



Technical Data Sheet

DOWSIL™ X3-6211 Encapsulant

FEATURES & BENEFITS

- One-part
- UV cure gel with no mixing required
- Suitable for very low temperatures

COMPOSITION

- No mixing required
- UV curable for extremely fast processing speeds
- Gel remains flexible in very low temperature applications

One-part, clear, UV cure, low temperature gel

APPLICATIONS

- DOWSIL™ X3-6211 Encapsulant is designed for very fast UV cure over relatively flat and less complicated circuit boards.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications.

Property	Unit	Result
Viscosity	cP	925
	mPa-sec	925
	Pa-sec	0.9
Gel Hardness	grams	105
Penetration	1/10 mm	50
UV Cure Time (to 90% Gel Hardness)	seconds	5 at > 3000 mJ/sq cm
Refractive Index		1.41
Dielectric Strength	volts/mil	425
	kV/mm	17
Shelf Life at 25°C	months	12

DESCRIPTION

This group of gels addresses special needs to enable your designs in a reliable and cost effective manner. This family include thixotropic gels that provide controlled flow, fluorogels with resistance to some solvents and fuels, controlled volatility gels for sensitive applications, and UV curing gels for very fast and low temperature cure. Gels are a special class of encapsulants that cure to an extremely soft material. Gels cure in place to form cushioning, self-healing, resilient materials. Cured gels retain much of the stress relief and self-healing qualities of a liquid while providing the dimensional stability of an elastomer which is increasingly needed for delicate components.

Gels have been used to isolate circuits from the harmful effects of moisture and other contaminants and provide electrical insulation for high voltages. Another use is providing stress relief to protect circuits and interconnections from thermal and mechanical stresses. Gels are usually applied in thick layers to totally encapsulate higher architectures. More recently, gels have found application in optoelectronics due to their stress relieving capability and high refractive index, as well as the stability of these properties over time.

MIXING AND DE-AIRING

Some gels are supplied in bladder packs that avoid direct air contact with the liquid gel components, allowing

use of air pressure over the pack in a pressure pot for dispensing. Do not apply air pressure directly to the liquid gel surface (without the bladder pack) as the gel can become supersaturated with air and bubbling can occur when the material is dispensed and cured. Use of bladder packs prevents bubbling, maintains cleanliness and avoids gel contamination. Gels can be dispensed manually or by using one of the available types of meter mix equipment. If possible, the potential for entrapment and incorporation of gas (typically air) should be considered during design of the part and selection of a process to dispense the gel. This is especially important with higher-viscosity and faster curing gels. Degassing at > 28 inches (10–20 mm) Hg vacuum may be necessary to ensure a void-free, protective layer.

USEFUL TEMPERATURE RANGES

For most uses, silicone elastomers should be operational over a temperature range of -45 to 200°C (-49 to 392°F) for long periods of time. However, at both the low and high temperature ends of the spectrum, behavior of the materials and performance in particular applications can become more complex and require additional considerations. For low-temperature performance, thermal cycling to conditions such as -55°C (-67°F) may be possible, but performance should be verified for your parts or assemblies. Factors that may influence performance are configuration and stress sensitivity of components, cooling rates and hold times, and prior temperature history. At the high-temperature end, the durability of the cured silicone elastomer is time and temperature dependent. As expected, the higher the temperature, the shorter the time the material will remain useable.

COMPATIBILITY

Certain materials, chemicals, curing agents and plasticizers can inhibit the

cure of addition cure adhesives. Most notable of these include: organotin and other organometallic compounds, silicone rubber containing organotin catalyst, sulfur, polysulfides, polysulfones or other sulfur containing materials, unsaturated hydrocarbon plasticizers, and some solder flux residues. If a substrate or material is questionable with respect to potentially causing inhibition of cure, it is recommended that a small scale compatibility test be run to ascertain suitability in a given application. The presence of liquid or uncured product at the interface between the questionable substrate and the cured gel indicates incompatibility and inhibition of cure.

REPAIRABILITY

In the manufacture of PCB system assemblies, salvage or rework of damaged or defective units is often required. Removal of Dow dielectric gels to allow necessary repairs can be assisted by using Dow OS fluids. Additional information regarding these products is available from Dow. Digestive stripping agents, such as SU100 Silicone Sealant/Adhesive from Silicones Unlimited, can also be used. In addition, if only one component needs to be replaced, a soldering iron may be applied directly through the gel to remove the component. After work has been completed, the repaired area should be cleaned with forced air or a brush, dried, and patched with additional silicone gel.

HANDLING PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT

WWW.CONSUMER.DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

USABLE LIFE AND STORAGE

Storage conditions and shelf life (“Use By” date) are indicated on the product label.

PACKAGING INFORMATION

In general, Dow dielectric gels are available in batch-matched kits containing both Part A and Part B components. Packages that are typically available include 210 mL dual cartridges, one gallon pails, five gallon pails and 55 gallon drums. Not all gels may be available in all packages, and some additional packages and package sizes may be available.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, www.consumer.dow.com or consult your local Dow representative.

**LIMITED WARRANTY
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The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

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TODAY?**

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To discuss how we could work together to meet your specific needs, go to www.consumer.dow.com for a contact close to your location. Dow has customer service teams, science and technology centers, application support teams, sales offices, and manufacturing sites around the globe.

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