

NuSil Technology

1050 Cindy Lane • Carpinteria, CA 93013
 805/684-8780 • 805/566-9905 Fax
 www.nusil.com

An ISO 9001 Certified Company

MED-1137

Adhesive Silicone

Product Profile

Description

- One-part, low slump, solvent-free translucent silicone
- Cures at room temperature

Applications

- For bonding silicone elastomers to each other and some synthetics or metals

Typical Properties	Result	Metric Conv.	ASTM	NT-TM
Uncured:				
Appearance	Translucent	-	D2090	002
Extrusion Rate*	180 g/min	-	C603	033
Flow Rate**	.75 inch	19.1 mm	D2202	019
Tack-Free Time	8 minutes	-	C679	005
Cured: 72 hours @ ambient temp. and humidity				
Specific Gravity	1.07	-	D792	003
Durometer, Type A	25	-	D2240	006
Tensile Strength	650 psi	4.5 MPa	D412, D882	007
Elongation	560%	-	D412, D882	007
Stress @ 200% Strain	145 psi	1.0 MPa	D412, D882	007

*Performed using a 1/8 inches nozzle and 90 psi air pressure

**0.375 inches (9.525 mm) plunge, 5 minutes

Instructions for Use

Apply MED-1137, supplied in cartridges, with the use of an appropriate caulking gun. Do not store alcohols near the work site as traces of alcohol inhibit the adhesive's catalytic system.

Surface Preparation

Thoroughly clean surfaces being bonded or built-up with silicone adhesive with a non-oily cleaner or mild soap to remove possible surface contaminants. Do not use synthetic detergents or oil-based soaps, as they may be absorbed and subsequently leach out. Rinse copiously with hot water and follow with a thorough rinse using distilled water. Use compatible degreasers to clean metal surfaces.

Bonding Applications

Spread a layer of silicone adhesive on one of the surfaces. Squeeze both surfaces being bonded together. Apply sufficient pressure to ensure full contact, without forcing the silicone adhesive from between the pieces.

Curing Time

Curing or vulcanization time depends upon the thickness of the silicone adhesive layer, relative humidity, and accessibility of atmospheric moisture to the curing adhesive. For sections of typical thickness, a relative humidity level between 20-60% is recommended to cure the adhesive at room temperature. Dry heat will not accelerate the cure and should not be used for at least the first 72 hours.

Generally, the adhesive forms a thin, tack-free outer skin for thick section films within a few minutes after application. Complete any shaping of the uncured adhesive before this skin forms using a spatula, which works best if kept wet with distilled water (sterile, if required). A piece of ice also works well as a shaping tool.

Packaging

- 8 Gram Tube
- 2 Ounce Tube (59 mL)
- 5 Ounce Tube (148 mL)
- 6 Ounce Tube (177 mL)
- 20 Ounce Tube (591 mL)

Warranty

Because MED-1137 cures upon exposure to moisture vapor, the tube must be kept tightly closed when not in use. A plug of cured material may form in the tip of the tube. If a plug forms, remove or dispense it from the tube before using.

Non-sterile Packaged Units

The acidic nature of MED-1137 provides a natural bactericidal effect. While a MED-1137 container may be relatively free of microorganisms, it cannot be considered sterile unless subjected to a validated sterilization process. MED-1137 is not intended to be sterilized in the tube, as the white polyethylene cap on the tube will not withstand heat-sterilization temperatures. When the adhesive is fully cured, it can withstand sterilization with ethylene oxide, dry heat, or steam autoclaving. The size and shape of fabricated articles must be considered when establishing the conditions of sterilization. Larger quantities and larger parts may require longer periods of heating and may retain ethylene oxide longer than small parts. It is the user's responsibility to determine the outgassing time required for a particular application if using ethylene oxide sterilization methods.

Caution

Do not use MED-1137 in the uncured state to repair or encapsulate living tissue in the body because approximately 4.5% acetic acid (vinegar-like odor) evolves in vapor form during the cure process. Avoid contact with eyes and skin, as uncured adhesive irritates. Take appropriate precautions if wearing contact lens. In case of contact, flush eyes with water, use a dry towel to remove from skin and contact a physician. Keep out of the reach of children.

FDA Master Access File

A Master Access File for MED-1137 will be filed with the U.S. Food and Drug Administration. Customers interested in authorization to reference the Master Access File must contact NuSil Technology.

Warnings About Product Safety

NuSil Technology believes the information and the data contained herein are accurate and reliable. However, the user is responsible to determine the material's suitability and safety of use. NuSil Technology 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 Technology makes no warranty concerning fitness for any use or purpose. NuSil Technology has completed no testing to establish safety of use in any medical application.

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, obtain available product safety information and take the necessary steps to ensure safety of use.

Specifications

Do not use the typical properties shown in this technical profile as a basis for preparing specifications. Please contact NuSil Technology for assistance and recommendations in establishing particular specifications.

Patent Warning

NuSil Technology disclaims any expressed or implied warranty against the infringement of any patent. NuSil Technology does not warrant the use or sale of the products described herein will not infringe the claims of any United States' or other country's patents covering the product itself, its use in combination with other products or its use in the operation of any process.

Warranty Information

NuSil Technology's warranty period 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 any other expressed or implied warranty, including 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.