

## Technical Data Sheet

### TufGel 336 High Strength Silicone Gel

#### PRODUCT DESCRIPTION

TufGel 336 is a tough, moderately cross-linked silicone elastomer, which has good room temperature cure adhesion to many substrates. This material also has room temperature primerless adhesion to a wide variety of substrates as compared to standard gels. Silicone gels are used to provide protection from vibration and thermal or mechanical shock. Silicone gels also provide excellent moisture protection.

#### KEY FEATURES

- One to one mix ratio
- Very fast cure
- High strength
- Room temperature primerless adhesion
- Good adhesion to many substrates including glass, aluminum and copper

#### TYPICAL PROPERTIES

UNCATALYZED		
TEST	TufGel 336 A	TufGel 336 B
Appearance	Clear Yellow	Black
Viscosity, #3 at 50 rpm	250 cps	500 cps
Specific Gravity	0.97	0.97

CATALYZED	
MIX RATIO 1:1	
TEST	RESULT
Gel Time at 25 °C *	5 – 8 minutes

\* Gel time is defined as the time required for the material to become a solid or a semi-solid.

CURED PROPERTIES	
Cure Profile	30 minutes at 70 °C 60 minutes at RT
Durometer, shore 00, 30 minutes at 70 °C	45 – 55
Sag Test, 10 minutes at RT	Pass
24 HR adhesion to digit board	Pass

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ADDITIONAL PROPERTIES	
Service Temperature Range	-55 °C – 204 °C
Adhesion	Silicone gels have a tacky surface and will form a mechanical bond to most substrates.
Electrical Properties	Excellent dielectric strength

### MIXING

TufGel 336 A and TufGel 336 B should be thoroughly mixed prior to catalyzing.

TufGel 336 A and B should be thoroughly mixed using a 1:1 ratio by weight or by volume. Once the components are mixed, the curing process begins. The gel time of the mixed material is listed above under typical properties. Fast curing gels (less than 30-minute gel time) should be dispensed utilizing automated mix and dispense equipment. Dispensing equipment is therefore recommended for this material.

### DE-AERATION

Air trapped during mixing should be removed to eliminate voids in the cured product. Vacuum de-airing may be necessary to completely remove all entrapped air bubbles. To ensure proper de-airing, subject the mixed material to 29 inches of mercury.

### STORAGE AND SHELF LIFE

This product is best when used within 24 months from date of manufacture. See product label and/or CoA for specific "Use By Date".

Product should be stored in its original, unopened container in an environment that does not exceed 38 °C (100 °F).

Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case, the properties required for the intended use should be checked for quality assurance reasons.

### DISCLAIMER

The technical data listed is provided for reference only and is not intended as product specifications. CHT USA's team accepts opportunities to either modify specifications in a current product or custom formulate a new one to meet your requirements. For sales and technical assistance, please contact us at: **(804) 271-9010** or **1-800-852-3147**.

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