

ThreeBond 1227H

(RTV-Silicone Liquid Gasket)

The product Three Bond 1227H is a single component, solvent free and non-acid liquid gasket on RTV (Room Temperature Vulcanising)- Silicone basis with Alcohol crosslinker. Within a very short time it forms a rubber-like highly elastic gasket completely adapted to the surface structure of the flange facing. Three Bond 1227H has been designed specifically as liquid gasket for flange surfaces which must resist extreme vibrations, e.g. cylinder head cover, oil pans, water pumps etc.

1. Features

- MEKO free RTV-Silicone
- Excellent chemical resistance against coolants and engine oil
- Outstanding mechanical and thermal resistance
- Excellent adhesion even to slightly polluted surfaces
- Extremely fast curing
- Instantaneous impermeability for pressure and fire test
- No shrinkage and no generation of corrosive gases
- No corrosion of metal and only very slight reaction on plastics

2. Typical properties

Test Item	Result 1227H	Unit
Reaction type	Alcohol	
Colour	Black	
SOD-Viscosity at 25°C	270	Pa·s
Density at 25°C	1.42	g/cm ³
Tack-free time at 25°C x 55% RH	≤33	min
Shore hardness	A57	
Elongation	235%	
Tensile strength	2.3	MPa
Shear strength Al/Al	1.7	MPa
Shear strength Mg/Mg	0.6	MPa
Shear strength Nylon/Nylon	1.7	MPa
Shelf life at 25°C	12*	Months

Curing condition: 25°C x 55% RH x 7 days
*230 kg drum 9 months

3. Oil resistance (Oil: SL OW-30)

150°C x 480h ✕Oil: Castrol product

Test Item	TB1227H	Unit
Shore hardness (A)	24	
Elongation	320%	
Tensile strength	1.9	MPa
Shear strength Al/Al	0.9	MPa

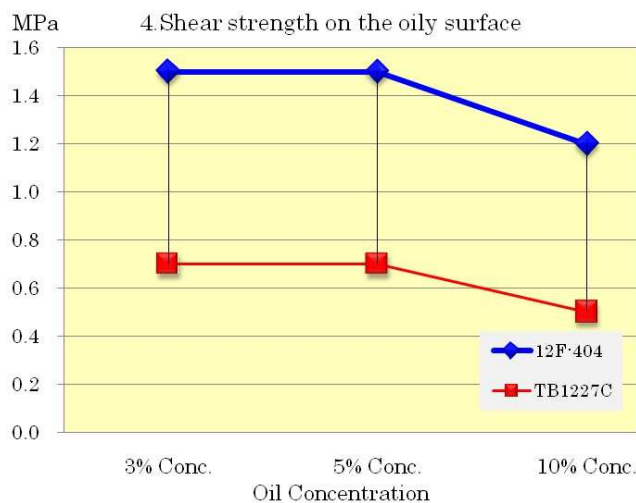
Curing condition: 25°C x 55% RH x 7 days

4. Shear strength on the oily surface

(Oil: SM 5W-30) ※Oil: Castrol product

Oil concentration	TB1227H	Unit
3%	1.5	MPa
5%	1.5	MPa
10%	1.2	MPa

Curing condition: 25°C x 55% RH x 7 days



5. Handling

- Keep the original container tightly closed and store it in a dark, dry, sufficiently ventilated and cool place
- The formation of skin and the thick hardenability of silicone vary depending upon the thickness of the layer, the ambient temperature and the relative air humidity

- In order to obtain optimal results, remove humidity, fat and other impurities from the fitting surfaces
- According to the nature of the joints (width, surface roughness, unevenness) apply an appropriate quantity of silicone uniformly on one of the fitting surfaces and assemble the parts within 10 minutes
- If the liquid gasket will be applied by means of our OLGs (On Line Gasket System), this always permits, even in case of complicated shapes, a uniform, clean and reliable dispensing with a minimum consumption
- Silicone once transferred into another container should not be returned to the original container. Excess sealant can be easily wiped off with a cloth

6. Packing

310 ml cartridges and 20 kg pail cans

All data given here were compiled to the best of our knowledge and are based on experiments and tests of our Company. We cannot guarantee the results obtained through the use of our products, and all products are sold and samples given without any warranty, expressed or implied, of fitness for any particular purpose or otherwise and upon condition that the user shall make his own tests to determine the suitability of the product for his purpose.

