

CF3-3521

Liquid injection molding fluorosilicone elastomer

DESCRIPTION

- Two-part, translucent fluorosilicone elastomer used with liquid injection molding equipment
- 1:1 Mix Ratio (Part A:B)
- Cures at room temperature or rapidly with heat
- 50 mole % fluorosilicone

APPLICATION

- For applications requiring a medium hardness silicone and solvent resistance
- Some typical applications include O-rings, gaskets, seals, and precision molded parts
- Excellent for molding high quality parts at rapid rates
- For applications requiring an operating temperature range of -65 to 240°C (-85 to 465°F)

PROPERTIES

Typical Properties	Average Result	Metric Conv.	Standard	NT-TM
Uncured:				
Appearance	Translucent	-	ASTM D2090	002
Work Time	12 hours	-	-	008
Extrusion Rate, Part A*	90 g/min	-	ASTM C603	033
Extrusion Rate, Part B*	150 g/min	-	ASTM C603	033
Cured: 30 min at 150°C (302°F)				
Specific Gravity	1.26	-	ASTM D792	003
Durometer, Type A	30	-	ASTM D2240	006
Tensile Strength	700 psi	4.8 MPa	ASTM D412	007
Elongation	360 %	-	ASTM D412	007

*Performed using a SEMCO 440 nozzle with an 1/8" orifice and 90 +/-5 psi air pressure

INSTRUCTIONS FOR USE

Mixing

Mix in a 1:1 ratio by weight.

Vacuum Deaeration

Remove air entrapped during mixing by common vacuum deaeration procedure, observing all applicable safety precautions. Slowly apply vacuum, up to 28 inches Hg, to a container rated for use and of volume at least four times that of material being deaerated. Hold vacuum until presence of air is no longer evident.

Substrate Consideration

Cures in contact with most materials. Exceptions include butyl and chlorinated rubbers, some RTV silicones containing organotin and/or amines, and unreacted residues of some curing agents.

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

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 LLC for details.

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.

WARRANTY INFORMATION

The warranty period provided by NuSil Technology LLC (hereinafter "NuSil Technology") is 12 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 all other expressed or implied warranties, including, but not limited to, 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

Packaging

6 oz Foil Barrier Kit (120 g)
12 Ounce Kit (355 mL)
400 mL SxS Kit
2 Pint Kit (910 g)
2 Gallon Kit (7.28 kg)
10 Gallon Kit (36.4 kg)

Warranty

12 Months

warranted. NuSil Technology expressly disclaims any liability for incidental or consequential damages.

WARNINGS ABOUT PRODUCT SAFETY

NuSil Technology believes, to the best of its knowledge, that the information and data contained herein are accurate and reliable. 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 Sheet 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, the user is advised to obtain available product safety information and take the necessary steps to ensure safety of use.

PATENT / INTELLECTUAL PROPERTY WARNING

NuSil Technology disclaims any expressed or implied warranty against the infringement of any domestic or international patent/intellectual property right. NuSil Technology does not

warrant the use or sale of the products described herein will not infringe the claims of any domestic or international patent/intellectual property right covering the product itself, its use in combination with other products, or its use in the operation of any process.