**TECHNICAL DATA SHEET**

**ASI 502 100% RTV Silicone**

**Features**
- 100% Acetoxy RTV Silicone
- Mold & Mildew Resistant
- Resistant to UV Degradation And Weathering
- Withstands Extreme Cold & Extreme Heat
- 25% Joint Movement Capability
- One-Component, Easy To Use Formulation

**Description**
ASI 502 100% RTV Silicone is a one-component, moisture cure, acetoxy silicone that cures to form an extremely durable rubber that can withstand a variety of extreme environments. Unlike many organic sealants, ASI 502 is extremely resistant to degradation, weathering, extreme temperatures and mold and mildew. ASI 502 meets the requirements of NSF Standard 51 and FDA Regulation No. 21 CFR 177.2600 for food grade applications. ASI 502 100% RTV Silicone can be applied to both vertical and overhead joints without sagging and is easy to extrude at both hot and cold temperatures. It will adhere to most common building materials (see list on back of TDS).

**Additional Features**
- Easy to Extrude At Cold Temperatures
- Non-Slump, Can Use On Overhead & Vertical Applications
- Excellent For Indoor & Outdoor Applications
- Creates A Waterproof Seal

**Conforms, Meets & Exceeds**
- ASTM C920  Class 25, Type S, Grade NS, Use NT, G, O
- TT-S-01543A
- TT-S-00230-C
- MIL-A-46106A
- NSF Standard 51
- FDA Regulation No. 21 CFR 177.2600
- UL Recognized
- VOC Compliant (23 grams/liter ASTM D2369)

<table>
<thead>
<tr>
<th>Physical Properties</th>
<th>Test Method</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity</td>
<td>ASI Test Method</td>
<td>582,000 cps (Spindle 7, 4rpm)</td>
</tr>
<tr>
<td>Skin Formation Time</td>
<td>ASI Test Method</td>
<td>10 minutes (70°F, 50% RH)</td>
</tr>
<tr>
<td>Density</td>
<td>ASTM D1475</td>
<td>8.5 lbs./gal</td>
</tr>
<tr>
<td>Hardness</td>
<td>ASTM C661</td>
<td>25 (Shore A)</td>
</tr>
<tr>
<td>Extrusion Rate</td>
<td>ASI Test Method</td>
<td>365 g/min</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>ASTM D412</td>
<td>264 psi</td>
</tr>
<tr>
<td>Elongation at Break</td>
<td>ASTM D412</td>
<td>500%</td>
</tr>
<tr>
<td>Application Temperature</td>
<td>ASI Test Method</td>
<td>-35°F to 150°F</td>
</tr>
<tr>
<td>Gun Grade</td>
<td>ASI Test Method</td>
<td>Pass (Non-Slump)</td>
</tr>
<tr>
<td>QUV Testing</td>
<td>ASTM G26</td>
<td>Pass (10,000 hrs)</td>
</tr>
<tr>
<td>Service Temperature</td>
<td>ASI Test Method</td>
<td>-50°F to 400°F</td>
</tr>
<tr>
<td>Typical Cure Rate</td>
<td>ASI Test Method</td>
<td>24 hrs. (1/8” bead)</td>
</tr>
</tbody>
</table>

Strength will start to develop immediately and continue increasing for 7 days after application. ASI recommends testing strength and adhesion on the 7th day. ASI 502 suggested application temperature range: -35°F to 150°F. ASI 502 can be used at temperatures higher than 400°F for intermittent periods. Testing should be done to confirm temperature requirements are met.

Information on this data sheet can change without notice and it is therefore not recommend that these figures be used in spec writing. If you have any questions contact manufacturer ‘s sales and technical service department.
Common Applications:
ASI 502 is an excellent sealant/adhesive for many Commercial, Industrial and Construction applications. Such applications include:
- Walk-In Freezer Manufacturing & Installation
- RV & Trailer Manufacturing
- Countertop Installation & Sealing
- Formed-In-Place Gasket Applications
- Industrial Manufacturing Applications
- Bathroom Installation & Sealing
- HVAC Applications
- Fireplace Manufacturing
- Appliance Manufacturing
- Sheet Metal Work & Sealing
- Marine Applications
- General Sealing & Bonding Applications

*Can be used for additional applications not listed. ASI recommends testing prior to use.*

Common Bonding Substrates:
ASI 502 can be used on a variety of substrates. Please inquire or test your substrates before use. Substrates may vary with manufacturer. We have listed some common substrates:
- Glass
- Granite
- Marble
- Metal
- Most Types Of Woods
- Most Fiberglass
- Aluminum
- Ceramic
- Natural & Synthetic Fiber
- Most Painted Surfaces
- Some Plastics

*Can be used on additional substrates not listed. ASI recommends testing prior to use.*

Directions
ASI 502 is ready to use and requires no mixing or additives. Tooling, if necessary, should be done before skinning takes place. In applications where partial or total confinement of sealant is prevalent, the time required for proper cure is generally lengthened by the degree of confinement. Higher temperature and higher humidity will accelerate skin & cure time. Cold temperatures and low humidity will slow down skin & cure time.

Clean Up
Wet adhesive can be cleaned with ASI 0240 Adhesive Remover & Cleaner. Dry sealant can be removed by abrading or scraping with aid from ASI 0240. See ASI 0240 TDS for more information.

Colors
ASI 502 is available in clear, white, black, aluminum, almond, bronze, gray, trans white, trans blue, trans rose, trans green, trans charcoal, trans beige, trans earth and trans gray. Additional colors can be available for purchase. Inquire to ASI sales staff for additional information.

Packaging
ASI 502 is stocked in squeeze tubes, cartridges, pails and drums. It can also be packaged into quart cartridges, sausage packs, semcos and pouches. Inquire to ASI sales staff for additional information.

Caution/Safety
Please refer to the SDS for the corresponding product for information regarding safety and handling.

Limitations
Do not store at elevated temperatures. Use only on clean surfaces free of contaminants. Cold temperature and low humidity will slow curing. Do not use on porous surfaces such as concrete, mortar or brick. It is not paintable.

Surface Preparation
All surfaces should be dry and clean. Alcohol or acetone can be used to clean the surface depending on the substrate. Priming for ASI 502 is not normally required. If a primer is required, please inquire to ASI sales staff. Unprimed adhesion can be easily tested by applying a small trial bead and allowing 7 days for maximum adhesion to occur. If primer is required, contact ASI.

Testing
Test per application requirement. Allow 7 days for maximum strength to develop before testing adhesion or strength.

Storage
When stored at 70°F and 50% RH, ASI 502 has a shelf-life of 12 months in cartridges, squeeze tubes, pails & drums. High temperature and high humidity can significantly reduce shelf-life.

Warranty Limitations
The information and data contained herein is believed to be accurate and reliable; however, it is the user’s responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made. It is the user’s responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application. Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain such authorization. Because the storage, handling and application of the material is beyond ASI’s control, we can accept no liability for the results obtained. ASI’s sole limited warranty is that the product meets the manufacturing specifications in effect at time of shipment. There is no warranty of merchantability or fitness for use, nor any other express or implied warranty. ASI will not be liable for incidental or consequential damages of any kind. The exclusive remedy for breach of such limited warranty is a refund of purchase price or replacement of any product shown to be other than as warranted. Suggestions of uses should not be taken as inducements to infringe upon any patents.