

# ThreeBond 1215

RTV Silicone

ThreeBond **1215** 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 silicone
- Moisture curing
- Service temperature : -60 / +200°C (+250)°C
- Powertrain and flange sealant

## 2. Properties

### Before curing

Test	Results	Units
Colour	Grey	-
Viscosity at 25°C	70	Pa.s
Specific gravity at 25°C	1.55	-
Tack free time	60	min

### After curing

Test	Results	Units
Hardness	45	Shore A
Elongation	320	%
Tensile strength	1.5	MPa
Shear strength	Al / Al	0.8 MPa
	Fe / Fe	0.9 MPa

### Pressure resistance

Test conditions	Results	Units
At 25°C	> 10	MPa
At 80°C	> 10	
At 150°C	> 10	
After 30 Cycles (- 40°C x 2 h   100°C x 2 h)	> 10	

### Chemical resistance

Test conditions	Mass change	Units
Engine oil (100°C x 24h)	+ 2.1	wt. %
Gear oil (100°C x 24h)	+ 4.6	
Gasoline (50°C x 24h)	- 4.7	
Water (95°C x 24h)	- 0.4	
LLC Coolant (95°C x 24h)	- 0.3	
10% Sulfuric acid (25°C x 24h)	- 4.1	
10% Caustic soda (25°C x 24h)	- 4.2	

## 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

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one. Any excess product should be wiped out using a cloth.

- Excess product may be removed using TB2890D 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**.