

**Silicone Rubber Sealant for filleting in Aluminum**  
**5.6 Oz Cartridge NSN: 8030-01-435-3104**

Technical Bulletin # 3096

**Product Description**

**INSULCAST RTVS 1657** is an aluminum filled silicone rubber caulk that finds use as a filleting material in aluminum construction. It is based on a non-corrosive RTV material that will not attack the surfaces it will be bonded to and is self bonding.

**Properties Uncured**

COLOR, VISUAL:	Gray
VISCOSITY:	Flowable Paste
SHELF LIFE @ 25°C, months:	6
POT LIFE (100 gr.) @ 25°C, mins:	0.5

**Properties Cured**PHYSICAL

HARDNESS, DUROMETER (Shore A):	40 minimum
ALUMINUM CONTENT, %	65 to 82
SERVICE TEMPERATURE, °C:	-60 to +220

**Use Instructions**

1. Before applying make sure that surface is clean and free of dirt and oils.
2. Remove rear red cap on cartridge and discard.
3. Remove front end cap and quickly screw in the appropriate size nozzle.
4. Insert cartridge in dispensing gun and apply to seam in a steady flow.
5. If smoothing is needed use a spatula, wipe off excess with a clean rag.
6. Re-cap when not in use, material cures in the presence of moisture, so that if humidity is below 10% cure may be slower than in typical properties.
7. Clean-up with VM & P Naphtha.

**Cure Schedule**

At room temperature:  
Cures to green strength (tack-free) in 2 hours.  
Full cure in 48 hours.

**Storage Requirements**

This product may settle upon shipment or storage. The product should be re-mixed well prior to use. Store material in a cool dry place.

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Q 06420

**Special** Notes

Certain materials may inhibit the cure of **RTVS 1657** when placed in contact with the mixed, uncured rubber. Materials such as amines and amine cured epoxies, sulfur containing materials and condensation (tin cured) silicones, are some which may cause inhibition. Even surfaces which have been in contact with such materials may cause it. If in doubt, a patch test should be done.

**Date** 02/2009**IMPORTANT:**

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**HEALTH CAUTION:**

Avoid breathing possible fumes, mists and vapors which can cause severe respiratory damage. Use of NIOSH approved breathing apparatus is required for more than minimal exposure. Always work in areas with adequate ventilation to allow dissipation of polyamine and other chemical fumes, and where applicable, solvent fumes. Use of goggles, protective garments, rubber gloves, protective cream is required. If material gets into eyes, flush thoroughly with clean water for twenty (20) minutes; then seek medical treatment. Avoid skin contact. Material can cause contact dermatitis. Always wash exposed areas immediately, using warm water and soap, followed by rinsing with clean water. Observe all safety precautions. It is important when using solvent based materials or solvents to keep away from open flame or ignition source.

**PLEASE REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER FIRST AID INFORMATION. FOR CHEMICAL EMERGENCY, CALL CHEMTREC (DAY OR NIGHT) 800 424-9300.**