



D AIRCRAFT PRODUCTS, INC.

DAPCO™ 3302 SILICONE ADHESIVE

GENERAL DESCRIPTION

DAPCO™ 3302 is a high solids silicone rubber contact adhesive. The product cures at room temperature (70°F) and features:

- ♦ Service temperature range from -65°F to 200°F
- ♦ Bonds silicone rubber to a variety of substrates
- ♦ Weatherability
- ♦ Qualified to aircraft manufacturer specifications
- ♦ No outgassing during cure

APPLICATIONS

DAPCO™ 3302 demonstrates good adhesion when bonding silicone rubber sheet stock, extrusions, and RTV compounds to themselves as well as metal, glass and plastic substrates. DAPCO™ 3302 can be applied using a variety of methods develops a flexible bond when properly cured and has a convenient working life.

TYPICAL PROPERTIES

	PART A	PART B	MIXED
Color	Clear	Clear	Clear
Solids, %	48	3	45
Appearance	Liquid	Liquid	Liquid
Viscosity (cps @72°F)	1500	7	<1350
Density, lbm/gal	8.2	6.5	8.0

PROCESSING

Mix Ratio: The recommended mix ratio for

DAPCO™ 3302 is:

	Weight	Volume
Part A	10	100
Part B	1	12.6

When mixing, it is recommended that a clean glass or metal container be used. Weight or measure Part A and then carefully add Part B (excessive amounts of curing agent will reduce working life).

The presence of contaminants such as grease, oil, urethanes, epoxies, etc., will inhibit cure and may contribute to a

tacky surface. Mix the two components until they are thoroughly blended.

Working Life: After mixing, the adhesive is useable for periods up to three hours at room temperature (70°F). Solvent evaporation will reduce working life and increase viscosities significantly. Maximum working life is insured by covering the container when not being used. Material which has partially gelled should be discarded and a fresh mixture prepared.

Curing: Apply a thin, continuous film of DAPCO™ 3302 to both substrates. Allow solvent to evaporate for 30 minutes at 70°F. Assemble substrates and apply moderate pressure to achieve intimate contact. To develop optimum adhesion, a seven day cure at room temperature (70°F) is recommended. Cure can be accelerated by an overnight gel period followed by exposure for 4 to 6 hours at 160°F.

SURFACE PREPARATION

The substrates must be free from contaminates, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly. DAPCO™ 1-100 Primer should be used to improve adhesion in most cases.

DAPCO™ 1-100 should not be applied to the silicone rubber surface. Allow 45 minutes for the primer to cure. The adhesive must be applied within 90 minutes after primer has cured. When circumstances prevent immediate application of DAPCO™ 3302, the surface must be thoroughly cleaned to remove the primer before repeating the entire process.

TYPICAL CURED PROPERTIES

When cured in accordance with the recommended schedule, the following typical properties are developed:

Adhesion strength, pli,	
Bonding silicone rubber to:	
Silicone Rubber:	12
Aluminum:	14*
Phenolic Substrates:	10*

*When used with DAPCO™ 1-100 Primer



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STORAGE AND HANDLING

Store in a cool, dry place at temperature below 80°F. Keep containers tightly sealed and take precautions to avoid solvent evaporation. When properly stored, the material is stable for a period of 6 months from the date of shipment.

SAFETY

DAPCO™ 3302 contains flammable solvents. Keep away from excessive heat or any other source of ignition. Exercise good housekeeping practices. Material Safety Data Sheets available upon request.

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