

CAF[®] 520

Industrial and professional range

Description	<p>CAF 520 is a one component silicone elastomer curing at Room Temperature:</p> <ul style="list-style-type: none"> • Neutral • Self-adhesive • Thixotrope • Translucent
Examples of applications	<p>CAF 520 is a fast-curing, ready-to-use silicone elastomer suitable for sealing and bonding. It cross-links at room temperature to give a flexible seal.</p> <p>CAF 520 is used for following applications:</p> <ul style="list-style-type: none"> • Sealing and bonding of plastic materials. • Bonding of headlight. • Industrial maintenance. • Domestic appliances. • Electronics. • Solar panels.
Advantages	<p>CAF 520 combines the advantages of:</p> <ul style="list-style-type: none"> • Primer-less adhesion. • Odourless, it is particularly well accepted in the workstation environment. • High cure rate. • Its mechanical properties and good adhesion to many surfaces allow perfect assembly and full sealing between materials of different types as glass, metals, ceramics and plastics.

Characteristics**1. Characteristics of the non cured product**

<i>Properties</i>	CAF 520
Appearance	Non flowing paste
Odour	Alcoxy
Colour	Trans.
Flowability <i>(norms BOEING S7502, NM459)</i>	<3
Specific gravity <i>(g/cm, at 25 °C, approx)</i>	1.02
Extrusion g/min <i>(3mm, 3 bars, norm 495A, average)</i>	50

Characteristics (cont')

2. curing

Properties	CAF 520
Skin Formation (at 23 °C, 50% HR, min.)	5-8
Tack-free Time (at 23 °C, 50% HR, min, approx.)	25
Curing Rate (at 23 °C, 50% HR, approx.) - 2 mm / hour - 24 h /mm	7 4

3. Characteristics of the cured product on 2 mm thick film

Properties	CAF 520
Shore A Hardness (ISO 868, approx.)	15
Modulus at Elongation (MPa, approx.)	0.3
Tensile Strength (MPa, approx.)	1.1
Elongation at break (%, approx.)	550

4. Thermal properties

Properties	Service Temperatures
Lower usage temperature limit (brittle point, °C, approx)	- 60 °C
Upper usage temperature limit (Maximum Temperature, °C, approx)	150 °C

Note: Determined by measuring the mechanical properties and Shore A Hardness before and after treatment. These values aren't absolute limits, but the range within which variations in mechanical properties are not reduced by more than 50%.

Characteristics (cont')**5. Adhesion properties***1 mm thick, 7 days curing at 23°C, 50% HR, norm NM748*

Substrates	Tensile strength
Glass (MPa, approx.)	0.7
Alu AG3 (MPa, approx.)	0.7
Stainless Steel (MPa, approx.)	0.7
Epoxy-PES paint, on stainless steel (MPa, approx.)	0.6
Polycarbonate (MPa, approx.)	0.4
Type of failure	100% Cohesive

Note: **CAF 520** gives primerless adhesion on numerous other substrates such as:

Coated glass, anodised and heat lacquered aluminium, PVC, PMMA.

Processing

CAF 520 is ready to use.

Processing is particularly easy, since the products are delivered ready to use. Application can be carried out either manually or using robotic application equipment.

CAF 520 is applied to one of the two joint surfaces and assembled before the product has formed a skin.

It is recommended to apply **CAF 520** onto clean & dry surfaces.

Packaging

CAF 520 is available in 250 kg (on pallets of 4 units) and 25 kg drums (on pallets of 10 units).

Storage and shelf life

When stored in its original unopened packaging, at a temperature of between +2°C and +30°C, **CAF 520** may be stored for up to 12 months from the date of manufacture clearly marked on the packaging.

Beyond this date, Bluestar Silicones no longer guarantees that the product meets the sales specifications.

Safety

Please consult the Safety Data Sheet of **CAF 520**.

Visit our website www.bluestarsilicones.com

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