**Product Information**

**Automotive Solutions**

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**Silastic® FL 60-9201 Fluoro Liquid Silicone Rubber (F-LSR)**

60 durometer, pigmentable, 100 % Fluorosilicone Rubber designed for liquid injection molding

**FEATURES**

- Cures over a wide temperature range: 130°C to 200°C
- Fast cure platinum technology, no cure by-products
- Retains elasticity at low temperatures: TR10 -66°C, Tg -68°C
- Resists high temperatures
- 2-part with convenient 1:1 mix ratio
- Excellent resistance against automotive fuels and oils

**BENEFITS**

- Produces flashless parts
- Suitable for use in highly automated injection molding processes
- Allows intricate parts with close tolerances
- Enables short process cycle times
- Provides reliable sealing

**APPLICATIONS**

- Solvent and chemically resistant molded parts
- Intricate parts with close tolerances
- Gaskets and membranes for demanding static and dynamic sealing applications
- Extrusion onto wires, belts, fabrics, and other surfaces
- Thin, high-precision coatings

**TYPICAL PROPERTIES**

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

<table>
<thead>
<tr>
<th>Test</th>
<th>Property</th>
<th>Unit</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>As molded</strong>&lt;sup&gt;1&lt;/sup&gt;</td>
<td>Color Part A</td>
<td>Light yellow</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Color Part B</td>
<td>White</td>
<td></td>
</tr>
<tr>
<td>CTM 1094</td>
<td>Viscosity Part A (shear rate 10 s&lt;sup&gt;-1&lt;/sup&gt;)</td>
<td>Pa.s</td>
<td>850</td>
</tr>
<tr>
<td>CTM 1094</td>
<td>Viscosity Part B (shear rate 10 s&lt;sup&gt;-1&lt;/sup&gt;)</td>
<td>Pa.s</td>
<td>850</td>
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<tr>
<td>ASTM D792</td>
<td>Specific Gravity</td>
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<td>1.42</td>
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<tr>
<td>ASTM D2240</td>
<td>Hardness</td>
<td>Shore A</td>
<td>60</td>
</tr>
<tr>
<td>DIN 53504, S2</td>
<td>Tensile strength</td>
<td>MPa</td>
<td>6.5</td>
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<tr>
<td>DIN 53504, S2</td>
<td>Elongation at break</td>
<td>%</td>
<td>220</td>
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<tr>
<td>ASTM D624B</td>
<td>Tear Strength</td>
<td>kN/m</td>
<td>14</td>
</tr>
<tr>
<td>ASTM D385</td>
<td>Compression Set</td>
<td>%</td>
<td>21&lt;sup&gt;3&lt;/sup&gt;/28&lt;sup&gt;4&lt;/sup&gt;</td>
</tr>
<tr>
<td><strong>Post-cured</strong>&lt;sup&gt;2&lt;/sup&gt;</td>
<td>ASTM D2240</td>
<td>Hardness</td>
<td>Shore A</td>
</tr>
<tr>
<td></td>
<td>DIN 53504, S2</td>
<td>Tensile strength</td>
<td>MPa</td>
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</tr>
<tr>
<td></td>
<td>ASTM D385</td>
<td>Compression Set</td>
<td>%</td>
</tr>
<tr>
<td>ASTM D 471</td>
<td>Fluid resistance - volume swell</td>
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<tr>
<td></td>
<td>IRM 903, 168 hrs 150°C</td>
<td>%</td>
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<tr>
<td></td>
<td>Biodiesel, 168 hours 40°C</td>
<td>%</td>
<td>3.7</td>
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<tr>
<td></td>
<td>Reference Fuel C, 168 hours 23°C</td>
<td>%</td>
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<tr>
<td></td>
<td>FAM B, 168 hours 23°C</td>
<td>%</td>
<td>23.9</td>
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</tbody>
</table>

<sup>1</sup>Cure conditions, as molded 10 minutes at 120°C, Post-cured 4 hours at 200°C.
<sup>2</sup>Cure conditions, as molded 10 minutes at 120°C, Post-cured 4 hours at 200°C.
<sup>3</sup>Tested according to method B, type II (6mm) molded buttons, 22 hours 175°C.
<sup>4</sup>Tested according to method B, type II (6mm), plied disks, 22 hours 177°C.
<sup>5</sup>Injection molded slab, Post-cured 4 hours at 200°C.
DESCRIPTION
Silastic® FL 60-9201 Fluoro Liquid Silicone Rubber (F-LSR) is specifically designed for liquid injection molding. The product is supplied as a two component, soft fluorosilicone paste. It heat cures to a 60 durometer material. The cured rubber product is resistant to a wide variety of solvents and chemicals over a wide temperature range of -63 to +175°C (-82° to +347°F) under immersion conditions, and up to +225°C (+437°F) in dry heat.

HOW TO USE
Mixing
Silastic FL 60-9201 Fluoro Liquid Silicone Rubber is a two-component material supplied as parts A and B, which should be combined in a 1:1 ratio. Meter mix equipment which pumps, meters, and mixes the two components without the incorporation of air is strongly recommended for production.

Pot Life
After the A and B components are mixed, Silastic FL 60-9201 Fluoro Liquid Silicone Rubber will remain usable for at least 48 hours at room temperature.

Cure Rate
The cure time for Silastic FL 60-9201 Fluoro Liquid Silicone Rubber is a function of cure temperature and the thickness and dimensions of the part to be cured. The material cures within seconds when heated to 150°C (302°F). The cure time for a particular part is determined by the time required to heat the silicone material to this temperature. It can be optimized for the particular part dimensions to be molded.

Cure Inhibition
The cure mechanism of this product can be inhibited by amines, sulfur, tin complexes, and some peroxides. Care should be taken to avoid contamination that would lead to cure inhibition.

Clean-Up/Removal
Solvents such as Dow Corning® OS Fluids, mineral spirits, naphtha, toluene and xylene can be used to clean up uncured product. IPA can also be used.

HANDLING PRECAUTIONS
PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE ON THE DOW CORNING WEB SITE AT DOWCORNING.COM, OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.

USABLE LIFE AND STORAGE
When stored at or below 32°C (90°F) in the original unopened containers, this product has a usable life of 18 months from the date of production.

PACKAGING INFORMATION
This product is supplied in lot matched pail kits (2x 22kg).

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 Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our Web site, dowcorning.com or consult your local Dow Corning representative.

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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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