



1521

1521 is two components adhesive that can cure fast at room temperature providing excellent sealing and bonding.

This material is recommended for the potting of electronic components, typically for junction box on PV modules.

| | |
|---------------------------|-----------------------|
| Technology / Base | Silicone |
| Type of Product | Adhesive |
| Components | Two components |
| Curing | Room temperature cure |
| Appearance / Color | Black |
| Consistency | Viscous Liquid |

Features and Benefits

- Fast cure at room temperature, excellent deep section cure.
- Easy handling due to 6:1 mixing ratio.
- Excellent adhesion to various substrates.
- Suitable for automated dispensing.
- Excellent electrical performance.
- Excellent resistance to hot damp conditioning.

Curing Profile

Recommended cure:

- (23±2)°C, (50±5)%RH for 7 days

Contact HB Fuller technical support for additional curing recommendations.

Please contact your local Sales Office for available packaging options.

Disposal Advice

Please refer to the MSDS for disposal instructions.

Application Instructions

1. Part A should be blended thoroughly before mix with Part B in order to make filling material distribute evenly.
2. Mix evenly according to the ratio.
3. Pot the mixed material.
4. Recommended using automatic dispensing equipment to applying the potting compound.

Safety Advice

Please refer to the MSDS for safety advice.

Storage Conditions

Product shall be ideally stored in a cool, dry area in unopened containers at room temperature.
 Keep away from children.
 Shelf Life: 6 months from date of manufacture.

Typical Packaging



Technical Data

| Rheology | Value | Condition/Method |
|--|---------------------------|-----------------------------------|
| Viscosity Resin | 13000 mPa·s | GB/T 2794 |
| Viscosity Activator | 25 mPa·s | GB/T 2794 |
| Viscosity Mixed | 3000 mPa·s | GB/T 2794 |
| Density | | |
| Mixed Density | 1.40 g/cm ³ | GB/T 13354 |
| Mix Ratio | | |
| Volumetric Mix Ratio | 4:1 | |
| Weight Mix Ratio | 6:1 | |
| Curing | | |
| Flash Point | >93°C | GB/T 5208 |
| Working Time | 8 minutes | Viscosity higher than 30000mPa·s. |
| Gel Time | 60 minutes | The glue does not flow. |
| Cured Mechanical Properties | | |
| Hardness | 40 ShoreA | GB/T 531 |
| Tensile Strength | 1.2 MPa | GB/T 528 |
| Elongation to Break | 110% | GB/T 528 |
| Thermal Indication | | |
| Thermal Service Range | (-50~150)°C | |
| Heat-Conducting Property | | |
| Thermal Conductive | 0.30 W/m·K | DIN EN 821 |
| Electrical Property | | |
| Volume Resistivity | 1.0×10 ¹⁵ Ω·cm | GB/T 1692 |
| Breakdown Strength | 23kV/mm | GB/T 1695 |
| Damp-Heat Aging Property (85°C,85%RH for 1000h) | | |
| Volume Resistivity | 1.0×10 ¹⁵ Ω·cm | GB/T 1692 |

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