

Revised
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TECHNICAL DATA SHEETS
FLEX 1200
SILICONE

Description:

FLEX 1200 is a non-slumping, non-corrosive, low odor, low volatile, single component, room temperature vulcanizing (RTV) silicone adhesive/sealant. It has been designed specifically for on line, low pressure tests carried out before product begins to cure. Product exhibits excellent resistance to automotive engine oils.

Typical Applications:

Designed primarily for flange sealing with good oil resistance and to withstand high joint-movement requirements. For example, stamped sheet metal covers (timing covers and oil sumps).

PROPERTIES OF UNCURED MATERIAL

Typical	Value	Range
Chemical Type	Oxime Silicone Rubber Paste	
Appearance	Paste	
Specific Gravity @ 20°C	1.34	1.30 to 1.37
Viscosity @ 25°C	Thixotropic Paste	
Extrusion Rate gm/min: (3mm nozzle, 6 bar, 25°C)	35	20 to 50
Flash Point (TCC), °C	>93	

TYPICAL CURING PERFORMANCE

Tack Free Time

The surface of this adhesive becomes dry to touch on exposure to atmospheric moisture in 7 to 24 minutes at 23±2°C, 50±5%RH.

Electrical Properties

	Constant	Loss	
Dielectric constant & loss, ASTM D150,	@ 1 kHz	5.05	0.048
	@ 100kHz	4.29	0.042
	@ 1MHz	4.13	0.023
	@ 10MHz	4.12	0.013
Volume resistivity, ASTM D257, Ω.cm		6.70 x 10 ¹³	
Surface resistivity, ASTM D257, Ω		4.35 x 10 ¹⁵	
Physical Properties			
Hardness, Shore A, ASTM D2240		35	
Elongation at break, %, ASTM D412		400 minimum	
Tensile strength, N/mm ² , ASTM D412		1.4 minimum	

PERFORMANCE OF CURED MATERIAL

(After 21 days @ 23±2°C, 50±5% RH at 0.5mm gap)
Isopropyl Alcohol wiped substrates

	Value	Typical Range	
Shear Strength, ASTM D1002, DIN 53283	Mild steel, N/mm ²	1.2	1.0 to 1.4
	(psi)	(150)	(150 to 200)
	Aluminum (T2024), N/mm ²	1.0	0.7 to 1.3
	(psi)	(150)	(100 to 190)
	Aluminum (Alclad), N/mm ²	1.3	1.0 to 1.5
	(psi)	(180)	(150 to 220)
Zinc Dichromate, N/mm ²	1.3	1.0 to 1.5	
	(psi)	(180)	(150 to 220)

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

Engineering Excellence

For technical information and support call **1-800-552-0299** or visit our website at

www.instantca.com