

ThreeBond 1211

RTV Silicone

ThreeBond 1211 is a one component silicone based liquid gasket. It vulcanizes at room temperature (RTV) and forms a rubber-like elastic body offering excellent resistance to vibration and shock. It also has an excellent resistance to heat, automotive oils and fluids and effectively seals joints that are subjected to high temperature.

1. Features

- Oxime type
- One component solvent free
- Moisture curing
- Service temperature ; -60 / +200°C (+250)°C
- Good chemical and thermal resistance
- Good adhesion to metals (Alu, steel...)

2. Properties

Before curing

Test	Results	Units
Colour	White	-
Viscosity at 25°C	70	Pa.s
Specific gravity à 25°C	1.01	-
Tack-free time	40	min

After curing

Test	Results	Units
Hardness	26	Shore A
Elongation	300	%
Tensile strength	2.5	MPa
Shear strength (Aluminium)	1.4	MPa

Curing conditions: At 23°C, 50% RH for 168 hours

Electrical characteristics

Tests	Results	Units
Volume resistivity	5×10^{12}	$\Omega \cdot m$
Dielectric breakdown strength	20	MV/m

Curing conditions: At 23°C, 50% RH for 168 hours

Chemical resistance

Product	Results	Units	Remarks
Water	-0.5	%	90°C x 24h
Gasoline	-20.2	%	50°C x 24h
Test lube oil N° 2	+ 5.0	%	100°C x 24h

Pressure resistance

Clearance	Results	Unit
0.10 mm	0.07	MPa
0.20 mm	0.04	
0.50 mm	0.01	

Curing conditions: At 23°C, 50% RH for 30 min

3. Handling

- Before use, please refer to the safety data sheet.
- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.
- Depending on the materials (dimensions and surface roughness), apply an appropriate and uniform amount of liquid gasket on the surface, then assemble rapidly.
- Tack free time and curing speed will vary depending on room temperature and humidity ratio.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Excess product may be removed using TB2890E cleaner.
- Keep the product in its original container, tightly sealed and store it in a dark, dry and well ventilated place at **10 ~ 25°C**.

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