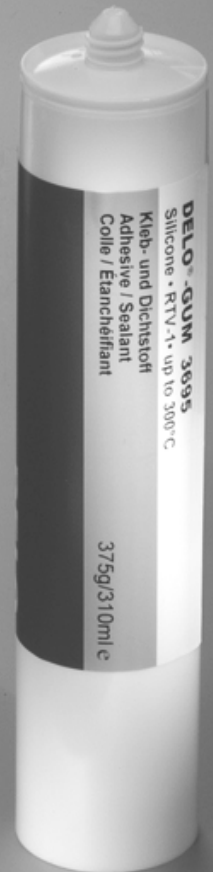


## DELO<sup>®</sup>-GUM

1-component silicone adhesives and sealants  
2-component casting compounds



**Instructions for use &  
General information  
on the product group**

## Application areas

DELO<sup>®</sup>-GUM 1C silicones are one-component adhesives and sealants based on polysiloxane connections. They are used as permanently elastic adhesives and as sealants, casting compounds and fixing compounds in electrical engineering, electronics, tool construction, mechanical engineering, precision engineering and the glass industry.

DELO<sup>®</sup>-GUM 2C silicone is a two-component silicone rubber which can be used as casting compound for model making and mold construction.

## Surface pretreatment

The contact surfaces must be free of oil, grease and other contaminations in order to achieve optimal bond strength. We provide our cleaners DELOTHEN. Isopropyl alcohol has proven to be efficient for cleaning glass. You can draw more detailed information from the technical information "DELOTHEN Cleaners".

After cleaning, adhesion to the component can be further improved by means of surface pretreatment. You can draw additional details from the written information on surface pretreatment.

The suitability and strength of the adhesive are to be verified on original components under application-specific conditions.

If the components to be bonded are made of rigid base materials and if the components are subject to strong humidity in use, priming with DELO<sup>®</sup>-PRE 3003, a special primer for silicones, is recommendable.

## Processing

The products are supplied ready for use. Depending on the type of delivery, they can be processed manually directly from the container (Euro cartridge dispensing gun) or by means of DELO<sup>®</sup> dispensing units.

DELO<sup>®</sup>-GUM 2C silicone is supplied in double chamber cartridges.

### **Euro cartridges:**

1. Cut the Euro cartridge tip.
2. Screw on the dispensing tip.
3. Insert Euro cartridge into the dispensing gun.

### **DELOMAT<sup>®</sup> with Euro cartridge holder:**

1. Insert the cartridge into the cartridge pipe.
2. Screw the swivel nut of the pressure tank cover tightly onto the cartridge pipe.
3. If necessary, put the cartridge pipe with the cartridge through the retaining bent.
4. Cut the cartridge tip at its upper end.
5. Carefully screw the cartridge into the thread of the valve or attach the adapter for the flexible discharge site. Caution!! Make sure that the o-ring is inserted correctly!

Remember that 1-component silicones form skin after approx. 5 minutes (at 50 % relative humidity) at the ambient air, which might influence wetting of the second component negatively. Therefore, application and joining must be completed within this period of time in order to avoid an impairment of the composite quality. When applying silicone to larger areas, a scraper or a notched trowel should be used so that the surface wetting is as ideal as possible.

### **DELO<sup>®</sup>-GUM: in double chamber cartridges**

The adhesive is applied by means of dispensing guns which are operated manually or pneumatically .

1. Insert the double chamber cartridge into the dispensing gun.
2. Remove the closing cap from the cartridge top by turning
3. Attach the mixing tube and lock it.
4. Operate the trigger lever.
5. Apply the homogeneously mixed adhesive to the component.
6. When using new double cartridges or a new mixing tube with a cartridge in use, abandon at least the first content of the mixing tube in order to avoid mixing errors. The cartridges are overfilled so that there are no losses. When using the double chamber cartridge system please refer to the processing details and the instructions for use.
7. When using the original closure cap for closing cartridges which have not been emptied completely, this can result in partially cured adhesive at the outlets of the cartridge. Therefore, use the filled mixing tube as closure.
8. Remove possibly cured adhesive from the outlet before initial use or when using cartridges which have already been opened.

If the processing pauses are shorter than the pot life of the 0.1 oz (3 g) preparation of the respective product, the same mixing tube can be further used.

In case of work finish or longer interruptions, the mixing tube can remain on the cartridge as closure.

Before further processing, the old mixing tube is removed, the outlet at the cartridge is ridded of possibly cured adhesive and a new mixing tube is attached.

### **Curing**

One-component silicones cure under the influence of humidity. Curing starts at the surface of the silicone.

Complete curing of the depths of the silicone rubber proceeds at a speed of approx. 0.08 in (2 mm)/24 h with 50 % rel. humidity. Larger layer thicknesses and area bondings require longer curing times as the diffusion speed of the humidity into the product decreases with the increasing, cured layer. Increased air humidity concentrations accelerate the reaction, lower concentrations decelerate curing. During curing of 1-component silicones, low-molecular decomposition products are formed which are dependent on the product. Reactions of the decomposition products (oximes, amines or acetic acid) impairing the function of the components must be clarified in advance or determined in tests.

DELO<sup>®</sup>-GUM 2C silicone cures without the influence of air humidity within a few minutes.

You can draw the detailed, product-specific information on the processing of each product from the respective technical data sheet.

### **Instructions and advice for occupational health and safety**

see material safety data sheet

## **Storage**

In unopened original container.

Cool and dry storage is recommendable.

Storage life: see technical data sheet

## **General**

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this.

It is the user's responsibility to test the suitability of the product for the intended purpose by considering all specific requirements. Type and physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions.

The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for a specific purpose.

## **If you have any further questions**

Please contact us.

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