

# Technical Specifications

## "Double-Bubble®" brown #04030 HARDMAN® Silicone

**Double-Bubble® brown** is a one-part silicone sealant that cures in the presence of atmospheric moisture to a durable, flexible rubber, which has excellent adhesion to most non-porous surfaces.

It is recommended for following substrates: aluminum, carbon steel, ABS, acetate, acrylic, epoxy, fiberglass, nylon, phenolic, polycarbonate, polyester, polystyrene, polyurethane, PVC, ceramics, china, glass, stone and wood.

It has a work life of 5 to 10 minutes. The moisture content of the air at the time of application and during cure has a direct influence on the work life and speed of cure of the sealant.

It can be applied at outdoor temperatures of  $-37\text{ }^{\circ}\text{C}$  provided that the surfaces are clean and frost free. After cure it remains rubbery down to  $-62\text{ }^{\circ}\text{C}$  and will retain its properties after extended exposure up to  $204\text{ }^{\circ}\text{C}$ .

### How to use

Surface must be clean and dry before application. Remove all chemicals, dirt, wax and oil. Simply fold the **Double-Bubble® brown** package along the center seal, snip the end, squeeze out all the contents, mix thoroughly and apply.



### Typical Uncured Properties

Color	Translucent White
Viscosity at $25\text{ }^{\circ}\text{C}$ , cps	Thixotropic Paste
Weight per Gallon, lbs.	8.68
Specific Gravity at $25\text{ }^{\circ}\text{C}$	1.04
VOC Content, lb./gal.	0.4
Work time, minutes	8
Tack-free time, minutes	20
Full cure, hours	24
Shelf Life / months	12

### Typical Cured Physical Properties (Tested at $25\text{ }^{\circ}\text{C}$ unless otherwise indicated)

Test	Results
Hardness, Shore A	25
Tensile Strength, psi	250
Elongation, %	>400
Service Temperature, $^{\circ}\text{C}$	-62 to 204

### Storage and Handling

Store **Double-Bubble®** adhesives at room temperature in a dry environment. Extreme low temperatures may cause crystallization. Extreme high temperatures may degrade the properties.

### Precautions

Although the system contains low volatility materials, nevertheless, care should be taken in handling. Adequate ventilation of work place and ovens is essential. These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately. For industrial use only.

### Packaging Size

100 pcs / carton, 5 g each

### IMPORTANT NOTICE TO PURCHASER

ROYAL ADHESIVES believes this data to be reliable in all respects, however, makes no expressed or implied warranty of merchantability, of fitness for a particular purpose, or of result. User must, at its own risk and expense, and under user's conditions and methods, test suitability of the product for the intended application. ROYAL ADHESIVES shall not be liable for any direct, incidental or consequential damages arising out of the improper use of or the inability to use the product.



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