



## Technical Data Sheet

### QSi 60

*Quantum Silicones' 60 Durometer Condensation Cure  
for Potting Applications*

#### Product Description

QSi 60 is a red, high-temperature, self-leveling, 2-component silicone material primarily intended for potting applications. This material is supplied as base and can be used with 2 different catalysts. This material can be mixed with 0.5% DBT Catalyst; however, the catalyst level can be increased or decreased to obtain the desired cure speed. To extend the work-life, adding as little as 0.1% of DBT Catalyst can be done without changing the final physical properties. Additionally, this material can be catalyzed with 10% Deep Section Catalyst for applications requiring a deeper cure. Once mixed, the material is self-leveling and will have a useful work-life of approximately 30-40 minutes. The material will be fully cured after 24-36 hours at room temperature. This material can also be vulcanized at elevated temperatures to increase the cure speed.

#### Key Features

- Self-Leveling
- Variable cure speed
- Excellent thermal stability

#### Typical Properties

UNCATALYZED PROPERTIES		
Color Base component	Red	
Viscosity Base component	55,000	
Specific Gravity Base component	1.49	
Percent Solids	100%	
CATALYST	DBT Catalyst	Deep Section Catalyst
Catalyst Color	Clear/Light yellow	Beige
Mix Ratio	100:0.5 by weight	10:1 by weight

<b>Catalyzed Properties</b>	
Appearance	Red
Rheology	Self-Leveling
Work Life, minutes	30
Durometer, 24 hour	60
Specific Gravity	1.48

### **Instructions for Use**

#### **Mixing**

Select a mixing container 4-5 times larger than the volume of QSil 60 silicone rubber compound to be used. Weigh out the QSil 60 base compound and add the appropriate amount of curing agent. 0.5% DBT Catalyst or 10% Deep Section Catalyst, **by weight**, will provide a work time or pot life of about one hour and a cure time of 24 hours. The pot life may be lengthened by using less DBT Catalyst (as little as 0.1% DBT Catalyst). With clean tools, thoroughly mix the QSil 60 base compound and the curing agent, scraping the sides and bottom of the container carefully to produce a homogeneous mixture.

#### **De-aeration**

Air trapped during the mixing should be removed to eliminate voids in the cured product. Degassing is usually complete about two minutes after frothing ceases. When using the QSil 60 for potting, a de-aeration step may be necessary after pouring to avoid capturing air in complex assemblies.

#### **Deep Section Cure**

If these QSil 60 silicone rubber compounds are to be used in deep sections at temperatures over 150C (302F), the cured product should be properly conditioned prior to service. Following room temperature cure of 1-3 days, a typical program would be eight hours at 50C intervals from 100C (212F) to the service temperature. Longer times at each temperature will be required for larger parts of very deep sections.

#### **Bonding**

If adhesion is an important application requirement, QSil 60 silicone rubber compounds require a primer to bond to non-silicone surfaces. Thoroughly clean the substrate with a non-oily solvent such as naphtha or methyl ethyl ketone (MEK) and let dry. Then apply a uniform thin film of a suitable silicone primer to air dry for one hour or more.

### **Storage and Shelf Life**

QSil 60 should be stored in the original unopened container at less 4C (40F). It will remain useful for a period of 12 months if stored under those conditions. QSil 60 will have a useful shelf life of 3 months when stored at less than 27C (80F).

### **Not for Product Specification**

The technical data listed herein is provided as a reference only and **is not** intended as sales specifications. For sales and technical assistance or for product recommendations, please call 1-800-852-3147.

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