R32-2186
Fast-cure silicone adhesive

DESCRIPTION

- Two-part, translucent, thixotropic, high tear strength silicone system
- Cures rapidly with the application of heat in an oven, or by a heat gun or lamp
- Many bonding applications do not require the use of a silicone primer for suitable adhesion
- Does not require atmospheric moisture to cure
- No curing byproducts such as acetic acid or methyl alcohol
- Consistency allows product to be supplied 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

<table>
<thead>
<tr>
<th>Typical Properties</th>
<th>Average Result</th>
<th>Standard</th>
<th>NT-TM</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Uncured:</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Appearance*</td>
<td>Translucent</td>
<td>ASTM D2090</td>
<td>002</td>
</tr>
<tr>
<td>Viscosity, Part A*</td>
<td>82,000 cP (82,000 mPas)</td>
<td>ASTM D1084, D2196</td>
<td>001</td>
</tr>
<tr>
<td>Viscosity, Mixed*</td>
<td>170,000 CP (170,000 mPas)</td>
<td>ASTM D1084, D2196</td>
<td>001</td>
</tr>
<tr>
<td>Flow (0.375&quot; plunge for 5 minutes)*</td>
<td>0.5 inches (1.3 cm)</td>
<td>ASTM D2202</td>
<td>019</td>
</tr>
<tr>
<td>Extrusion Rate, Part A*</td>
<td>6 g/minute</td>
<td>ASTM C603</td>
<td>033</td>
</tr>
<tr>
<td>Extrusion Rate, Part B*</td>
<td>23 g/minute</td>
<td>ASTM C603</td>
<td>033</td>
</tr>
<tr>
<td>Work Time*</td>
<td>15 hours minimum</td>
<td>-</td>
<td>008</td>
</tr>
<tr>
<td><strong>Cured: 15 minutes at 150°C (302°F)</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Specific Gravity*</td>
<td>1.12</td>
<td>ASTM D792</td>
<td>003</td>
</tr>
<tr>
<td>Durometer, Type A*</td>
<td>15</td>
<td>ASTM D2240</td>
<td>006</td>
</tr>
</tbody>
</table>
INSTRUCTIONS FOR USE

Mixing
Mix at a 1:1 mix ratio when extracted from 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 Considerations
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 volatizing the contaminants by heating.

Adjustable Cure Schedule
Product cures at room temperature and a wide range of elevated temperatures and cure times to accommodate different production needs. Contact NuSil Technology for details.

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SPECIFICATIONS

Do not use the 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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