

## DESCRIPTION

The PERMACOL RTV 615 A/B is a silicone casting resin, which can be used for casting electrical switches and components.

This casting resin cures at room temperature, so full cure takes place at 20°C.

This product is suitable for different colours. The standard is crystal clear and can also be made in white and red.

Technical details	
Mixing ratio	A : B = 100 : 10 (weight)
Viscosity A-component	4.300 mPa.s (D=30/s 23°C)
Viscosity B-component	800 mPa.s (D=30/s 23°C)
Application temperature	+15°C
Pot life	4 hrs at 25°C
Curing time	6-7 days at 25°C
	4 hrs at 65°C
	1 hrs at 100°C
	45 min at 125°C
	15 min at 150°C
Colour mixture	Crystal clear
	White
	Red
Hardness	44 shore A
Temperature resistance	-60°C up to +204°C
Density A-component	1.02 g/cm <sup>3</sup>
Density B-component	0.99 g/cm <sup>3</sup>
Elongation at break	160%
Volume resistance	3.2×10 <sup>15</sup> Ω/cm
Thermal conductivity	0.19 W/m.K

## BENEFITS

- Crystal clear
- Multiple colours possible
- Solvent free
- Very low shrinkage
- Following FDA regulation 21CFR 177.2600: Rubber articles intended for repeated use

## USAGE INSTRUCTIONS

Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Weigh the components according to the mixing ratio and mix until a homogeneous colour is reached.

During the mixing and pouring of the resin, bubbles may enter the product. These can be removed by mixing under reduced pressure or with a heat gun after pouring. Make sure that the heat gun is only used on the bubbles, not to heat the product.

## CLEANING

Uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK. Cured adhesives must be removed mechanically.

## STORAGE

Store in its original packaging frost free and dry. See packaging for the expiration date. See packaging for expiration date. Shelf life: 6 months.

## SAFETY

Use protective gloves to avoid direct contact with the skin. Check the Material Safety Data Sheet for specific safety information.

## PACKAGING

The PERMACOL RTV 615 series are available in different kinds of cartridges.

## Legal Disclaimer

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