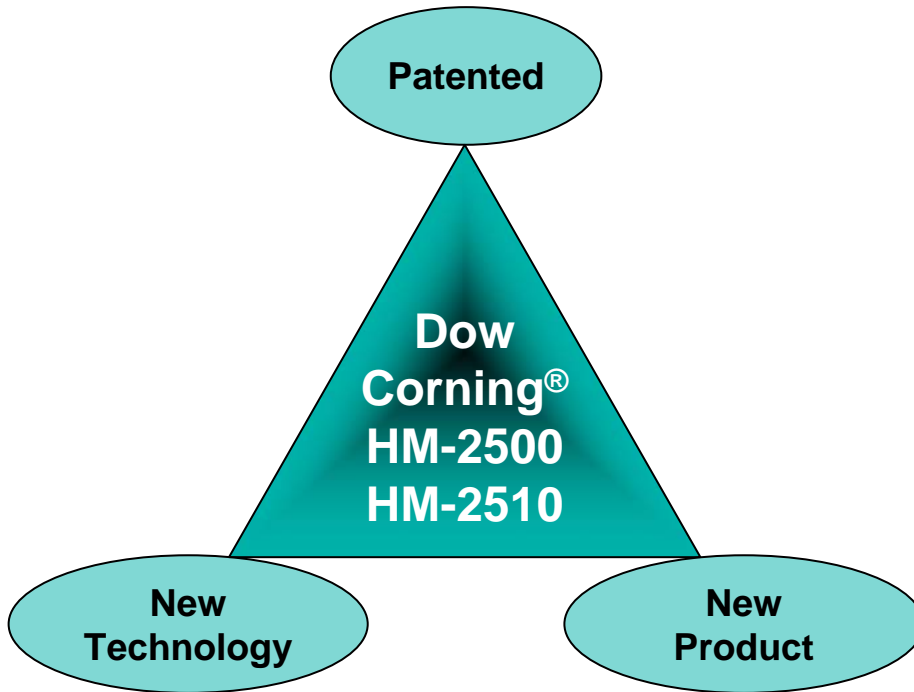


Dow Corning® HM-2500/HM-2510 Assembly Sealant

Silicone Reactive Hot Melt -
**An Innovative Silicone Sealant
Technology**

Dow Corning® HM-2500/HM-2510 Assembly Sealant



- ✓ High Green Strength
(better than double sided tapes)
- ✓ Ultra Clear
- ✓ 100% Silicone
- ✓ High Viscosity at Room Temp
(500,000 poise)
- ✓ Pumps like a sealant at 120° C
(1050 - 2,100 poise)
- ✓ Tacky but dry to the touch
- ✓ Tenacious adhesion without
primers to most (if not all
substrates)
- ✓ Very low Volatile Organic
Compounds (VOC)
- ✓ Paintable?

Silicone Reactive Hot Melt

Dow Corning[®] HM-2500/HM-2510 has the typical properties of silicone sealants

- 100% Silicone
- Neutral Cure (Alkoxy Sealant Technology)
- Excellent Adhesion
e.g. PVC, Wood, Glass, Aluminum, Coatings, Paints, Acrylic, Fiberglass, Polypropylene, Polystyrene
- Outstanding UV resistance
- Broad Temperature Resistance
- High Mechanical Strength
 - High Tensile Strength (2.3 – 2.7 MPa),
Extremely High Elongation (760 - 1000%),
Medium 100% Modulus (0.67 MPa: HM-2500)

Silicone **Reactive** Hot Melt

Dow Corning[®] HM-2500/HM2510 is a Moisture Curing Silicone Adhesive/Sealant

- Cures to a Silicone Elastomer
- Reacts with Atmospheric Moisture
- Forms Permanent Adhesive Bond
- Stable in Application Process
- Uses Dow Corning Cure Chemistry (20 years of proven performance)

Silicone Reactive Hot Melt

What is a Hot Melt?

- Hot Melt Adhesive

A classification of materials that are generally nearly 100% solids which are solid at room temperature and applied in a molten state at elevated temperatures.

Instant strength is achieved by the removal of heat.

- Reactive Hot Melt Adhesive

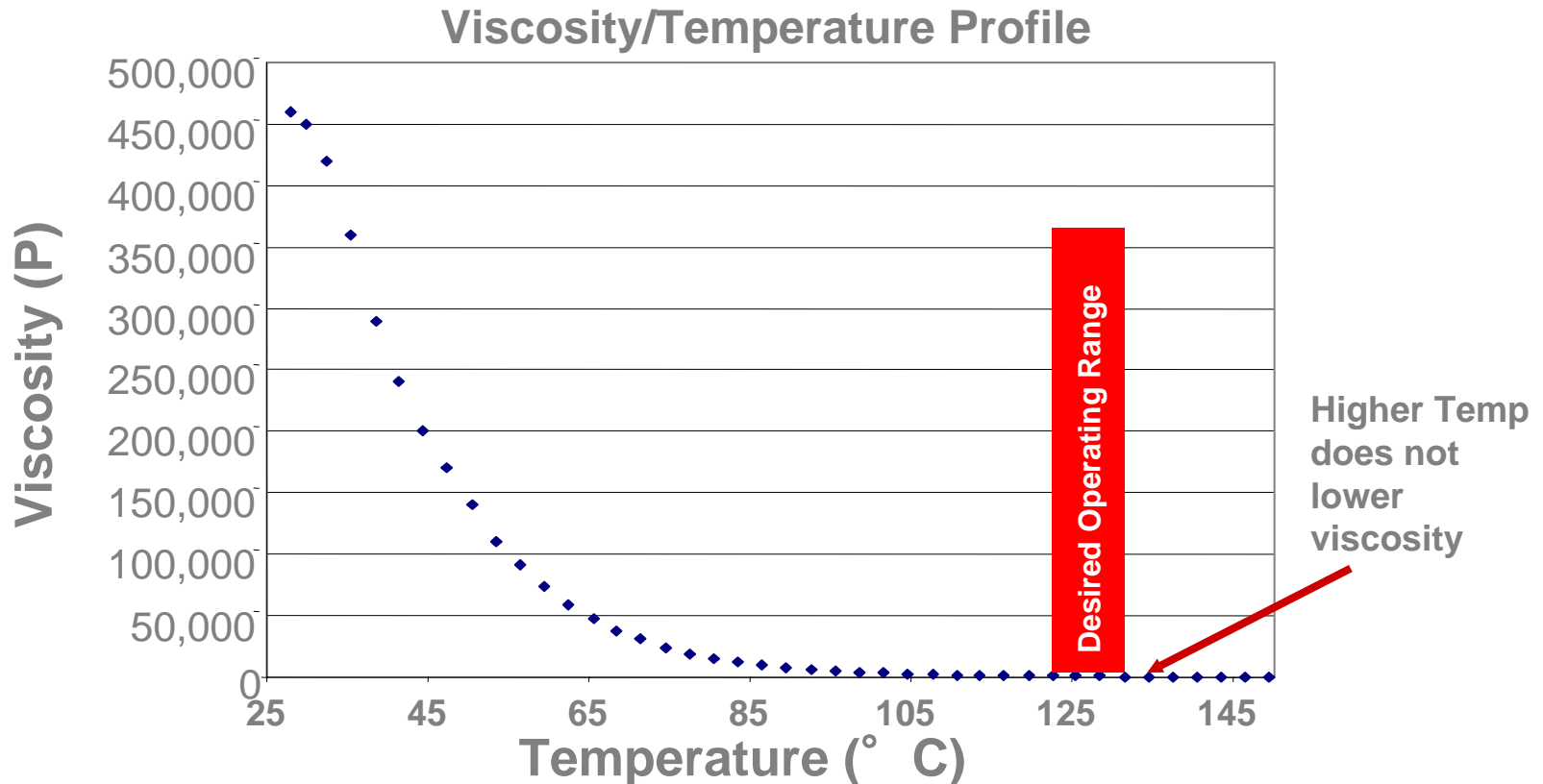
A subset of Hot Melt adhesives where crosslinking of the polymer and/or resin component will yield a end product that is physically stable over a wide temperature range

- Pressure Sensitive Adhesive

A material that adheres to a surface with slight pressure and releases from that surface with negligible transfer of material to the surface

Silicone Reactive Hot Melt

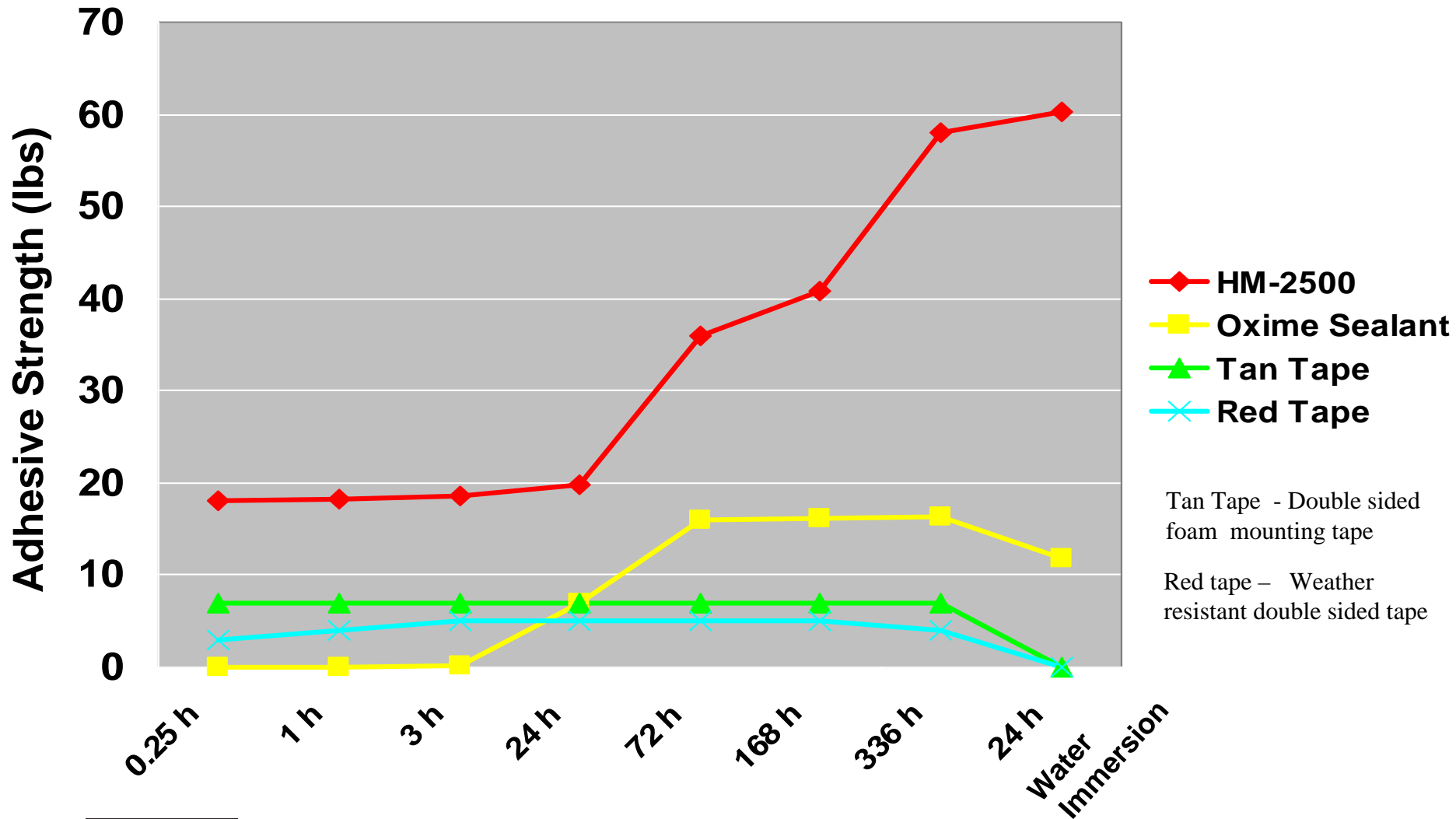
- Dow Corning[®] HM-2500 should be applied at 120° C
 - Max. Application Temperature is 135° C



Silicone Reactive **Hot Melt**

- High Green Strength
 - Results from the Rapid Cooling and Rapid Rise in Viscosity
 - Holds Parts together during Manufacturing Process and Curing Cycle
- PSA Characteristic (Pressure Sensitive Adhesive)
 - Very Tacky when at Application Temperature
 - Dry to the Touch but Remains Tacky like a PSA
 - Will Not Contaminate Process or Substrates

Green Strength Comparison



Tan Tape - Double sided foam mounting tape
Red tape - Weather resistant double sided tape



We help you invent the future™

Physical Properties

Product	Durometer [Shore A]	Tensile [MPa]	Elongation [%]	100% Modulus [MPa]	Movement Capability
HM-2500	60	2.4	1000	0.7	+/- 25%
HM-2510	47	2.7	760	-	
Oxime Sealant	22	1.2	350	0.4	+/- 25%
Foam Tape	n/a	0.7	200	0.3	Not reported
PU Hot Melt	60	7.6	1250	5.2	Not reported

Tried and Tested Application Equipment Solutions

Graco® Therm-O-Flow



Nordson® BM-20 BM-200



DOW CORNING

We help you invent the future™

Tried and Tested Application Equipment Solutions

PAM® 500K by Fastening Technology Inc

300 gram cartridges

120V(or 230V), 80 psi compressed air



Steinel® PUR Glue 50 Gun

50 gram cartridges

120 V(or 230V)



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