

Speedline 73-20 RTV Silicone Sealant is a high quality, single-component, 100% silicone sealant that is perfect for interior and exterior sealing and caulking. It adheres to metal, glass, marble, tile, ceramic, porcelain, painted surfaces, non-oily woods, rubber and many plastics. It can be used as an adhesive for bonding surfaces together. It is safe for use around livestock and in applications involving the preparation of food.

Surface Preparation

In preparation for bonding 73-20 RTV Adhesive/Sealant, thoroughly clean all surface areas, removing any grease and loose particles. Additionally cleanse the surface areas with a wipe of acetone. For rubber surfaces, roughen the rubber surface and then wipe with acetone. All surfaces should be dry at the time of application.

Application

Prepare the 73-20 Tube by cutting off the nozzle at an angle providing a desired bead size. Additionally pierce the seal inside the throat of the tube tip.

Push the sealant ahead of the nozzle to maintain a uniform bead. The thickness should be limited to ¼" (6mm) or less. If using an air powered caulking gun, do not exceed 45 psig.

Limit your application to an area that you can complete and yet allow any required tooling or edge detailing. Under normal room temperature, the material will become tack free within twenty minutes, so all tooling, removal of masking tape, etc. should be complete within five to ten minutes.

Cure

The curing process of 73-20 RTV Sealant starts with its exposed surface and progresses inward; an initial tack-free skin forms shortly across the exposed surface. At 75° F (24° C) and 50% relative humidity a skin will form in about 20 minutes. Any required tooling should be enacted prior to the skin starting to form; it is also necessary to remove any masking tape if it is used along the edges of the application area. Tooling and the removal of masking tape should be limited to the first 5 or 10 minutes. The curing process is directly affected by the moisture exposure; greater or lesser relative humidity will speed up or slow down the cure process.

Thickness, as well as humidity will affect the total cure time of the material. At room temperature, a ⅛" thick confined bead of 73-20 will solidify to a solid rubber in 24 hours with a final cure within 3 days. A ½" bead might add a day to the cure, though the outer ⅛" would cure at a like rate.

An odor caused by the release of acetic acid will be experienced during the cure period. This unpleasant aroma will disappear with a cure and will not be detectable after a full cure.

- **Type: One-part silicone rubber**
- **Form: Nonslumping paste**
- **Cures at room temperature and ambient humidity**
- **Low temperature flexibility**
- **High temperature performance**
- **Excellent weatherability and ozone and chemical resistance**
- **General Use: As a sealing or bonding adhesive or gasketing**
- **Product will not yellow or discolor in exterior applications.**

Use

Speedline 73-20 RTV Adhesive/Sealant is commonly used to:

- Seal joints between layers of plastic or layers of metal and plastic
- Attach screwless fastenings to metal, wood or plastic
- Can be used in metal to metal applications
- Bonded gasketing in heating and refrigeration applications

Compliance Information

Speedline 73-20 RTV Adhesive/Sealant complies with the following codes and standards:

- MIL-A-46106
- Meets the requirements of FDA Regulation No. 21 CFR 177.2600 subject to end use compliance with limitations
- Meets the requirements of USDA for use in Federally inspected meat and poultry plants
- TT-S-001543A (COM-NBS) Class A, TT-S-00230C (COM-NBS) Class A
- Canadian 19-GP-9MA Type 1
- Conforms to NSF standard 51

Typical Properties as Supplied

RTV	Room Temperature Vulcanizing
Colors	Aluminum, white, and clear
Specific Gravity at 77° F (25° C)	1.04
Extrusion Rate (3.18mm orifice, 90 psi air pressure)g/min	350
Flow, Sag, Slump	NIL
Application Temperature Range, °F (°C)	37 to 60 (-35 to 140)
Tooling Time, Minutes	5-10
Tack Free Time, Minutes	20
Cure Time at 77° F (25° C and 50% RH (3.18mm thick ness),hrs	24

As Cured (7 days)

Durometer Hardness, Shore A, points (ASTM 2240)	25
Tensile Strength, Mpa (psi)...(ASTM D412)	4 (350)
Elongation , percent (ASTM D412)	550
Brittle Point, F (C)	-62 (-82)
Peel Strength, ppi	21.6
Temperature Range:	
Continuous operating temperature, max	450°F (232° C)
Intermittent operating temperature, max	500°F (250° C)

Caution

This product will form formaldehyde vapor at temperatures above 300° F (150° C) in the presence of air. Formaldehyde is a potential cancer hazard and known to promote skin and respiratory problems. These vapors will irritate eyes, nose and throat. Material should be installed in well ventilated areas. **Take precautions to preclude contact with skin and eyes. Read the further precautions in the Safety Data Sheet and those outlined on the material label prior to handling.**

Warranty and Shelf Life:

When stored in the original, unopened container at temperatures less than 90°F (32° C) it is guaranteed for one year from date of purchase.

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