

# EPM-2420

## Low volatility general purpose silicone adhesive

### DESCRIPTION

- Two-part, clear silicone system
- Incorporates an adhesion promoter
- Low viscosity
- 1:1 Mix Ratio (Part A: Part B)

### APPLICATION

- To provide protection of electric components and assemblies against shock, vibration, moisture, dust, chemicals and other environmental hazards
- Ideal for applications where clarity and low viscosity are important
- For applications requiring low volatility
- Use to adhere covers onto housings or for any application where grooves and other configurations require a material that self levels

### PROPERTIES

Typical Properties	Average Result	Standard	NT-TM
<b>Uncured:</b>			
Appearance*	Transparent	ASTM D2090	002
Viscosity, Mixed*	2,600 cP (2,600 mPas)	ASTM D1084, D2196	001
<b>Cured: 1 hour at 65°C (149°F)</b>			
Specific Gravity*	1.01	ASTM D792	003
Durometer, Type A*	30	ASTM D2240	006
Tensile Strength*	425 psi (2.9 MPa)	ASTM D412	007
Elongation*	150%	ASTM D412	007
Volatile Content (1 hour at 275°C)	0.85%	ASTM D2288	004
Ionic Content, Cl	< 2 ppm	-	-
Ionic Content, K	< 1 ppm	-	-
Ionic Content, Na	< 8 ppm	-	-

\*Properties tested on a lot-to-lot basis. 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.

## INSTRUCTIONS FOR USE

### Mixing

Thoroughly mix in a convenient 1:1 (Part A: Part B) mix ratio by weight 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 Technology's CF1-135 is recommended.

### Substrate Considerations

Cures in contact with most materials common to 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 a wide range of cure times and temperatures to accommodate different production needs. [Contact](#) NuSil Technology for details.

## 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

### Packaging

50 Gram Kit  
50 mL SxS Kit  
100 Gram Kit  
400 mL SxS Kit  
500 Gram Kit

### Warranty

12 Months

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## 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 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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