

# R1-2680-4

## Film adhesive

### DESCRIPTION

- Two-part film adhesive
- Cures at room temperature or rapidly with heat

### APPLICATION

- For bonding or sealing silicone elastomers and some metals or plastics
- For applications requiring shorter work times, easy clean-up, and consistent bond thickness

### PROPERTIES

Typical Properties	Average Result	Standard	NT-TM
<b>Uncured:</b>			
Appearance, Part A	Translucent	-	139
Dimensional Analysis	0.004 inches (0.1 mm)	-	138
<b>Cured: 4 hours at ambient temperature and humidity</b>			
Floating Roller Peel Resistance of Tack Free Films Method B	5 psi (0.037 MPa)	ASTM D1002	314

## INSTRUCTIONS FOR USE

Apply the activator (SP-270) to one or both surfaces coming in contact with the film and allow the solvent to evaporate. Peel off the dark blue backing and apply the sheeting to one surface. Remove the other backing and apply the other surface to the film.

### Substrate Considerations

Cures in contact with most materials, exceptions include: sulfur-cured organic rubbers, latex, chlorinated rubbers, some RTV silicones and unreacted residues of some curing agents.

### Processing and Handling Recommendations

Product cures at a wide range of cure times and temperatures to accommodate different production needs.

Contact NuSil technical sales staff regarding questions or concerns related to a particular application.

## OPERATING TEMPERATURE

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. Silicone typically remains flexible at extremely low temperatures and has been known to perform at -50°C (-58°F) as well as resist breakdown at elevated temperatures up to 250°C (482°F). The user is responsible to verify performance of a material in a specific application.

## ROHS AND REACH COMPLIANCE

Please [contact](#) NuSil Technology's Regulatory Compliance department with any questions or for further assistance.

## 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

### Packaging

12" x 12" Sheet Kit  
(30.48 x 30.48 cm)  
14" x 20' Roll  
(35.56 x 609.6 cm)

### Warranty

12 Months

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.

### **PATENT / INTELLECTUAL PROPERTY WARNING**

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