

NOT MEASUREMENT SENSITIVE

A-A-2985A

April 4, 2001

SUPERSEDING

A-A-2985

March 15, 1996

COMMERCIAL ITEM DESCRIPTION

ADHESIVE, AIR-CURE, SILICONE RUBBER

The General Services Administration has authorized the use of this commercial item description for all federal agencies.

1. **SCOPE.** This Commercial Item Description covers a synthetic adhesive suitable for use in bonding silicone rubber to itself and to aluminum without the use of heat and pressure. The product may be either a one-part or a two-part adhesive.

2. **CLASSIFICATION.**

Type I - One Component

Type II - Two Component

3. **SALIENT CHARACTERISTICS.** The adhesive shall be a silicone rubber material which will produce a product that meets all the requirements specified herein.

3.1 **Curing time.** The adhesive shall be tack-free after curing for 24 hours, and it shall fully cure within 72 hours at 23 +/- 2°C (73 +/- 4°F). Successful completion of the peel strength test as specified in 3.4 shall verify the curing time.

3.2 **Pot life.** Pot life for Type II material only shall be a minimum of three hours. Spread 10 grams of the two part, mixed adhesive onto a non-porous surface that has been conditioned at 23 +/- 2°C (73 +/- 4°F). Maintain room temperature for three hours. If the material remains spreadable after three hours, the pot life requirement has been met.

3.3 **Viscosity.** Viscosity shall be 1000 to 5000 centipoises as determined in accordance with ASTM D 1084, Method B.

3.4 **Peel Strength.** Peel strength, performed after a 24-hour cure, shall be not less than 14N/cm (8 pounds/inch.). After a 72-hour cure, peel strength shall be not less than 17N/cm (10 pounds/inch.). Four specimens of each bond being tested shall be used for each peel test performed. Test specimens shall be prepared in accordance with ASTM D 413, Section 6 (for Strip Specimens - Type A). Alclad aluminum specimens shall conform to SAE J454 (2024). Residual mold release material may be removed from the

Beneficial comments, recommendations, additions, deletions, clarification, etc., and any data which may improve this document, should be sent to: General Services Administration, Hardware SuperStore, Technical Services Division [6FEE], 1500 East Bannister Road, Bldg. #6, Kansas City, MO 64131-3088

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surface of the rubber material prior to bonding; however, the surface of the rubber must be dull and smooth, without visible scratches. Peel tests shall be conducted in accordance with ASTM D 413, Section 10 (Strip Specimens: Type A, 180° peel.)

3.4.1 Water resistance. Rubber bonded to aluminum specimens shall be immersed in water at 23 +/- 2°C (73 +/- 4°F) for 24 hours. The specimens shall then be tested as specified in 2.4 within five minutes after removal from the water. The peel strength shall not have decreased more than 15 percent of the 72 hour cure peel strength value (without immersion) determined in 3.4.

3.4.2 Oil resistance. Rubber bonded to aluminum specimens shall be immersed in oil conforming to ASTM D 471, Reference oil #2, at 23 +/- 2°C (73 +/- 4°F), for 24 hours. The peel strength shall not have decreased more than 20 percent of the 72 hour cure peel strength value (without immersion) determined in 3.4.

4. REGULATORY REQUIREMENTS. The offeror/contractor is encouraged to use recovered materials in accordance with Public Law 94-580 to the maximum extent practicable.

5. PRODUCT CONFORMANCE.

5.1 Product Conformance. The products provided shall meet the salient characteristics of this Commercial Item Description, conform to the producer's own drawings, specifications, standards, and quality assurance practices, and be the same product offered for sale in the commercial market. The government reserves the right to require proof of such conformance.

5.2 Market Acceptability. The following market acceptability criterion is necessary to document the quality of the product to be provided under this CID.

5.2.1 The manufacturer of the item must have been producing the product meeting the requirements of this CID for at least 2 years.

6. PACKAGING. Preservation, packaging, and packing shall be as specified in the contract or order.

7. NOTES.

7.1 Source of Documents.

7.1.1 Copies of ASTM specifications or standards may be obtained from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

7.1.2 Copies of SAE specifications or standards may be obtained from the Society of Automotive Engineers, 400 Commonwealth Dr., Warrendale, PA 15096-0001.

7.2 National Stock Numbers (NSN). The following is a list of NSNs assigned that correspond to this CID. The list may not be indicative of all possible NSNs associated with the CID.

NSN	Type	Size
8040-00-201-8835	I	Quart
8040-00-097-6524	II	Quart
8040-01-027-4900	II	4.0 Ounce

Preparing Activities
GSA-FSS