



Technical Data Sheet

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QGel 321 Custom Silicone Gel

PRODUCT DESCRIPTION

QGel 321 is a tinted, fast curing, very soft, moderately cross-linked silicone polymer. 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
- Fast cure
- Tinted for ease of mix
- Soft but resilient

TYPICAL PROPERTIES

UNCATALYZED		
TEST	A	B
Appearance	Clear	Yellow
Viscosity, cps	900 cps	900 cps
Specific Gravity	0.97 g/cm ³	0.97g/cm ³

CATALYZED	
MIX RATIO 1:1	
TEST	RESULT
Gel Time, 25C	5-10 minutes

CURED PROPERTIES	
Cure Profile	5 minutes at 150C
	10 minutes at 100C
	60 minutes at 25C
Penetration, 30 minutes at 90C	9 - 15 mm

ADDITIONAL PROPERTIES	
Service Temperature Range	-55 to 200C
Adhesion	Silicone gels have a tacky surface and will form a mechanical bond to most substrates.
Electrical Properties	Excellent dielectric strength



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MIXING

QGel 321 should be thoroughly mixed using a 1:1 ratio by weight. 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. The use of mixing equipment is 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 insure proper de-airing, subject the mixed material to 29 inches of mercury.

STORAGE AND SHELF LIFE

If QGel 321A and QGel 321B are in an environment that does not exceed 25C (77F) then QSi will warranty the material for a period of one year from the date of shipment.

DISCLAIMER

The technical data listed is provided for reference only and is not intended as product specifications. QSi has the capability to customize products as requested. For sales and technical assistance please contact customer service at **(804) 271-9010** or **1-800-852-3147**.

Visit our website at www.quantumsilicones.com.