

### TYPICAL PROPERTIES

#### Uncured

Specific Gravity:	1.04
Color:	Black
Slump:	NIL
Tack Free Time (77°F & 50% RH), min	20
Cure Time at 77 F (25 c and 50% RH (3.18 Mm thk.), hrs.	24

#### Cured – (7 days at 77°F + 3°F and 50% and + 5% TH)

Elongation, percent (ASTM D412)	550
Durometer, Shore A, points (ASTM 2240)	25
Tensile Strength, Mpa (psi), (ASTM D412)	4 (350)
Brittle point, F (C) , ASTM D746)	-62 (-82)
Peel Strength, ppi	21.6
Extrusion Rate 3.18mm orifice, 90 psi air pressure)g/min	350
Temperature Range:	
Continuous operating temp, max	450 F (232 C)
Intermittent operating temp, max	500 F (250 C)

\* Information on this data sheet is subject to change without notice and should not be used for spec. writing. For additional information on specific applications, contact the factory.

### DESCRIPTION

Deacon 327 Industrial Grade Silicone Sealant is a one part acetoxy cure adhesive that is suitable for general industrial sealing and adhesive applications. This product will adhere to clean metal, glass, many types of wood, silicone resins, vulcanized silicone rubber, ceramics and plastic surfaces. A primer may be required for optimum adhesion to some substances.

Deacon 327 Industrial Grade Silicone Sealant has good resistance to weathering, vibration, moisture, ozone, and extreme temperatures. It may be applied in subzero weather without loss of extrusion or physical property characteristics. Fully cured Deacon 327 Industrial Grade Silicone Sealant can be used for extended periods at temperatures up to 450°F (232°C), and for shorter periods, as high as 500°F (260°C). Test have shown that even after two months at 450°F (232°C), or up to one week at 500°F (260°C), the sealant remained rubbery.

### USES

- Seal heating, ventilating, or air conditioning duct work.
- Seal cracks or gaps around windows, vents, ducts, fixtures, lights.
- Seal leaks in gutters, downspouts, ducts, piping.
- Seal cracks in interior walls and ceilings, door joints, fixtures.
- Seal out water from compartments in machinery, appliances.
- Seal around freezer doors and windows to prevent frost and condensation from forming.
- Seal electrical connections and boxes to waterproof.
- Seal joints and cracks in the roofs and sides of truck trailers.
- Seal stainless steel food service equipment.
- Seal electrical controls, instruments, motors, fans, and machinery to keep out dust, dirt, and moisture.
- Make quick sheet metal patches.
- Seal wall-floor and wall-ceiling seams.
- Sealing windows in oven doors and flues on gas appliances, flanged pipe joints, access doors.
- Adhering auto and appliance trim, including metal, fabric, and fabric-backed plastics.
- Sealing trailers, truck caps.
- Filletting and caulking joints in sheet-metal stacks, ductwork, and equipment housings.
- Bonding gaskets in heating and refrigeration units.
- Sealing of marine cabins and windows.
- Anti-abrasion coating.
- Bonding signs and sign letters.
- Attaching screwless brackets or nameplates, and tacking plastic materials to metal.
- Formed-in-place gasket for gear boxes, compressors, pumps.

### HOW TO USE

#### Applying the Material: Tack-Free Time

Deacon 327 Industrial Grade Silicone Sealant is supplied ready-to-use. Under pressure, it flows readily from its container. The paste-like consistency makes it easy to work; a spatula or wooden paddle can be used for tooling the surface.

The cure progresses inward from the surface. At conditions of at least 75°F (24°C) and 50 percent relative humidity, the sealant forms a tack-free skin within 20 minutes. Tooling is not practical after this skin begins forming, and should be completed within 5 to 10 minutes of application, even though this may require alternate periods of applying and tooling. Likewise, if masking tape has been used to mark off the area, it should be removed before the tack-free skin forms.

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CONSULT MSDS & TECH SHEET FOR ALL SAFETY, TECHNICAL, & WARRANTY INFORMATION BEFORE USE.  
NOT RECOMMENDED FOR USE ON NUCLEAR APPLICATIONS

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# Deacon 327-RTV

# Industrial Grade Silicone Sealant

## Curing

Cure time is affected by relative humidity, degree of confinement, and cross-sectional thickness of the sealant. Sections up to 1/8 inch thick become rubbery solids in about 24 hours at room temperatures of 20 percent relative humidity. Less moisture content reduces it slightly.

In applications where Deacon 327 Industrial Grade Silicone Sealant may be partly or totally confined during cure, the time required for proper cure is generally lengthened by the degree of confinement. Metal-to-metal bonds should not overlap more than one inch. Every applications, involving confinement during cure should be thoroughly tested before commercialization.

The odor given off during cure is due to the liberation of acetic acid. This odor disappears as the cure progresses, and is not detectable after the cure is complete

## Bonding

1. Thoroughly clean and degrease metal and plastic surfaces, then rinse all surfaces, except plastic, with acetone. Rubber surfaces should be roughened with sandpaper, then wiped with acetone. Follow the precautions given on solvent container label.

2. For stronger, more uniform bonds, apply a thin film of A-120 prime coat to all surfaces except rubber and silicone rubber. Allow to air dry for 30 to 45 minutes at room temperature. (Full instructions are provided with the prime coat)

**CAUTION:** A-120 prime coat is flammable and has no FDA status. Keep away from heat and open flames. Use only with adequate ventilation.

## Sealing

Using Deacon 327 Industrial Grade Silicone Sealant in sealing applications follows approximately the same step-by-step procedures as outlined for bonding applications. After preparing the surface and priming where required, the sealant is applied by forcing it in the joint or seam to obtain full contact between sealant and surfaces.

## SPECIFICATIONS

Meets or exceeds the following specifications : USDA for use in federally inspected Meat and poultry plants. FDA Regulation No.21 CFR 177.2600, TT-S-00230C (COM-NBS) Class A, and TT-S-001543A (COM-NBS) Class A, Canadian 19-GP-9MA Type 1 and MIL-A-46106.

## WARNING

DIRECT CONTACT OF UNCURED SEALANT IRRITATES EYES AND MAY IRRITATE SKIN. OVEREXPOSURE TO VAPOR MAY IRRITATE EYES, NOSE AND THROAT. Avoid eye and skin contact. Use adequate ventilation. Do not handle contact lenses with sealant on hands. IN CASE OF EYE CONTACT, flush eyes with water for 15 min. Obtain medical attention. IN CASE OF SKIN CONTACT, remove from skin and flush with water. Sealant releases acetic acid (vinegar-like odor) during cure.

**KEEP OUT OF REACH OF CHILDREN**

## SHIPPING LIMITATIONS

None.

## STORAGE AND SHELF LIFE

When stored in original unopened container at or below 90°F (32°C), Deacon 327 Industrial Grade Silicone Sealant has a shelf life of 2 years from the date of shipment. Containers should always be kept sealed when not in use.

## PACKAGING

Deacon 327 Industrial Grade Silicone Sealant is available in 4.5 gallon pails, 1 gallon pails, and 10.3 fl. Oz. cartridges.

## USER'S PLEASE READ

The information and data contained herein are believed to be accurate and reliable; however, it is the user's responsibility to determine suitability to use. Since the supplier cannot know all of the uses, or the conditions of use to which these products may be put, no warranties concerning the fitness or suitability for a particular use or purpose are made.

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