



Marine Silicone Sealant 3200

Product Data Sheet

January 2009
Supersedes: January 2006

Product Description Marine Silicone Sealant 3200 is a paste-like, one-component material, which cures to a tough rubbery solid when exposed to moisture in the air. It will adhere to clean metal, glass, wood, ceramic, painted surfaces and many plastics. It is easy to use and exhibits excellent resistance to weathering, vibration, mildew and extreme temperatures.

- Key Features**
- Mildew resistant
 - Seals a wide variety of substrates
 - Non-sagging formulation

Technical Data

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Properties	Marine Silicone Sealant 3200
Tack-Free Time @ 23° C and 50% Relative Humidity	30 to 60 minutes for black & white, 30 to 80 minutes for clear
Rate of Cure @ 23° C and 50% Relative Humidity	3 mm per 24 hours
Shore A Hardness ((DIN 53505))	25 (black & white) 21 (clear)
Density at 25° C	1.52 g/cm ³ (black & white) (DIN53479A) 1.05 g/cm ³ (clear) (DIN53479A)
Elongation at Break (DIN 53504 S3A)	> 530%
Tensile strength (DIN 53504 S3A)	2,0 MPa
Service Temperature	-40°C to + 90°C
Colours	White, Black and Clear
Application temperature	5°C to + 40°C
Consistency	Non-sagging paste
UV resistance	Good

Direction for use

Surface Preparation:

Surfaces to be sealed or bonded should be clean and dry. Surfaces should be free from grease, mold release, oil, water/condensation and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Citrus Based Adhesive Remover, 3M™ Scotch-Weld™ Solvent No. 2 or methyl ethyl ketone (MEK).*

***When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to product label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.**

Local and federal air quality regulations may regulate or prohibit the use of this product or surface preparation and cleanup materials. Consult local and federal air quality regulations before using these products.

Note: Alcohol will interfere with the curing process and extra care must be taken when using alcohol as a cleaning solvent to prevent any contact with the sealant.

Use of a primer is an extra step and cost and will depend on substrates and the final end use. Using primer can improve the corrosion resistance of certain metals as well as improve the durability of the bond when exposed to high humidity conditions. For most applications high strength bonds on metal can be achieved without the use of a primer. Pre-testing for adhesion is suggested to determine if a primer is needed. The 3M™ Scotch-Weld™ Structural Adhesive Primer EC-1945 B/A works well for most metals.

Application:

Cut tip to desired bead size. Marine Silicone Sealant 3200 is supplied ready-to-use. Sealant should be applied at temperatures between 5°C and 40°C. The paste-like consistency makes it easy to tool with a spatula. The cure of the silicone progresses inward from the surface. At conditions of at least 23°C and 50% relative humidity a tack-free skin forms within approximately 30 minutes. Tooling is not practical after the skin begins forming.

Cleanup:

While sealant is still soft cleaning can be done with the same solvents used for surface preparation. If sealant is already cured, removal is done mechanically with razor knife, piano wire, sanding or Scotch-Brite™ Moulding Adhesive and Stripe Removal Disc. This disc is available from 3M Automotive Aftermarket Division.

**Application
Equipment
Suggestions**

Cartridge and Flex Pack:

For ease of dispensing an all metal, rod driven, friction feed manual applicator gun or an air operated applicator gun is suggested. Please contact your 3M sales representative for these items.

Bulk Dispensing:

For bulk dispensing a 46:1 ratio dual action piston pump with a ram is suggested. Actual equipment is dependent on the fluid flow desired, the number of guns to be supplied for each pump and distance product has to be pumped. It is best to consult with the equipment supplier to make sure the proper type and size of equipment is specified. Common suppliers of this type of pumping systems are Graco and Binks. It is best to work with a distributor for Graco or Binks located in your area. Our technical service group will be glad to work with you and your chosen supplier to ensure the proper equipment is selected.

Storage	Marine Silicone Sealant 3200 must be stored in the original, un-opened containers at 15 ° C – 25 ° C for maximum shelf life. Rotate stock on a “first in-first out” basis.
Shelf Life	When stored at the recommended conditions in original un-opened containers, Marine Silicone Sealant 3200 has a shelf life of 18 months after date of manufacture.
Precautionary Information	Refer to product label and Material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. http://www.3M.fi/teollisuus
For Additional Information	To request additional product information or to arrange for sales assistance, call Suomen 3M Oy / Teollisuustuotteet, 09-525 21 . Address correspondence to: PL 90 / Lars Sonckin kaari 6, 02601 Espoo.
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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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