

MED-6615

Addition cure silicone dispersion

DESCRIPTION

- Two-part low viscosity silicone adhesive dispersed in heptane
- Cures via addition-cure chemistry
- 1:1 Mix Ratio (Part A: Part B)

APPLICATION

- Suitable for dip casting and heat-curing of thin elastomeric films
- Low viscosity makes dispersions ideal for use as sprayable coatings
- Useful as a solvent-based adhesive

NuSil™ MED-6615 may be considered for use in human implantation for a period of greater than 29 days.

PROPERTIES

Typical Properties	Average Result	Standard	NT-TM
Uncured:			
Appearance	Translucent	ASTM D2090	002
Non-Volatile Content, Part A	33%	ASTM D2288	004
Non-Volatile Content, Part B	31%	ASTM D2288	004
Viscosity, Part A	39 cP (39 mPas)	ASTM D1084, D2196	001
Viscosity, Part B	93 cP (93 mPas)	ASTM D1084, D2196	001
Cured: 30 minutes minimum at ambient temperature and humidity, 45 minutes at 75°C (167°F), and 15 minutes at 150°C (302°F)			
Durometer, Type 00	72	ASTM D2240	006
Tensile Strength	1060 psi (7.3 MPa)	ASTM D412	007
Elongation	750%	ASTM D412	007
Tear Strength	120 ppi (21.1 kN/m)	ASTM D624	009
Stress at 100% Strain	65 psi (0.45 MPa)	ASTM D412, D882	007
Tissue Culture (Cytotoxicity Testing)	Pass	USP <87> ISO 10993-5	061

Typical Properties	Average Result	Standard	NT-TM
Elemental Analysis of Trace Metals	Pass	ASTM E305	131

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

For two-part, platinum catalyzed dispersions, mixing Part A into Part B (instead of Part B into Part A) is important especially when using a dispersion with high solids content. Thoroughly stir individual components prior to addition to ensure homogeneity. Mix in a 1:1 ratio by weight. Do not use wooden spatulas to mix and avoid the use of latex gloves. Exercise care to prevent solvent loss during deairing. Accomplish additional dilution for thin film applications by adding appropriate solvent. Mixer design/size/type, blade/propeller type, shear/RPM levels, and heat generated during mixing, are important parameters and should be addressed in order to have an adequately mixed dispersion.

Warning: Consult the MSDS for MED-6615 prior to use, as its solvent carrier is hazardous.

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 de-aired. Hold vacuum until bulk deaeration is complete.

Substrate Considerations

Cures in contact with most materials common to biomedical assemblies. Exceptions include: sulfur-cured organic rubbers, latex, chlorinated rubbers, some RTV silicones and unreacted residues of some curing agents.

Coating & Use

Dispersions are more commonly used in dip molding processes, but can also be sprayed or cast. Make sure to apply under a fume hood or in a well ventilated environment. Care should be taken before placing coated mandrels or parts in oven due to the presence of solvent. Reference cure schedule for devolatilization times. For further information, please see NuSil's [A Guide to Silicone Dispersions – Strategies for Processing and Troubleshooting](#).

Note: Some bonding applications may require the use of a primer. NuSil Technology' MED1-161 is recommended. For more

Packaging

2 Pint Kit (800 g)

Warranty

12 Months

information on primer selection, visit www.nusil.com and review [Choosing a Silicone Primer/Adhesive System](#).

Storage

Most dispersions are stored prior to application. It is important to note that NuSil recommends keeping the dispersion in its original container when possible, tightly sealed and stored below 40° C. Care should be taken to prevent solvent evaporation and contamination during long or short term storage.

FDA MASTER FILE

A Master File for MED-6615 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.

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

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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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