



## 2530

2530 is two components addition type adhesive that can cure fast at high temperature providing excellent sealing and bonding.

This material is recommended for use with metals, plastics and glass. This material is also capable to snap cure during in-line production at higher temperatures.

<b>Technology / Base</b>	Silicone
<b>Type of Product</b>	Adhesive
<b>Components</b>	Two components
<b>Curing</b>	Heat cure
<b>Appearance / Color</b>	Black
<b>Consistency</b>	Viscous Liquid

### Features and Benefits

- Fast cure at high temperature.
- Easy handling due to 5.1:1 mass mixing ratio.
- Excellent adhesion to various substrates.
- Suitable for automated dispensing.
- Excellent thermal performance.
- Excellent resistance to all kinds of weather such as UV light, rainwater and hailstone impacting, etc.

### Curing Profile

Recommended cure:

- 120 °C for 5 minutes

Contact HB Fuller technical support for additional curing recommendations.

### Application Instructions

1. Coating surface area should be clean and free of any fluxes, residues, dust or any other contaminants.
2. Mix evenly according to the ratio.
3. The assembly must be completed within the operating time. The cure speed can be accelerated by heating if need.
4. Recommended using automatic dispensing equipment to applying the potting compound.

### Storage Conditions

Product shall be ideally stored in a cool, dry area in unopened containers under 30°C. Keep away from children.

Shelf Life: 6 months from date of manufacture.

### Typical Packaging

Please contact your local Sales Office for available packaging options.

### Disposal Advice

Please refer to the MSDS for disposal instructions.

### Safety Advice

Please refer to the MSDS for safety advice.



Technical Data

Rheology	Value	Condition/Method
Viscosity Resin	120000 mPa·s	GB/T 2794
Viscosity Activator	8000 mPa·s	GB/T 2794
<b>Density</b>		
Part A Density	1.24 g/cm <sup>3</sup>	GB/T 13354
Part B Density	0.97 g/cm <sup>3</sup>	GB/T 13354
Mixed Density	1.19 g/cm <sup>3</sup>	GB/T 13354
<b>Mix Ratio</b>		
Volumetric Mix Ratio	4:1	
Weight Mix Ratio	5.1:1	
<b>Curing</b>		
Flash Point	> 93 °C	GB/T 5208
Working Time	30 minutes	
Cure Temperature and Time	5 minutes @ 120 °C	
<b>Cured Mechanical Properties</b>		
Hardness	27 Shore A	GB/T 531
Tensile Strength	1.8 MPa	GB/T 528
Elongation to Break	200%	GB/T 528
Shear Strength Aluminum –Aluminum	1.2	GB/T7124
<b>Thermal Indication</b>		
Thermal Service Range	(-50~300)°C	
<b>Thermal Aging Property (300°C for 7 days)</b>		
Tensile Strength	1.8 MPa	GB/T 528
Elongation to Break	200%	GB/T 528

Date Modified: 01/01/2022

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



**NOTE TO USER:** by ordering/receiving product, you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received this documentation. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, (1) the total aggregate liability of H.B. Fuller for any claim or series of related claims, however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability, or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. (2) H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill, or any indirect or consequential losses arising out of or in connection with product supply. (3) Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence, death, or personal injury caused by negligence, or for breach of any mandatory implied terms unless permitted by law.