

# R-2615

## Optically clear potting and encapsulating silicone elastomer

### DESCRIPTION

- Two-part, optically clear, solvent free, low viscosity silicone
- Cures at room temperature or rapidly with heat
- Offers good physical and electrical stability across a broad range of temperatures
- 10:1 Mix Ratio (Part A: Part B)

### APPLICATION

- To provide protection of electronic components and assemblies against shock, vibration, moisture, ozone, dust, chemicals and other environmental hazards by potting or encapsulating
- For photonics applications
- 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
<b>Uncured:</b>				
Appearance	Transparent	-	ASTM D2090	002
Viscosity	6,000 cP Part A/ 90 cP Part B	6,000 mPas Part A / 90 mPas Part B	ASTM D1084, D2196	001
Viscosity (Parts A and B mixed)	5,300 cP	5,300 mPas	-	-
Work Time	4 hours	-	-	008
<b>Cured: 15 min at 150°C (302°F)</b>				
Specific Gravity	1.03	-	ASTM D792	003
Durometer, Type A	50	-	ASTM D2240	006
Tensile Strength	1,300 psi	9.0 MPa	ASTM D412	007
Elongation	100 %	-	ASTM D412	007
Tear Strength	20 ppi	3.5 kN/m	ASTM D624	009
Refractive Index	1.41	-	ASTM D1747, D1218	018
Dielectric Strength	500 volts/mil	19.7 kV/mm	ASTM D149	-
Volume Resistivity	1 x 10 <sup>15</sup>	-	ASTM D257	040

## INSTRUCTIONS FOR USE

### Mixing

Mix in a 10:1 ratio Part A to Part B, taking care to minimize air entrapment during mixing.

### 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 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 cleaning solvent or volatilizing the contaminants by heating.

Note: Some bonding applications 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 cure times and temperatures to accommodate different production needs. [Contact](#) NuSil Technology for details. Some cure schedules\* include:

<u>65°C (149°F)</u>	<u>100°C (212°F)</u>
40 minutes	2 minutes

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

## 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

### Packaging

37 ml Kit (37.4 g)  
1 Pint Kit (505 g)  
1 Gallon Kit (4.04 kg)  
5 Gallon Kit (20.2 kg)

### Warranty

12 Months

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.

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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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