



## ND 510 Technical Data Sheet

### Description:

**ND 510** is an injection moldable, elastomeric-based expandable sealant that is supplied in a non-tacky form. The material is formulated to expand and cure when exposed to typical automotive paint or primer bake conditions, providing good adhesion and sealing characteristics to a variety of metal, e-coated metal, and nylon substrates. ND 510 meets Chrysler MS-CD466 Type E, Heat Expandable – High/Low Bake

### Typical Properties:

- Color: Blue
- Specific Gravity: 1.35 g/cm<sup>3</sup>
- Non-Volatile Content: 99 % minimum
- Flash Point > 430 ° F
- Volumetric Expansion: 150 % minimum
- Water Absorption: < 3 %
- Shear Adhesion (Initial): > 150 psi
- Shear Adhesion (Environmental): > 115 psi
- Shelf life: 6 Month

### Recommended Cure Temperatures:

- 250 ° F – 325 ° F

### Application:

**ND 510** is ideal for injection, insert, or two-shot molding processes in which the sealant can be directly molded onto nylon substrates. ND 510 can be supplied in free flowing pellet, sheet stock, and custom die cut shapes to meet the specific needs of the application. Recommended processing temperatures for molding are 180 ° F – 210 ° F.