

# GEL-3500

## Fluorosilicone gel

### DESCRIPTION

- A two-part, firm fluorosilicone gel
- Available in custom formulations to offer various work times, cure schedules and penetration values to allow matching of processing techniques to production requirements while maintaining the 1:1 mix ratio

### APPLICATION

- For applications requiring a gel with solvent resistance

### PROPERTIES

Typical Properties	Average Result	Metric Conv.	Standard	NT-TM
<b>Uncured:</b>				
Appearance	Translucent	-	ASTM D2090	002
Viscosity, Part A	12,000 cP	12,000 mPas	ASTM D1084, D2196	001
Viscosity, Part B	10,500 cP	10,500 mPas	ASTM D1084, D2196	001
Work Time	12 hours	-	-	008
<b>Cured: 45 minutes at 150°C (302°F)</b>				
Durometer, Type 00	50	-	ASTM D2240	006
Operating Temperature Range	-85 to 428°F	-65°C to 220°C	-	-

## INSTRUCTIONS FOR USE

### Mixing

Thoroughly mix Parts A and B in a 1:1 ratio by weight or volume. Obtain a softer gel (high penetration value) by increasing the ratio of Part A to Part B or a firmer gel (lower penetration value) by increasing the ratio of Part B to Part A. Changes in the cure rate can result when deviating from the 1:1 mix ratio. Airless mixing, metering and dispensing equipment is recommended for production processing.

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

### Vacuum Deaeration

Removed 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

GEL-3500 will cure in contact with most materials. Exceptions include butyl and chlorinated rubber, some RTV silicones and unreacted residues of curing agents used with a few types of plastics.

### 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.

## 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

### Packaging

50 ml SxS Kit  
2 Pint Kit (910 g)

### Warranty

12 Months

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