



#### TYPICAL USES

- Industrial Hi-Temp Form-in-Place gasket maker
- Mechanical assemblies in high temperature environments
- Replaces almost any cut gasket and can be used to coat pre-cut gaskets to increase reliability
- Water pump and compressor gaskets
- Appliance gaskets
- Ductwork sealer/adhesive
- Electrical insulation
- Air conditioner and humidifier gaskets
- Fireplace seals
- High temperature spacers

#### PRODUCT DESCRIPTION

CSL504 is a one part, moisture curing, room-temperature vulcanizing (RTV), 100% silicone sealant that cures to a tough rubber gasket and is ideal for high temperature applications.

CSL504 is designed to maintain maximum performance in a continuous temperature environment of up to 315°C (600°F) and intermittent exposure up to 343°C (650°F). The gasket will remain permanently flexible even after 7 day continuous exposure to maximum temperatures.

CSL504 resists aging, weathering and thermal cycling without hardening, shrinking, or cracking.

#### PRODUCT CHARACTERISTICS AND PRACTICAL INFORMATION

Type	100% silicone, one-part RTV
Appearance	Smooth, non-slump black paste
<b>Temperature Range‡</b>	
Application Temperature Range	Ambient to 50°C (120°F)
Useable Temperature Range	-60°C to 315°C (-76°F to 600°F); Intermittently up to 343°C (650°F).
<b>Drying Time*</b>	
Skin-Over Time	10-20 minutes
Cure Time	24 hours
Full Physical Characteristics	7 days

#### PHYSICAL PROPERTIES

(Typical properties - values not to be used as specifications)

<b>Uncured</b>	
Specific Gravity	1.14
Slump/Sag	Nil
Extrusion Rate (3.2mm (1.8") orifice, 90psi)	350 g/min
Cure System	Acetoxy, Moisture Cure

#### Cured At Standard Conditions\* for 7 Days

Durometer Hardness (ASTM D2240, Shore A)	30 points
Tensile Strength (ASTM D412)	290 psi (20.4 kg/cm <sup>2</sup> )
Elongation at Break (ASTM D412)	300%
Tear Resistance (ASTM D624, Die B)	31 ppi (5.4 kN/m)
Shrink Factor	Nil

‡Please consult CSL for suitability for application at lower temperatures

\*At standard conditions 77°F (25°C) and 50% relative humidity

#### COLORS

CSL504 is available in Black.

#### SURFACE PREPARATION

All surfaces should be clean and dry, and free of dust, dirt, and grease.

#### APPLICATION

CSL504 is ready to use and requires no mixing or additives. The cure mechanism begins as soon as the sealant is exposed to air.

At conditions of 25°C (77°F) and 50% relative humidity, a bead of sealant 3mm (1/8") will skin over within 10-20 minutes and fully cure in 24 hours. Higher humidity accelerates cure.

#### For assembly as a form-in-place gasket

1. Remove all previous material from mating surfaces.
2. All surfaces should be clean and dry.
3. Cut nozzle to desired bead size: 1/16"-1/4" diameter; 1/8" bead is usually sufficient for most applications.
4. Remove cap, puncture tube or cartridge seal and attach extension nozzle.
5. Apply a continuous and even bead of silicone to one surface, first tracing the internal areas of the gasket configuration, then all surrounding bolt holes.
6. Assemble parts immediately while silicone is still wet.
7. Finger tighten flange only until material begins to seep out the sides of the flange.
8. Allow to set for at least two hours and re-torque at least one quarter to one half turn.
9. For best results, allow to cure overnight.

#### For assembly as a gasket dressing

1. Repeat steps 1 thru 4 as in previous section.
2. Apply a thin film of silicone to one surface to be sealed.
3. Place the pre-cut gasket onto silicone film.
4. Apply a second thin film to pre-cut gasket surface.
5. Remove any excess and assemble parts immediately.

## SAFETY PRECAUTIONS

CSL504 releases small amounts of acetic acid during cure. Adequate ventilation should be provided with extensive use of this sealant.

On direct contact, uncured sealant may irritate eyes. Flush well with water and call a physician. Avoid prolonged contact with skin. See Safety Data Sheet available on this product.

This product is intended for use only by professional applicators in accordance with the advice given in this document, the Safety Data Sheet (SDS) and the container(s), and should not be used without reference to the SDS that CSL Silicones Inc. has provided to its customers. **KEEP OUT OF REACH OF CHILDREN.**

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards & regulations.

If in doubt regarding the suitability of use of this product, consult CSL Silicones Inc. for further advice.

## STORAGE

CSL504, when stored in original, unopened container in dry, shaded conditions, away from sources of heat or ignition, and stored at or below 32°C (90°F), has a shelf life of 18 months from date of manufacture.

## PACKAGING

CSL504 is available in 300 ml (10.2 fl. oz.) cartridges, 19L (5 US gallon) pails and 189L (50 US gallon) drums.

## WARRANTY

CSL Silicones Inc. warrants that its products will meet its specifications. CSL shall in no event be liable for incidental or consequential damages. Except as expressly stipulated, CSL's liability, expressed or implied, is limited to the stated selling price of any defective goods.

Data is subject to change without notice and it is therefore recommended that this information not be used for specification writing. For additional information on specific applications, contact the manufacturer.

**CSL is ISO 9001:2008 Registered**  
**CSL504 is Ecologo Certified**

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### Disclaimer

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