15 mins and full cure in 72 hrs. Provides flexible yet durable protection to resist weathering, moisture, damage due to UV rays and high temperatures in sandblasting operations, machining and plating operations. Peels off clean on plastics, wood and metals. Incure 894 can be coated on various substrates and is designed for both manual brushing and high volume automatic dispensing systems.

CURE SCHEDULE

Primary UV Cure, sec	N.A.
Secondary Moisture Cure, hr	24

UNCURED PROPERTIES

Chemical Type	Oxime Cure
Appearance	Translucent
Viscosity, cP (rpm)	35,000 - 45,000
Density, g/ml	0.99

CURED PROPERTIES

Hardness, Shore	A15 to A25
Chemical Resistance	Good
Service Temperature	-45°C to 260°C (-49°F to 500°F)
Peel Strength, PSI (ASTM D790)	N.A.
Tensile Shear, PSI (ASTM D1002-94)	120
Elongation, %	110

ADVANTAGES

Incure Pyra-Sil™ one-part moisture cure silicones cure at room temperature with no curing ovens and the energy costs. Adheres to many metals, ceramics, glass, laminates and plastics. Surface cures within 5 mins and 95% strength achieved from 24 to 72hrs. Heat < 60°C (140°F) may be used to accelerate cure. Excellent physical and electrical properties over a broad range of operating conditions.

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CURE SCHEDULE

Product is best cured with a high intensity lamp, preferably > 200mW/cm² of UVA. UV exposure starts the curing process and firm up the material with a skin layer, with moisture cure taking over to complete the full curing process. See Cure-Depth vs Time guide.

CURE DEPTH VS TIME GUIDE

Total Energy (J/cm ²)	After 24-hr*	After 48-hr*	After 168-hr*
2,000mJ/cm ²	4.8mm	7.9mm	12.5mm
3,000mJ/cm ²	5.0mm	8.1mm	12.5mm
4,000mJ/cm ²	5.1mm	8.3mm	12.5mm

*Guide based on 55% Relative Humidity, 25°C

SURFACE PREPARATION

All bonding surfaces must be free from contaminants such as grease, loose particles, oils, corrosive chemical stains etc. Rough or porous material such as metal castings should be baked at high temperature to burn off any embedded contaminants, especially trapped oils and chemicals. Smooth metal surfaces should ideally be abrasive blasted to 0.25mm (0.001") for optimum results.

APPLICATION PROCEDURES

Prepared surface can be coated simply by brushing method, dipping or dispensing (for selective area coating). Products with viscosities lower than 500cP are suitable for use on spraying systems.

STORAGE AND PREPARATION FOR USE

This product carries shelf-life of 6 months in the original, unopened packaging. For optimum results, all Pyra-Sil™ products should be stored in original containers below 22°C (72°F) in a cool dry place. Sealed containers in original packaging are guaranteed for 6 months when stored in the recommended temperature.

NOTE

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