



1522

1522 is two components adhesive that can cure fast at room temperature providing high bond strength.

This material is recommended for use with metals, plastics and glass. Typical applications involve the sealing and bonding of PV modules.

Technology / Base	Silicone
Type of Product	Adhesive
Components	Two components
Curing	Room temperature cure
Appearance / Color	Black
Consistency	Paste

Features and Benefits

- Fast cure at room temperature, excellent deep section cure.
- High bond strength on a variety of substrates.
- Suitable for automated dispensing.
- Excellent electrical performance.
- Excellent resistance to all kinds of weather such as UV light, rainwater and hailstone impacting, etc.

Curing Profile

Recommended cure:

- (23±2)°C, (50±5)%RH for 7 days

Contact HB Fuller technical support for additional curing recommendations.

Typical Packaging

Please contact your local Sales Office for available packaging options.

Disposal Advice

Please refer to the MSDS for disposal instructions.

Application Instructions

1. Coating surface area should be clean and free of any fluxes, residues, dust or any other contaminants.
2. A specific machine must be used to mix part A and B.
3. The assembly must be completed in the working time.
4. The excess adhesive can be removed after the clean-up time.

Safety Advice

Please refer to the MSDS for safety advice.

Storage Conditions

Product should be stored in a cool, dry area in unopened containers at room temperature. Keep away from children.

Shelf Life: 6 months from date of manufacture.



Technical Data

Rheology	Value	Condition/Method
Viscosity Resin	Thixotropy	
Viscosity Activator	Thixotropy	
Viscosity Mixed	Thixotropy	
Density		
Mixed Density	1.29g/cm ³	GB/T 13354
Mix Ratio		
Volumetric Mix Ratio	10:1	
Weight Mix Ratio	12.2:1	
Curing		
Flash Point	> 93°C	GB/T 5208
Working Time	10 minutes	
Clean-up Time	30 minutes	
Cured Mechanical Properties		
Hardness	41 Shore A	GB/T 531
Tensile Strength	2.4 MPa	GB/T 528
Elongation to Break	200%	GB/T 528
Lap Shear Strength		
Aluminum –Aluminum	1.3 MPa	GB/T 7124
Tensile Strength		
Aluminum –Glass	1.1MPa	GB/T 13477
Thermal Indication		
Thermal Service Range	(-50~200)°C	
Electrical Property		
Volume Resistivity	4.0×10 ¹⁴ Ω·cm	GB/T 1692
Breakdown Strength	20kV/mm	GB/T 1695
Damp-Heat Aging Property (85°C,85%RH for 1000h)		
Hardness	32 Shore A	GB/T 531
Tensile Strength	1.8 MPa	GB/T 528
Elongation to Break	180%	GB/T 528
Lap Shear Strength		
Aluminum –Aluminum	1.0 MPa	GB/T 7124
Tensile Strength (H-Bar)		
Aluminum –Glass	1.0MPa	GB/T 13477

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