



## Technical Data Sheet

### DOWSIL™ SE 1880 Gel

DOWSIL™ SE 1880 Gel is a controlled volatility, low temperature gel

#### Features & Benefits

- One-part
- Heat cure
- Suitable for very low temperatures
- Controlled silicone volatility
- No mixing required
- Gel remains flexible in very low temperature applications
- Low viscosity allows good flow under components
- Reduced potential for silicone volatiles

#### Composition

- One-part, clear
- Polydimethylsiloxane gel

#### Typical Properties

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

Property	Unit	Result
Viscosity	cP	775
	mPa-sec	775
	Pa-sec	0.8
Specific Gravity (Un-Cured)		0.97
Penetration	1/10 mm	85
Heat Cure Time @ 150°C	minutes	30
Dielectric Strength	volts/mil	500
	kV/mm	20
Volume Resistivity	ohm*cm	6.41 E+14
Shelf Life @ 5°C	months	12

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DOWSIL™ SE 1880 Gel

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Description	<p>One-part, low temperature gels exhibit the stability of their properties at temperatures down to -80°C allowing PCB system assemblies to operate at these extreme temperatures. The soft nature of these gels can also assist in managing the CTE mismatch between components or materials during such low temperature excursions. This low temperature performance could assist in lowering field failures and warranty costs. 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.</p>
Mixing And De-Airing	<p>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 &gt; 28 inches (10–20 mm) Hg vacuum may be necessary to ensure a void-free, protective layer.</p>
Pot Life And Cure Rate	<p>Working time (or pot life) is the time required for the initial mixed viscosity to double at room temperature (RT). For one-part products the viscosity either increases at a much lower rate or does not change significantly at RT. Cure conditions are shown in the typical properties table. Cure is defined as the time required for a specific gel to reach 90% of its final properties. Gels will reach a no-flow state prior to full cure. Additional time should be allowed for heating the part to near oven temperature. Cure schedules should be verified in each new application.</p>
Useful Temperature Ranges	<p>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.</p>

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 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.
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.
Usable Life And Storage	Shelf life is indicated by the "Use Before" date found on the product label. Refer to the product label for storage temperature requirements. Special precautions must be taken to prevent moisture from contacting these materials. Containers should be kept tightly closed and head or air space minimized. Partially filled containers should be purged with dry air or other gases, such as nitrogen. Exposure to moisture could reduce adhesion and cause bubbles to form.
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 <a href="http://WWW.CONSUMER.DOW.COM">WWW.CONSUMER.DOW.COM</a> , OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.
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, <a href="http://www.consumer.dow.com">www.consumer.dow.com</a> or consult your local Dow representative.
Limitations	This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

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