

## DESCRIPTION

- Two-part, gray silicone adhesive system
- Cures at room temperature or rapidly by applying heat in an oven or by a heat gun or lamp
- Does not require atmospheric moisture to cure
- No curing byproducts such as acetic acid or methyl alcohol
- Product available in easy-to-use, airless side-by-side kits that eliminate mixing and deairing difficulties
- 1:1 Mix Ratio (Part A: Part B)

## APPLICATION

- Adhesive for bonding and sealing silicones to each other and other substrates such as metals and plastics
- For rapid production or prototyping due to a rapid cure

## PROPERTIES

TYPICAL PROPERTIES	RESULT	ASTM	NT-TM
<b>Uncured:</b>			
Appearance, Part A	Black	D2090	002
Appearance, Part B	White	D2090	002
Color, Mixed	Dark Gray	-	-
Extrusion Rate, Part A	280 g/min	C603	033
Extrusion Rate, Part B	290 g/min	C603	033
Work Time	1 hour	-	008
<b>Cured: 2 hours @ 65°C (149°F)</b>			
Specific Gravity	1.16	D792	003
Durometer, Type A	45	D2240	006



TYPICAL PROPERTIES	RESULT	ASTM	NT-TM
Tensile Strength	1,000 psi (6.9 MPa)	D412, D882	007
Elongation	400%	D412, D882	007
Tear Strength	190 ppi (33.5 N/mm)	D624	009
Stress @ 200% Strain	525 psi (3.6 MPa)	D412, D882	007
Lap Shear, unprimed	145 psi (1.0 MPa)	D1002	010
Lap Shear, primed w/ CF1-135	625 psi (4.3 MPa)	D1002	010
180° Peel, primed w/ CF1-135	50 ppi (8.8 N/mm)	D903	104
Young's Modulus	300 psi (2.1 MPa)	-	-
Dielectric Strength	825 Volts/mil (32.5 kV/mm)	D149	-

## INSTRUCTIONS FOR USE

### Mixing

Mix at a 1:1 mix ratio when extracted from their side-by-side kits through a static mix and dispense cartridge. Attach the disposable static mix tip to the cartridge and extrude the product directly onto the substrate.

Note: NuSil Technology recommends discarding the first few grams of extruded material.

Can also be purchased in standard two-part kits. When using standard kits, take care to minimize air entrapped while mixing. Place the mixed product in a vacuum chamber to remove entrapped air and subsequently reduce bubble formation during curing.

### Substrate Consideration

Cures in contact with most materials common to electrical and electronic assemblies. Exceptions include: sulfur cured organic rubbers, latex, chlorinated rubbers, some RTV silicones and unreacted residues of some curing agents. Clean units being encapsulated or potted to ensure they are free of contaminants. Also clean and dry containers and dispensers being used. Prevent cure inhibition by washing all containers with clean solvent or volatilizing the contaminants by heating.

Note: Some bonding applications may require use of a primer. NuSil Technology CF1-135 silicone primer is recommended.

### Adjustable Cure Schedule

Product cures at a wide range of cure times and temperatures to accommodate different production needs. Contact NuSil Technology for details.

### Packaging

50 ml SxS Kit  
 400 ml SxS Kit  
 2 Pint Kit (910 g)  
 2 Gallon Kit (7.28 kg)  
 10 Gallon Kit (36.4 kg)

### Warranty

6 Months



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## WARNINGS ABOUT PRODUCT SAFETY

NuSil Technology believes that the information and data contained herein are accurate and reliable. However, the user is responsible to determine the material's suitability and safety of use. NuSil Technology cannot know each application's specific requirements and hereby notifies the user that it has not tested or determined this material's suitability or safety for use in any application. The user is responsible to adequately test and determine the safety and suitability for their application and NuSil Technology makes no warranty concerning fitness for any use or purpose. NuSil Technology has completed no testing to establish safety of use in any medical application.

NuSil Technology has tested this material only to determine if the product meets the applicable specifications. (Please contact NuSil Technology for assistance and recommendations when establishing specifications.) When considering the use of NuSil Technology products in a particular application, review the latest Material Safety Data Sheets and contact NuSil Technology with any questions about product safety information.

Do not use any chemical in a food, drug, cosmetic, or medical application or process until having determined the safety and legality of the use. The user is responsible to meet the requirements of the U.S. Food and Drug Administration (FDA) and any other regulatory agencies. Before handling any other materials mentioned in the text, obtain available product safety information and take the necessary steps to ensure safety of use.

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## SPECIFICATIONS

Do not use the typical properties shown in this technical profile as a basis for preparing specifications. Please contact NuSil Technology for assistance and recommendations in establishing particular specifications.

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## PATENT WARNING

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## WARRANTY INFORMATION

NuSil Technology's warranty period is 6 months from the date of shipment when stored below 40°C in original unopened containers. Unless NuSil Technology provides a specific written warranty of fitness for a particular use, NuSil Technology's sole warranty is that the product will meet NuSil Technology's then current specification. NuSil Technology specifically disclaims any other expressed or implied warranty, including warranties of merchantability and fitness for use. The exclusive remedy and NuSil Technology's sole liability for breach of warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. NuSil Technology expressly disclaims any liability for incidental or consequential damages.

