

## QSiI216 10:1 Addition cure silicone encapsulant optically clear

### Introduction

This is a 2-component, silicone elastomer system specially designed for electronic potting and encapsulation applications. It offers good protection against chemicals, environmental contamination, mechanical shock, vibration and impact damage. It can be employed in areas where low flammability is a prerequisite. The cured elastomer can be repaired. The component parts have relatively low viscosities and are readily mixed either by hand or machine

### Key Features

- Non yellowing under UV light
- Optically clear
- Low Viscosity
- Wide temperature range

### Use and Cure Information

#### IMPORTANT:

The 'A' part of the product contains the platinum catalyst, great care should be taken when using automatic dispensing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.

### Mixing

Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settled fillers have been remixed. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing. Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In the case of automatic dispensing with static mixing head, the two components should be degassed before processing. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection.

### Inhibition of Cure

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

### Curing Conditions

The data offers a guide to the rate of cure at various temperatures, mixing of the components at temperatures between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.

### Health and Safety

Safety Data Sheets available on request.

### Packaging

ACC Encapsulants are available in a variety packaging including bulk containers. Please contact our sales department for more information.

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### Property

#### Uncured product

Property	Test Method	Value
Appearance		Clear Liquid
Colour A Part		Transparent
Colour B Part		Transparent
Cure Type		Addition
Max Cure Mins @ 100 °C		60 mins
Max Cure Hrs @ 25 °C		20 hrs
Mix Ratio		10:1
Pot Life mins		240 mins
Rheology		Viscous Liquid
Self Bonding		No
Viscosity A-Part mPas	Brookfield	5000 mPas
Viscosity B-Part mPas	Brookfield	1000 mPas
Viscosity Mixed mPas	Brookfield	4500 mPas

#### Cured product

CTE Linear ppm/°C		275 ppm/°C
CTE Volumetric ppm/°C		825 ppm/°C
Colour		Transparent
Duro Shore A	ASTM D 2240-95	40
Elongation %	ISO 37	100 %
Linear Shrinkage %		0.2 %
Max Working Temp +°C	AFS_1540B	204 °C
Min Working Temp - °C		-60 °C
SG	BS ISO 2781	1.02
Tensile MPa	ISO 37	4.8 MPa
<b>After 1 hour at 100°C</b>		
Thermal Conductivity W/mK		0.18 W/mK
UL 94V-0		No
<b>Storage</b>		
Max storage temperature °C		30 °C
Shelf life		24 mths
<b>Electrical properties</b>		
Dielectric Constant @ 1kHz	ASTM D-150	2.69
Dielectric Strength kV/mm	ASTM D-149	19.70 kV/mm
Dissipation Factor @ 1kHz	ASTM D-150	0.0006
Volume Resistivity ohms cm	ASTM D-257	1.7E+15 ohms cm

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