



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	White	
Consistency	Viscous Liquid	

Features and Benefits

- Fast cure at room temperature, excellent deep section cure.
- Easy handing due to 6:1mixing 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)℃, (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.

Please refer to the MSDS for safety advice.

Disposal Advice

Safety Advice

Please refer to the MSDS for disposal instructions.

Application Instructions

- 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.

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





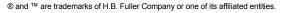
Technical Data			
Rheology	Value	Condition/Method	
Viscosity Resin	7000 mPa⋅s	GB/T 2794	
Viscosity Activator	25 mPa⋅s	GB/T 2794	
Viscosity Mixed	3000 mPa⋅s	GB/T 2794	
Density			
Mixed Density	1.40 g/cm ³	GB/T 13354	
Mix Ratio			
Volumetric Mix Ratio	4:1		
Weight Mix Ratio	6:1		
Curing			
Flash Point	> 93 ℃	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)℃		
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℃,85%RH for 1000h)			
Volume Resistivity	1.0×10 ¹⁵ Ω⋅cm	GB/T 1692	

Technical Data

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