

# PLASTOSIL N294 BLUE

## CHARACTERISTICS

PLASTOSIL N 294 is a free-flowing, ready-to-use silicone rubber that vulcanises either at room temperature or at high temperatures under the influence of atmospheric moisture. It is available in blue, white and red colour.

## SPECIAL CHARACTERISTICS

- One - part
- resistant to high temperatures
- resistant to mineraloil and water
- solvent free
- long open time

## APPLICATIONS

PLASTOSIL N 294 blue can be used for printing of sealing patterns on diverse substrates like steel or sulphur containing or sulphur free cylinder head gaskets by silk-screen printing.

## PRODUCT DATA

PROPERTY	TEST METHOD	UNIT	VALUE
Color			blue, red, white
Skin- forming time, 23° C, 50 % RH		[h]	6
Viscosity at 25°C, after stirring	ISO 3219	[mPa s]	22, 000

These figures are only intended as a guide and should not be used in preparing specifications.

## PRODUCT DATA

PROPERTY	TEST METHOD	UNIT	VALUE
Colour			blue, red, white
Density at 23°C, in water	ISO 2781	[g/cm <sup>3</sup> ]	1.21
Hardness Shore A	ISO 868		33
Elongation at break	ISO 37	[%]	300
Tensile strength	ISO 37	[N/mm <sup>2</sup> ]	2.2
Tear resistance 2 mm sheet, after 14 days at 23°C/50 % RH	ASTM D 624 B	[N/mm]	4,5

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## PROCESSING

Some filler may settle during transport and storage. To ensure a uniform mix, the components should be thoroughly stirred prior to use.

PLASTOSIL N 294 is a moisture curing silicone sealant. For this reason the curing rate strongly depends on both temperature and atmospheric humidity in the surrounding (see table below).

TEMPERATURE	CURING TIME Thickness 0.1 mm in a circulating air oven
150 °C	30 min
175 °C	15 min
200 °C	10 min
175 °C with steam	5 min

PLASTOSIL N 294 can be applied with standard silkscreen printing equipment.

## STORAGE STABILITY

PLASTOSIL N 294 blue has a shelf life of at least 9 months when stored at 23°C maximum in the originally sealed container. The 'Best use before and date of each batch appears on the product label.

Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

## SAFETY INFORMATION

PLASTOSIL N 294 releases during cure a total of approx. 5% butanone oxime. These vapours should not be inhaled for long periods or high concentrations. Work areas should therefore be well ventilated.

B.F. PLASTOSIL S.R.L.