

## R-2200-11

GRAY SILICONE MOLD-MAKING RUBBER

## DESCRIPTION

- Two-part, pourable silicone with outstanding release properties
- Heat accelerated cure
- High hardness, low shrinkage, and good dimensional stability

## APPLICATION

- Use in the injection and transfer molding of silicone parts
- Flexible potting, encapsulating and mold-making material
- Suited for prototype design and production tooling

## PROPERTIES

TYPICAL PROPERTIES	RESULT	METRIC CONV.	ASTM	NT-TM
<b>Uncured:</b>				
Appearance, Part A	Gray	-	D2090	002
Appearance, Part B	Translucent	-	D2090	002
Viscosity, Part A	150,000 cP	150,000 mPas	D1084, D2196	001
Viscosity, Part B	3,600 cP	3,600 mPas	D1084, D2196	001
Work Time	2.5 hours	-	-	008
<b>Cured: 30 minutes @ 150°C (302°F)</b>				
Specific Gravity	1.24	-	D792	003
Durometer, Type A	60	-	D2240	006
Tensile Strength	800 psi	5.5 MPa	D412	007
Elongation	155%	-	D412	007
Tear Strength	90 ppi	15.9 kN/m	D624	009



TYPICAL PROPERTIES	RESULT	METRIC CONV.	ASTM	NT-TM
Stress @ 100% Strain	800 psi	5.5 MPa	D412	007

## INSTRUCTIONS FOR USE

### Mixing

Thoroughly stir individual parts prior to addition to ensure a homogenous mixture. Mix Parts A and B in a 10:1 ratio.

### Vacuum Deaeration

Remove air entrapped during mixing by common vacuum deaeration procedure, observing all applicable safety precautions. Slowly apply vacuum, up to 28 inches of Hg, to a container rated for use and at least four times the volume of material being de-aired. Hold vacuum until bulk deaeration is complete.

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

### Substrate Considerations

R-2200-11 will cure in contact with most materials common to electrical and electronic assemblies. Exceptions include sulfur-cured organic rubbers, latex, chlorinated rubbers, some RTV silicones and unreacted residues of some curing agents.

### 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.

### Packaging

1 Pint Kit (505 g)  
1 Gallon Kit (4.04 kg)

### Warranty

6 Months

## WARNINGS ABOUT PRODUCT SAFETY

NuSil Technology LLC believes the information and the data contained herein are accurate and reliable. However, the user is responsible to determine the material's suitability and safety of use. NuSil Technology LLC 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 LLC makes no warranty concerning fitness for any use or purpose. NuSil Technology LLC has completed no testing to establish safety of use in any medical application.

NuSil Technology LLC has tested this material only to determine if the product meets the applicable specifications. (Please contact NuSil Technology LLC for assistance and recommendations when establishing specifications.) When considering the use of NuSil Technology LLC products in a particular application, review the latest Material Safety Data Sheet and contact NuSil Technology LLC 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, obtain available product safety information and take the necessary steps to ensure safety of use.

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## SPECIFICATIONS

Do not use the typical properties shown in this technical profile as a basis for preparing specifications. Please contact NuSil Technology LLC for assistance and recommendations in establishing particular specifications.

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## PATENT WARNING

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## WARRANTY INFORMATION

NuSil Technology LLC's warranty period is 6 months from the date of shipment when stored below 40°C in original unopened containers. Unless NuSil Technology LLC provides a specific written warranty of fitness for a particular use, NuSil Technology LLC's sole warranty is that the product will meet NuSil Technology LLC's then current specification. NuSil Technology LLC specifically disclaims any other expressed or implied warranty, including warranties of merchantability and fitness for use. The exclusive remedy and NuSil Technology LLC'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 LLC expressly disclaims any liability for incidental or consequential damages.

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