



GE Silicones

Silgrip® PSA529

Silicone Pressure Sensitive Adhesive

Product Description

PSA529 silicone pressure sensitive adhesive is a toluene solution of polysiloxane gum and resin. It is supplied at 55 percent silicone solids and may be further diluted with aromatic, aliphatic or chlorinated solvents. PSA529 may be blended with SR545 resin dispersion or with other methyl based silicone pressure sensitive adhesives to obtain specific performance properties.

PSA529 has an overall balance of peel strength, cohesion, lap shear strength and high temperature holding power, which provides a versatility that makes this product useful in a wide variety of applications, including fastening and bonding of dissimilar materials.

Key Performance Properties

- Wide temperature range performance, maintains good shear and tack properties at intermittent temperatures up to 500°F
- Adhesion to a wide variety of surfaces (stainless steel, anodized aluminum, steel) including low energy surfaces (silicones, fluoropolymers, polyolefines)
- Resistance to moisture, weathering (ozone, sunlight), chemical (acids, alkalis, oils) and biological (fungus) attack
- Elastomeric properties after curing with SRC18 catalyst
- Creep resistance

Typical Product Data

Property	Value
Silicone Solids, %	55
Specific Gravity	0.99
Density, lbs/gal	8.2
Viscosity @ 25 °C (77 °F), cps (Brookfield RVF, #3 Spindle, 20rpm)	2,500
Color	Light Straw, Translucent
Flash Point, TCC, °C(°F)	1.6 (35)
Solvent	Toluene

TYPICAL CURED ADHESIVE PROPERTIES

• Peel Adhesion ⁽¹⁾ , grams/inch	2350
• Tack ⁽²⁾ , g/cm ²	440

(1) 2 mil dry adhesive thickness, 2 mil polyester film, uncatalyzed, curing cycle: 10 minutes air dry, 10 minutes at 150°C, stainless steel, 12 inches/minute, 180° angle

(2) Polyken Tack Tester, 1000g weight, 1second dwell time, cm/second draw speed, 2 mil dry adhesive thickness, 2 mil polyester film, uncatalyzed, curing cycle: 10 minutes air dry, 10 minutes at 150°C

Specifications

Typical product data values should not be used as specifications. Assistance and specifications are available by contacting GE Silicones at 800/255-8886.

Instructions for Use

Laminating Applications

PSA529 silicone adhesive is supplied at a viscosity suitable for conventional coating equipment. If necessary, it may be thinned with toluene, xylene or other compatible solvents. After the adhesive is applied to the substrate, it is exposed to a two step process: solvent removal and curing.

Processing of PSA529 Catalyzed with Benzoyl Peroxide Solvent Removal

To achieve optimum adhesive properties, it is essential to optimize the drying step of the process in order to assure that the solvent is removed from the adhesive film before the curing step of the process starts. Improper drying will result in residual solvent entrapment within the adhesive. If the adhesive is then exposed to temperatures higher than 93.5°C (200°F), decomposing peroxide catalyst can cause crosslinking reaction between solvent and adhesive through methyl groups on siloxane chains and on solvent molecules and adversely affect the properties of the adhesive. Typical temperature range for the drying step of the process is 83°C (180°F) to 90°C (194°F). A typical drying cycle is 2 minutes at 90°C (194°F).

Curing Process

Once the solvent is removed from the adhesive film, the peroxide cure should be initiated by exposure to heat. A typical curing cycle is 2 minutes at 165°C (329°F). Longer exposure time and higher temperature, up to 204°C (400°F), can be used without adverse effects. The exact conditions required to achieve a complete cure will depend on oven length and efficiency, peroxide type and type of substrate used, and should be established during experimental trials on the machine.

Catalysts

High purity, 98% benzoyl peroxide⁽³⁾ in the quantity of 1 to 3% based on silicone solids, has been found to give the most consistent results in curing of silicone pressure sensitive adhesives. In applications requiring low temperature cure, 2,4-dichlorobenzoyl peroxide, which is activated at 132°C (270°F), can be used. It should be noted that 2,4-dichlorobenzoyl peroxide may generate polychlorinated biphenyls during the curing process. Please refer to Code of Federal Regulations, title 40, part 761 regarding incidental PCB byproducts if 2,4-dichlorobenzoyl peroxide is utilized.

The peroxide should be dispersed in solvent before it is mixed with the adhesive. Thorough mixing of the peroxide and adhesive to achieve homogeneous dispersion is essential for consistency of finished product.

(3) Available from: Elf Atochem North America, Inc.

Processing of PSA529 Catalyzed with SRC18

Room temperature curing can be obtained by catalyzing PSA529 adhesive with SRC18 amino functional silane.

Note: It is necessary (for maximum physicals) to add an amount of SRC18 catalyst that will eventually cause complete cure of PSA529 adhesive. Completely cured PSA529 adhesive is tack free and is not useful for pressure sensitive adhesive applications. When using SRC18 catalyst with PSA529 adhesive for laminating (bonding) dissimilar materials, follow SRC18 catalyst data sheet (document #CDS5187) precautions carefully.

Bonding Applications

Catalyzed adhesive may be applied with a brush, roller or any suitable coating device. Thinning, if required, may be done with toluene or paint thinner. Both surfaces to be bonded should be thoroughly cleaned with alcohol, the adhesive should be applied to them and allowed to dry either in room temperature or in an elevated temperature. The length of drying time will depend on solvent used, adhesive thickness and temperature it is exposed to. The recommended adhesive thickness is 3 to 4 mils dry. After the solvent is completely evaporated from the adhesive, the surfaces to be bonded should be firmly pressed together and the adhesive should be allowed to cure.

Cure is a function of time and temperature. Room temperature cure at 21 °C (70 °F) will require 3-7 days for the catalyzed adhesive to develop maximum strength. The cure time can be shortened by elevating temperature to a maximum 165 °C (329 °F). A typical shortened cure cycle is 24 hours at 25 °C (77 °F) followed by 24 hours at 100 °C (212 °F). Note: Use adhesive in a well- ventilated area.

Blending Instructions

Typical Formulation	
PSA529	100.0 parts by weight
SRC18	3.3 parts by weight

SRC18 catalyst should be added to the adhesive and stirred well before using (consult Material Safety Data Sheets prior to use).

Store catalyzed adhesive in tightly closed containers and use within 48 hours. Where longer pot life is required, dilute the adhesive mixture to approximately 30% silicone content with toluene or paint thinner. Diluted mixtures are useful up to three months.

Handling and Safety

Material Safety Data Sheets are available upon request from GE Silicones. Similar information for solvents and other chemicals used with GE products should be obtained from your suppliers. When solvents are used, proper safety precautions must be observed.

Storage and Warranty Period

The warranty period is 6 months from date of shipment from GE Silicones if stored in the original unopened container at 25 °C (77 °F).

Availability

PSA529 silicone pressure sensitive adhesive may be ordered from GE Silicones, Waterford, NY 12188, GE Silicones sales office nearest you or an authorized GE Silicones product distributor.

Government Requirement

Prior to considering use of a GE Silicones product in fulfilling any government requirement, contact GE Silicones Customer Service department to determine if all government requirements can be met. CDS4944

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