

Dow Corning® HM-2500 Assembly Sealant

*Innovative Dow Corning Reactive
Hot-Melt Silicone Sealant Technology*



One Part



Primerless



Instant Green Strength

Immediate hold • Increases productivity • Reduces costs

Dow Corning Innovation

Introducing a reactive hot-melt silicone sealant technology that provides instant green strength to increase productivity, improve quality and reduce costs in industrial assembly applications.

Introducing

Dow Corning® HM-2500 Assembly Sealant is a patented, neutral-cure, reactive hot-melt silicone that is ideal for automated applications in the manufacturing of various components.

HM-2500 is optimized for use with automated dispensing equipment, which creates a uniform seal for part-to-part consistency, minimizes sealant waste and cleanup, and can reduce labor costs substantially.

Typical Performance Properties

Test Method	Property	Unit	Value
CTM ¹ 0719	Viscosity at 248°F (+120°C)	cps	210,000
CTM 0086	Nonvolatile content	percent	98.5
CTM 0243	Open time	minutes	15
CTM 0243	Green strength at 15 min.	PSI	18
CTM 0243	Green strength at 60 min.	PSI	28
	Cure time (1/8") (73°F, 50%RH)	days	2
ASTM ² C 661	Durometer shore-A	points	60
ASTM D412	Tensile strength	PSI	350
ASTM D412	Elongation at break	percent	1000
ASTM C 793	Weathering resistance		Excellent
CTM 0044	Specific gravity, uncured	g/ml	1.061
ASTM C 711	Service temperature range	°F (°C)	-25 to 200 (-32 to 93)
ASTM C711	Low-temperature flexibility	°F (°C)	-25 (-32)
	Application temperature	°F (°C)	250 (+120)
	Pot life	hours	24

¹CTMs: (Corporate Test Method) correspond to standard ASTM tests in most instances. Copies of CTM's are available upon request.

²ASTM: American Society for Testing Materials

More than Silicone

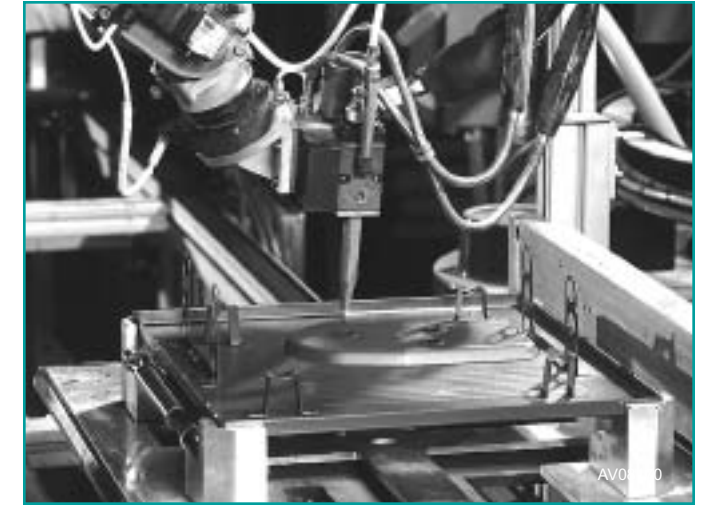
At Dow Corning, our goal is to provide you with innovative solutions that will help you increase production, reduce costs and be competitive in the industrial assembly marketplace. We also develop productivity-enhancing adhesive and sealant material, and equipment solutions, as well as provide the technology and service you need to develop products and applications.

Increase production. Reduce labor costs.

With readily available automated equipment and Dow Corning® HM-2500 Assembly Sealant, you can move parts from one processing step to the next, and ship them as fast as you can make them.

Automated application:

- Creates a perfect seal, reduces part-to-part variability and can increase customer satisfaction
- Minimizes sealant waste and cleanup
- Can reduce labor costs



Dow Corning® HM-2500 Advantages

The Equipment Advantage

We want to ensure that your transition to our hot-melt technology is a successful one. In addition to supplying you with our new, reactive hot-melt silicone, Dow Corning also provides you with proven and tested equipment solutions.

Pre-engineered pump and robotic equipment combinations have been adapted for use with the Dow Corning® HM-2500 reactive hot-melt sealant and are available through our preferred equipment suppliers.

- **Instant green strength for immediate hold**
 - Parts move from one processing step to the next
 - Improves quality, increases productivity, reduces costs
- **No “hold time” requirement**
 - Ship parts as fast as you can make them
 - Increases productivity, reduces space requirements
 - Saves time and money
- **Worker friendly**
 - Non-hazardous formulation
 - Very low odor

■ Long pot life and long open time

- Material stability
- Offers processing flexibility and manufacturing options
- Reduces sealant failure concerns

■ Proven neutral-cure 100% silicone chemistry

- Compatible with most common component materials without the need of a primer
- Cures to a flexible, weather-resistant silicone elastomer with outstanding durability and UV resistance

■ Aggressive adhesion to PVC, aluminum, painted and treated wood, high performance paints, plastics and various substrates

- Long-lasting adhesion
- A seamless seal

■ Crystal clear or select colors for improved aesthetics

Dow Corning® HM-2500 offers the perfect combination of long open time and instant green strength. It gives you 15 minutes to set the part. But once the part is placed, the hold is immediate.

How To Contact Us

For more than 60 years, OEM designers, maintenance and materials engineers around the world have trusted Dow Corning brand for performance and expertise to solve or prevent sealant problems. Dow Corning solutions are available through a distributor network of more than 3000 channel partners around the world. To learn more about our extensive product and service offerings, visit www.dowcorning.com or email industrial@dowcorning.com.

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