

DESCRIPTION

- Two-part, white silicone system
- Offers a high tear strength, good physical properties and a broad operating temperature range
- Convenient 1:1 mix ratio (Part A: Part B)

Meets or exceeds the ASTM E 595 low outgas specifications outlined in NASA SP-R-0022A and European Space Agency PSS-014-702, with a TML of $\leq 1\%$ and CVCM of $\leq 0.1\%$

APPLICATION

- For applications requiring low outgassing and minimal volatile condensables under extreme operating conditions
- To provide protection of electric components and assemblies against shock, vibration, moisture, dust, chemicals and other environmental hazards
- Ideal for use in potting connectors, cable harness breakouts, molded high-voltage terminals, seals and gaskets due to its high tear strength
- For use as an adhesive
- For applications requiring a broader operating temperature range

PROPERTIES

TYPICAL PROPERTIES	AVERAGE RESULT	ASTM	NT-TM
Uncured:			
Appearance*	White	D2090	002
Viscosity, Part A*	60,000 cP (60,000 mPas)	D1084, D2196	001
Viscosity, Part B*	40,000 cP (40,000 mPas)	D1084, D2196	001
Work Time*	30 minutes	-	008
Tack-Free Time*	4 hours	C679	005
Cured: 15 minutes @ 150°C (302°F)			
Durometer, Type A*	30	D2240	006
Tensile Strength*	700 psi (4.8 MPa)	D412	007
Elongation*	350%	D412	007

TYPICAL PROPERTIES	AVERAGE RESULT	ASTM	NT-TM
Lap Shear Strength* (primed w/ CF1-135)	400 psi (2.8 MPa)	D1002	010
Young's Modulus	325 psi (2.2 MPa)	-	-
Coefficient of Linear Thermal Expansion			
Below Tg (-150°C to -115°C)	60 ppm/°C (60 μm/m/°C)	D3386	-
Above Tg (-95°C to 250°C)	445 ppm/°C (445 μm/m/°C)	D3386	-
Dielectric Strength	955 volts/mil (37.6 kV/mm)	D149	-
Thermal Conductivity	0.230 W/(mK) (55 x 10 ⁻⁵ cal/(cm·sec·°C))	E1530	101
Dynamic Mechanical Analysis (DMA)	See Attached Graph	D4065	-
Collected Volatile Condensable Material (CVCM)*	0.04%	E 595	072
Total Mass Loss (TML)*	0.44%	E 595	072

*Properties tested on a lot-to-lot basis. 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.

INSTRUCTIONS FOR USE

Mixing

Mix Part A and B in a 1:1 mix ratio by weight. CV-2289-1 is ideal for static mix and dispense application.

Vacuum Deaeration

Remove air entrapped during mixing by common vacuum deaeration procedure, observing all applicable safety precautions. Slowly apply full vacuum to a container rated for use and at least four times the volume of the material being deaerated. Hold vacuum until bulk deaeration is complete.

Inhibition Concerns

Cures in contact with most materials common to electronic assemblies. Exceptions include butyl and chlorinated rubbers, some RTV silicones and unreacted residues of some curing agents. Units being encapsulated or potted should be clean and free of surface contaminants. Containers and dispensers being used should also be clean and dry. Cure inhibition can usually be prevented by washing all containers with solvent or volatilizing the contaminant by heating.

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

Adjustable Cure Schedule

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

Packaging

50 ml SxS Kit
500 Gram Kit

Warranty

6 Months

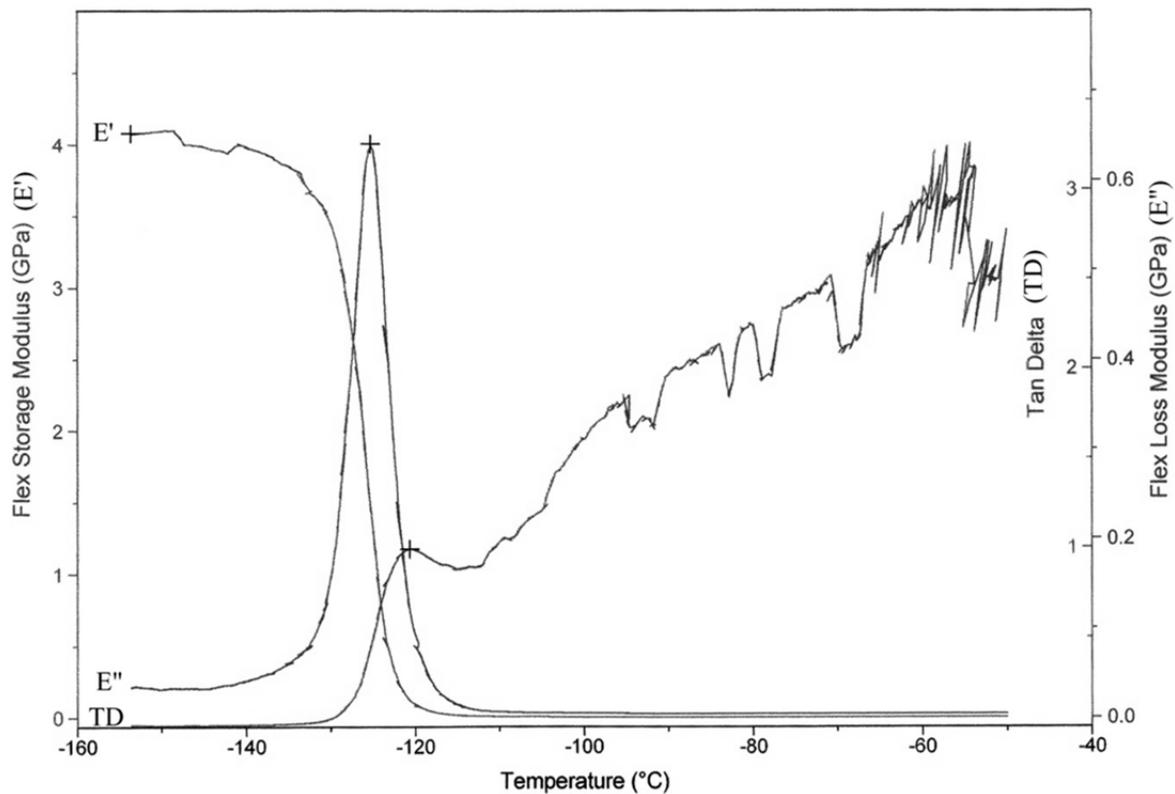
65°C (149°F)
10 minutes

100°C (212°F)
5 minutes

* Cure time defined as the time required for a knife coat layer ~0.02" to be removed from a release liner

DYNAMIC MECHANICAL ANALYSIS (DMA) ASTM D-4065-01

	Tg	Initial E'	Final E' (Gpa)	Tan Delta above Tg
CV-2289-1	-125°C	4.0 Gpa	0.001 Gpa	2 - 25



HEAT AND LOW-TEMPERATURE RESISTANCE

In most applications, silicone may be heated from 180 to 200°C for a year, or even up to 450°C for short periods, without any appreciable effect on physical properties. Silicone also demonstrates flexibility at extreme low temperatures, with a stiffening temperature of approximately -115°C.

The operating temperature range of a silicone in any application is dependent on many variables, including but not limited to: temperature, time of exposure, type of atmosphere, exposure of the material's surface to the atmosphere, and mechanical stress. In addition, a material's

physical properties will vary at both the high and low end of the operating temperature range. The user is responsible to verify performance of a material in a specific application.

RoHS AND REACH COMPLIANCE

CV-2289-1 is compliant with the Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment (RoHS) regulation contained in Article 4(1) of the European Parliament and Council's Directive 2002/95/EC. RoHS mandates that manufacturers restrict the use of lead, mercury, cadmium, hexavalent chromium, polybrominated biphenyls, polychlorinated biphenyls, and polybrominated diphenyl ethers in electrical and electronic equipment.

CV-2289-1 is also compliant with the Registration, Evaluation, and Authorization of Chemicals (REACH) regulation (European Union 1907/2006). CV-2289-1 does not contain any of the 16 chemicals identified as Substances of Very High Concern (SVHC) by the European Chemicals Agency (ECHA), which oversees REACH compliance.

Please contact NuSil Technology's Regulatory Compliance department with any questions or for further assistance.

SPECIFICATIONS

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WARRANTY INFORMATION

The warranty period provided by NuSil Technology LLC (hereinafter "NuSil Technology") 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 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 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.

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