

BOSS® 326 Hi-Temp Red Silicone Sealant

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Type one part, non-slumping silicone paste
Cure cures at room temperature by reaction
with moisture in the air
Special Properties performs at temperatures
ranging from -85°F to 600°F (-65°C to 316°C) for
continuous operation and to 650°F (343°C)
for intermittent exposure
Primary Uses bonding, sealing, potting,
encapsulating and protective coating operations where
parts must perform at high temperatures

TYPICAL PROPERTIES

As supplied

Color Red
Flow/Slump NIL
Extrusion Rate (1/8" orifice, 90 psi) 335 g/min.

**Cure Characteristics – exposed to air,
77°F (25°C) and 50% RH**

Skin-over time	6 min.
Tack-free time	15 min.
Cure time (1/8" thickness)	24 hrs.

As Cured –after 72 hours at 77°F (25°C) and 50% RH

Durometer, shore A	32 points
Tensile strength	350 psi
Elongation	500%
Unprimed adhesion (most substrates*)	good

*Optimum adhesion is obtained in 7 to 10 days curing time.
Use A-120 prime coat if increased adhesion is required.

*Information on this data sheet is subject to change without notice and should not be used for writing specifications.

For additional information on specific applications, contact Accumetric, LLC

DESCRIPTION

BOSS® 326 Hi-Temp Red Silicone Sealant is a one-part, non-slumping paste that cures to a tough, rubbery solid at room temperature on exposure to water vapor in the air. This silicone product was formulated to perform at temperatures ranging from -85°F to 600°F (-65°C to 316°C) for continuous operation and to 650°F (343°C) for intermittent exposure. It can be used for numerous sealing and bonding applications.



USES

- Sealing and encapsulating heating elements in appliances
- Aerospace gasketing
- Moving oven belts
- Industrial ovens
- Bag filters on smoke stacks
- Other critical bonding, sealing, potting, encapsulating and protective coating where parts must perform at high temperatures

HOW TO USE

Applying the Material: Tack-Free Time

BOSS® 326 Hi-Temp Red Silicone Sealant is supplied ready-to-use. Under pressure it flows readily from its container. The paste-like consistency makes it easy to work; a spatula or wooden paddle can be used for tooling the surface.

The cure progresses inward from the surface. At conditions of at least 77°F (25°C) and 50% relative humidity, the sealant forms a tack-free skin within 15 minutes. Tooling is not practical after this

skin begins forming and should be completed within 5 to 10 minutes of application, even though this may require alternate periods of applying and tooling. Likewise, if masking tape has been used to mark off the area, it should be removed before the tack-free skin forms.

Cure Time

Cure time is affected by relative humidity, degree of confinement and cross-sectional thickness of the sealant. Sections up to 1/8" thick become rubbery solids in about 24 hours at 77°F (25°C) and 50 percent relative humidity. Less moisture content reduces it slightly. In 24 hours, sections up to 1/8" thick cure to a rubber when a Shore A durometer hardness levels off to about 32 points.

In applications where **BOSS® 326** may be partly or totally confined during cure, the time required for proper cure is generally lengthened by the degree of confinement. It is possible, with absolute confinement, that cure will not be completed. The result is the softening of the sealant at elevated temperatures. Metal-to-metal bonds should not overlap more than one inch. Every application involving confinement during cure should be thoroughly tested before commercialization.

Curing time increases with the thickness of the sealant. A 1/2" cross-section, for example, may require 3 or 4 days for complete solidification. However, the cure will have penetrated the outer 1/8" in about 24 hours.

Adhered to glass, metal or most woods, **BOSS® 326** Hi-Temp Red Silicone Sealant has a typical peel strength of 20 pounds per inch after 72 hours at room temperature.

The odor given off during cure is due to the liberation of acetic acid. This odor disappears as the cure progresses, and is not detectable after the cure is complete.

Bonding

1. Thoroughly clean and degrease metal and plastic surfaces, then rinse all surfaces, except plastic, with acetone. Rubber surfaces should be roughened with sandpaper, then wiped with acetone. Follow the precautions given on solvent container label.
2. For stronger, more uniform bonds, apply a thin film of A-120 prime coat to all surfaces except rubber and silicone rubber. Allow to air-dry for 30 to 45 minutes at room temperature. (Full instructions are provided with the prime coat.)

CAUTION: A-120 prime coat is flammable and has no **BOSS®** FDA status. Keep away from heat and open flames. Use only with adequate ventilation.

3. Apply **BOSS® 326** to the prepared surface in a uniform thickness. Best adhesion is obtained with a 15 to 30 mil glue line. In those cases where the adhesive is used between surfaces, put the second surface in place, using enough pressure to displace the air but not the adhesive.
4. Let the unit stand undisturbed at room temperature to cure.

SPECIFICATIONS

BOSS® 326 meets performance requirements for the following: FDA/USDA requirements for use in establishments operating under Federal Meat and Poultry Inspection Program. When cured and washed, ingredients remaining or which could migrate to food are on FDA Regulation No. 21 CFR 177.2600. Meets Federal Specifications TT-S-001543A, TT-S-00230C, ASTM C920-86, NSF standard 51 and is UL Recognized.

CAUTION

DIRECT CONTACT OF UNCURED SEALANT IRRITATES EYES AND MAY IRRITATE SKIN. OVEREXPOSURE TO VAPOR MAY IRRITATE EYES, NOSE, AND THROAT. Avoid eye and skin contact. Use with adequate ventilation. Do not handle contact lenses with sealant on hands. IN CASE OF EYE CONTACT, flush eyes with water for 15 minutes. Obtain medical attention. IN CASE OF SKIN CONTACT, remove from skin and flush with water. Sealant releases acetic acid (vinegar-like odor) during cure. KEEP OUT OF THE REACH OF CHILDREN.

PACKAGING

BOSS® 326 Hi-Temp Red Silicone Sealant is available in 3 oz. and 12 oz. aluminum tubes, 10.3 oz. cartridges and 5 gallon pails. Other sizes available upon request.

SHIPPING LIMITATIONS

None.

STORAGE AND SHELF LIFE

When stored in original unopened container at or below 90°F (32°C), **BOSS® 326** Silicone Sealant has a shelf life of 12 months from date of shipment. Containers should always be kept sealed when not in use. After a container has been opened and the entire contents have not been used, extrude 3/8" of material past nozzle opening. When ready to use pull out cured plug. Sealant is ready to use.

USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

The supplier warrants only that its products will meet its specifications. There is no warranty of merchantability or fitness for use, nor any other express or implied warranty. The user's exclusive remedy and the supplier's sole liability is limited to refund of the purchase price or replacement of any product shown to be otherwise than as warranted. The supplier will not be liable for incidental or consequential damages of any kind.

Suggestions of uses should not be taken as inducements to infringe any patents.

MADE IN U.S.A.

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