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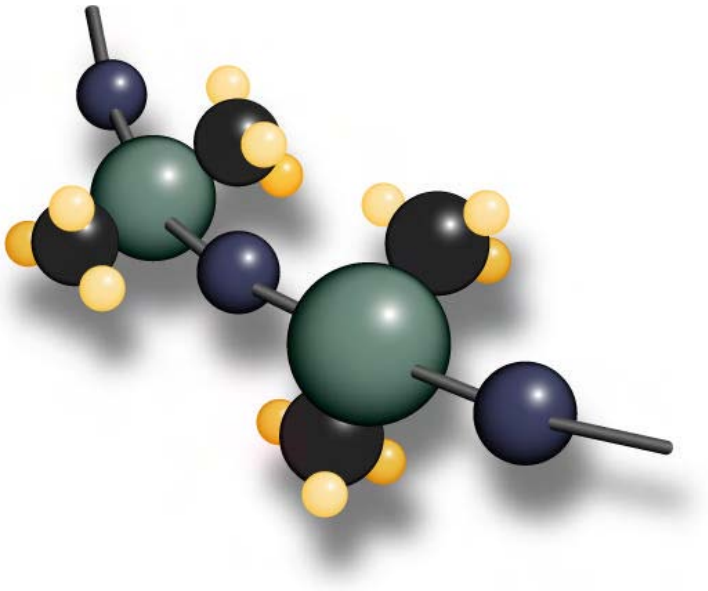

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An ISO 9001 Certified Company

*Product Profile*

# R-1008

## Silicone Coating / Marking Ink

## Description:

NuSil Technology R-1008 coating / marking ink includes a family of one-part, flowable silicone elastomer dispersions which cure at room temperature when exposed to atmospheric moisture. The following color designations are available:

| | |
|---|---|
| R-1008-1 | White |
| R-1008-2 | Black |
| R-1008-3 | Red |
| R-1008-4 | Orange |
| R-1008-5 | Yellow |
| R-1008-6 | Green |
| R-1008-7 | Blue |
| R-1008-8 | Violet |

R-1008 has material characteristics that include a non-corrosive cure system, excellent adhesion and is available in sprayable form.

## Applications:

This product is used as a marking ink for silicone rubber parts and other components where the coating must maintain long term stability.

## Instructions for Use:

SHAKE WELL BEFORE USING. Conventional paint spray equipment can be used to apply R-1008 as well as rollers or brushes. Viscosity adjustment must be made to match the appropriate application methods. For specialized applications, multiple coats may be required. Care should be taken to insure that under layers have not completely cured before subsequent coatings are applied.

## Storage:

This material cures in the presence of atmospheric moisture. It is recommended that an inert gas, such as Argon or Nitrogen, be used to blanket the product before securely re-closing the container.

## Typical Cure Schedule:

At 25°C (77°F) and 50% R.H. R-100 has a tack free time of 60 minutes, with full cure achieved in seven (7) days. Thick sections may require extended cure times and adequate time should be allocated for complete cure.

## Typical Properties as Supplied:

| | R-1008 |
|---|---|
| Chemical Classification | MQ |
| Color | Varies |
| Viscosity, cps @ 25°C (77°F) | 1000 |
| Solids, percent | 60 |
| Cure Time, 50% R.H. @25°C | |
| Tack Free, minutes | 60 |
| Full Cure, days | 7 |
| Solvent Type | Xylene |

## Typical Properties:

Cured 7 days @ 25°C, 50% R.H.

| | R-1008 |
|---|---|
| Durometer, Type A | 30 |

| | |
|---|---|
| Tensile Strength, psi / MPa | 300 / 2.07 |
| Elongation, % | 200 |
| Operating Temperature | -65°C - 260°C |

## Solvent Addition:

As supplied, NuSil Technology R-1008 is dispersed in xylene. The viscosity of R-1008 may be lowered by the addition of compatible moisture free solvents. Among these solvents are xylene, toluene, hexane and VM&P naphtha. Mixing should be carried out without introducing moisture from the air into the coating. Proper mixture may be accomplished by agitation in a closed container on a commercial paint shaker.

NOTE: A PRIMER MAY BE REQUIRED IN SOME BONDING APPLICATIONS. NUSIL TECHNOLOGY SP-120 PRIMER IS RECOMMENDED.

## Packaging:

One Pint Container
One Gallon Container
Five Gallon Container

## Warnings About Product Safety:

NuSil Technology believes that the information and data contained herein is accurate and reliable; however, it is the user's responsibility to determine suitability and safety of use for these materials. NuSil Technology can not know the specific requirements of each application and hereby makes the user aware that is has not tested or determined that these materials are suitable or safe for any application. It is the user's responsibility 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. There has been no testing done by NuSil Technology 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, you should review the latest Material Safety Data Sheets and contact NuSil Technology for any questions about product safety information you may have.

No chemical should be used in a food, drug, cosmetic, or medical application or process until you have determined the safety and legality of the use. It is the responsibility of the user 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, you should obtain available product safety information and take the necessary steps to ensure safety of use.

## Specifications:

The typical properties shown in this technical profile should not be used as a basis for preparing specifications. Please contact NuSil Technology for assistance and recommendations in establishing particular specifications.

## Patent Warning:

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## Warranty Information:

NuSil Technology's warranty period is 6 months from date of shipment when stored below 40°C in original unopened containers. Unless NuSil Technology provides you with 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 express or implied warranty, including warranties of merchantability and of fitness for use. Your 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, and NuSil Technology expressly disclaims any liability for incidental or consequential damages.