

# EPM-2410-1

## Low volatility silicone adhesive

### DESCRIPTION

- Two-part, white silicone system
- Designed for enhanced performance in extreme low and high temperatures
- Offers a high tear strength
- Convenient 1:1 mix ratio (Part A: Part B)

### APPLICATION

- For applications requiring low volatility
- To provide protection of electric components and assemblies against shock, vibration, moisture, dust, chemicals and other environmental hazards
- For use as an adhesive or encapsulant

### PROPERTIES

Typical Properties	Average Result	Standard	NT-TM
<b>Uncured:</b>			
Appearance	White	ASTM D2090	002
Viscosity, Part A	60,000 cP (60,000 mPas)	ASTM D1084, D2196	001
Viscosity, Part B	40,000 cP (40,000 mPas)	ASTM D1084, D2196	001
Work Time	30 minutes	-	008
Tack-Free Time	4 hours	ASTM C679	005
<b>Cured: 15 minutes at 150°C (302°F)</b>			
Durometer, Type A	30	ASTM D2240	006
Tensile Strength	700 psi (4.8 MPa)	ASTM D412	007
Elongation	350%	ASTM D412	007
Lap Shear Strength (primed w/ CF1-135)	400 psi (2.8 MPa)	ASTM D1002	010
Coefficient of Linear Thermal Expansion			
-150°C to -115°C	60 (µm/(m°C))	ASTM D3386	-
-95°C to 250°C	445 (µm/(m°C))	ASTM D3386	-
Volatile Content (1 hour at 275°C)	0.5%	ASTM D2288	004

Typical Properties	Average Result	Standard	NT-TM
Thermal Conductivity	0.230 W/(mK) (55 x 10 <sup>-5</sup> cal/(cm·sec·°C))	ASTM E1530	101
Ionic Content, Cl	< 15 ppm	-	-
Ionic Content, K	< 1 ppm	-	-
Ionic Content, Na	< 2 ppm	-	-

The test data shown for this material is the average value for typical properties. All of these properties may not be tested on a lot to lot basis and cannot be used to draft specifications. Please [contact](#) NuSil® for assistance and recommendations in establishing limits for product specifications.

## INSTRUCTIONS FOR USE

### Mixing

Thoroughly stir Part A prior to weighing for Part B addition as the product separates. Mix Part A and Part B in a 10:1 mix ratio by weight, just prior to use.

### Vacuum Deaeration

Remove air entrapped during mixing by common vacuum deaeration procedure, observing all safety precautions. Slowly apply full vacuum to a container rated for use and at least four times the volume of material being deaerated. Hold vacuum until bulk deaeration is complete.

Note: Some bonding applications may require the use of a primer. NuSil's CF1-135 is recommended.

### Substrate Considerations

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 solvent or volatilizing the contaminant by heating.

### Adjustable Cure Schedule

Product cures at a wide range of temperatures and cure times to accommodate different production needs. [Contact](#) NuSil for details.

## ROHS AND REACH COMPLIANCE

### Packaging

50 mL SxS Kit (0.054 kg)  
500 Gram Kit (0.5 kg)

### Warranty

12 Months

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

## SPECIFICATIONS

Do not use the typical properties shown in this technical profile as a basis for preparing specifications. Please [contact](#) NuSil for assistance and recommendations in establishing limits for product specifications.

## WARRANTY INFORMATION

The warranty period provided by NuSil Technology LLC is 12 months from the date of shipment when stored below 40°C in original unopened containers. Unless NuSil provides a specific written warranty of fitness for a particular use, NuSil's sole warranty is that the product will meet NuSil's then current specification. NuSil 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'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 expressly disclaims any liability for incidental or consequential damages.

## WARNINGS ABOUT PRODUCT SAFETY

NuSil 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 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 makes no warranty concerning fitness for any use or purpose. NuSil has completed no testing to establish safety of use in any medical application.

NuSil has tested this material only to determine if the product meets the applicable specifications. (Please [contact](#) NuSil for assistance and recommendations when establishing specifications.) When considering the use of NuSil products in a particular application, review the latest Material Safety Data Sheet and [contact](#) NuSil 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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