MED-4011

Low consistency silicone elastomer

DESCRIPTION
— Two-part, translucent gray, pourable silicone system
— Cures with heat via addition-cure chemistry
— 10:1 Mix Ratio (Part A: Part B)

NuSil™ MED-4011 shall not be considered for use in human implantation for a period of greater than 29 days.

APPLICATION
— For use in potting, encapsulating, coating, and injection or transfer molding applications

PROPERTIES

<table>
<thead>
<tr>
<th>Typical Properties</th>
<th>Average Result</th>
<th>Standard</th>
<th>NT-TM</th>
</tr>
</thead>
<tbody>
<tr>
<td>Uncured:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Appearance</td>
<td>Translucent</td>
<td>ASTM D2090</td>
<td>002</td>
</tr>
<tr>
<td>Viscosity, Part A</td>
<td>105,000 cP (105,000 mPas)</td>
<td>ASTM D1084, D2196</td>
<td>001</td>
</tr>
<tr>
<td>Viscosity, Part B</td>
<td>1,500 cP (1,500 mPas)</td>
<td>ASTM D1084, D2196</td>
<td>001</td>
</tr>
</tbody>
</table>

Cured: 3 minutes at 150°C (302°F)
Post-Cured: 1 hour at 150°C (302°F). Stabilize for 3 hours at ambient temperature and humidity

<table>
<thead>
<tr>
<th></th>
<th>Average Result</th>
<th>Standard</th>
<th>NT-TM</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specific Gravity</td>
<td>1.09</td>
<td>ASTM D792</td>
<td>003</td>
</tr>
<tr>
<td>Durometer, Type A</td>
<td>27</td>
<td>ASTM D2240</td>
<td>006</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>670 psi (4.6 MPa)</td>
<td>ASTM D412</td>
<td>007</td>
</tr>
<tr>
<td>Elongation</td>
<td>530 %</td>
<td>ASTM D412</td>
<td>007</td>
</tr>
<tr>
<td>Tissue Culture (Cytotoxicity Testing)</td>
<td>Pass</td>
<td>USP &lt;87&gt; ISO 10993-5</td>
<td>061</td>
</tr>
<tr>
<td>Elemental Analysis of Trace Metals</td>
<td>Pass</td>
<td>ASTM E305</td>
<td>131</td>
</tr>
</tbody>
</table>

The above properties are tested on a lot-to-lot basis. Do not use as a basis for preparing specifications. Please contact NuSil Technology for assistance and recommendations in establishing particular specifications.
INSTRUCTIONS FOR USE

Mixing
Combine Part A and Part B in a 10:1 mix ratio prior to use. Airless mixing, metering or dispensing equipment is recommended for production operations. If mixing by hand, take care to minimize air entrapment.

Vacuum Deaeration
Remove air entrapped during mixing by common vacuum deaeration procedure, observing all applicable safety precautions. Slowly apply full vacuum to a suitable container of at least four times the volume of material being deaired. Hold vacuum until bulk deaeration is complete.

Cure Inhibition
Curing may be inhibited by traces of amines, sulfur, nitrogen oxide, organotin compounds, and carbon monoxide. Because organic rubbers often contain these substances, they should not come in contact with the uncured elastomer. Catalyst residues from silicone RTV elastomers and peroxide-cured silicone elastomers may also inhibit the cure.

Note: Some bonding applications may require the use of a primer. NuSil Technology’s MED1-161 is suggested. For more information on primer selection, visit www.nusil.com and review Choosing a Silicone Primer/Adhesive System.

FDA MASTER FILE
A Master File for MED-4011 has been filed with the U.S. Food and Drug Administration. Customers interested in authorization to reference the Master File must contact NuSil Technology.

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.

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