



APTEK LABORATORIES, INC.

ISO 9001 / AS9100 Certified

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TECHNICAL DATA & INFORMATION

APTEK® 2725-A/B

- Low stress Silicone Adhesive
- -110°C to 260°C operating range
- 2+ hour work life

PRODUCT DESCRIPTION

APTEK 2725-A/B is a gray, two component, soft, thixotropic, electrically insulative, space-grade, silicone adhesive displaying excellent low temperature flexibility and unusually high physical strength properties.

APTEK 2725-A/B is a 100% solids system has been manufactured with highly pure resins to minimize the occurrence of ionic contamination without outgassing during cure or service.

KEY FEATURES AND BENEFITS

- Product also available with 3mil spacer beads – designated as APTEK 2725/.003-A/B; different bondline spacers available upon request
- Long work life > 2 hours for large area applications
- Flexible/low modulus over wide temperature range to absorb stress build-up during thermal cycling
- Convenient 1/1 PBW or PBV mix ratio for easy handling-ideal for cartridge dispensers/repair kits
- Very good adhesion to various substrates when used in conjunction with Momentive SS4155 primer or Dow Corning's 1200 primer
- Two-part adhesive cures to a third color to indicate thorough and complete mixing

HANDLING INFORMATION

Mix ratio, PBW or PBV 100 (2725-A)/100 (2725-B)

Work Life, @ 25°C, 10 gm mass, hours >2

Handling Notes

- Silicone resins and primers are moisture sensitive; therefore, blanket containers of any unused portions with Argon or dry nitrogen prior to resealing.
- Prior to application of adhesive, clean part(s) to be bonded with a lint free cloth saturated with MEK or other suitable degreaser. Then wipe with isopropyl alcohol and allow to dry.

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- Priming Procedure:
 - Apply primer to clean, dry surface by brushing, wiping with a lint free cloth, or dipping. Spraying may sometimes produce erratic results and is not recommended.
 - Only apply a very thin coat of primer approximately 0.015mm (0.5mil). Excess primer will actually reduce adhesion.

NOTE: We have found that mixing fresh GE SS4155 primer with anhydrous isopropyl alcohol at 1/1 PBW or PBV has demonstrated improved adhesion.

 - Allow primer to dry for one hour at 25°C and 45-75% RH prior to application of fresh adhesive mixture. Longer drying times may be required when RH is below 40%.
 - Primer may be left to dry for up to 12 hours before application of the sealant without loss of bonding effects. However, the primed surface must be covered to prevent dirt or contaminant pick-up.

COMPATIBILITY:

Certain materials, chemicals, curing agents and plasticizers can inhibit the cure of silicone encapsulants and adhesives. Most notable of these include:

- Organotin and other organometallic compounds
- Silicone rubber containing organotin catalyst
- Sulfur, polysulfides, polysulfones or other sulfur-containing materials
- Amines, urethanes or amine-containing materials
- Unsaturated hydrocarbon plasticizers
- Some solder flux residues
- Latex rubber gloves

MIXING

Bulk handling

Weigh 100 parts of 2725 Part A into a clean, dry, glass, or metal, container and then add 100 parts of 2725 Part B. DO NOT MACHINE MIX-hand stir with glass or metal stirrer until complete and thorough blending is achieved, care should be taken to avoid any source of moisture contamination or air entrapment during mix.

Note: For best results and void-free bond line, vacuum mixture @ less than 10 mm Hg for 5 minutes minimum.

Dual cartridge/dispenser kits

- Hold cartridge firmly and upright.
- Twist protective cap counterclockwise 90° and pull protective cap off, exposing the adhesive ports.
- Insert flanged base of mixing tube over the exposed adhesive ports perpendicular to the cartridge bracket. Note this is keyed and will only fit in one orientation.
- Rotate turquoise collar clockwise 90°. Ensure that mix tip is securely attached.
- Hold gray handles of ratchet gun, with up arrow facing you.
- While lifting and holding up silver lever with thumb, pull back black plunger fully, until it stops.

- Insert the cartridge into slot in front of gun.
- Continue to apply pressure to trigger to dispense adhesive through the tube.
- Allow one inch of adhesive to extrude before applying to bonding surface.
- Cut back tip of tube to adjust bead size.
- If using a luer lock adaptor, cut off the first two segments from the mix tip. Thread the luer lock adaptor on the third segment. Attach appropriate compatible luer lock tip.
- To remove plunger from spent cartridge hold up silver lever and pull back black plunger fully; then cartridge can be removed from gun.

CURE SCHEDULE

1 hour @ 125°C

NOTES:

1. Above cure schedule is a guideline and user should determine proper cure depending on achievement of the application requirements.
2. Material will eventually cure at room temperature after at least 7 days. User to determine length of time needed at room temperature for sufficient cure. However, some of the strength values may be less than those listed for heat cure.

TYPICAL PROPERTIES

(values not to be used for specification purposes)

<u>CHARACTERISTICS</u>	<u>2725-A</u>	<u>2725-B</u>	<u>TEST METHOD</u>
Color	black	white	Visual
Specific Gravity	1.14	1.14	ASTM D-1475
Viscosity @ 25°C, cps	65,000	80,000	Visual
Flash point, °C	>150	>150	ASTM D-92
Shelf life @ 5°C or below in factory Sealed containers, months	3	3	
 <u>CURED PHYSICAL PROPERTIES *</u> * (Cured 1 hr @ 125°C)		<u>2725-A/B</u>	<u>TEST METHOD</u>
Hardness, Durometer A		28	ASTM D-2240
Tensile Strength @ 25°C 0.06" thickness, psi		500	ASTM D-638
Elongation, %		380	ASTM D-638
Young's Modulus @ 25°C, psi		90	ASTM D-638

Lap Shear Strength @ 25°C , 5 mil bondline thickness on primed aluminum panels, psi	475	ASTM D-1002
Glass transition Temp (T _g), °C	-110	ASTM E-831
Coefficient of thermal expansion, in/in/°C		
alpha 1	50 x 10 ⁻⁶	ASTM E-831
alpha 2	360 x 10 ⁻⁶	ASTM E-831
Outgassing @ 10 ⁻⁶ torr		
TML, %	0.55	ASTM E-595
CVCM, %	0.05	ASTM E-595

<u>CURED ELECTRICAL PROPERTIES</u>	<u>2725-A/B</u>	<u>TEST METHOD</u>
Volume resistivity, ohm-cm	7 x 10 ¹⁴	ASTM D-257
Dielectric strength, volts/mil, 0.250" thick	350	ASTM D-149

SAFETY AND FIRST AID

APTEK 2725-A is a silica-filled silicone resin blend that is safe to handle when used properly. It is judged to be low in toxicity and to be rated as a slight skin irritant. Avoid contact with skin and eyes and use in a well-ventilated area and avoid breathing vapors. In case of eye contact, flush with fresh clean water for at least 15 minutes; for skin contact, wash thoroughly with soap and water. If swallowed, drink at least one pint of water and call a physician. Refer to Material Safety Data Sheet for more details.

APTEK 2725-B is a silica-filled silicone resin blend, which is safe to handle when used properly. Avoid skin and eye contact and use in a well-ventilated, hooded area. In case of eye contact, flush profusely with fresh clean water and contact a physician. For skin contact, wash thoroughly with soap and water. If inhaled, move subject to fresh air and provide water to drink. If swallowed, dilute with at least one pint of water and contact physician immediately. Refer to Material Safety Data Sheet for more details.

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