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Set-Bond 839

Properties-Uncured:

Color, Visual
Mixed Viscosity, cps
Specific Gravity
Mix Ratio, by weight

Part A

CLEAR

PASTE

1.15

100:100 RIGID

100:200 SEMI- RIGID

100:300 FLEXIBLE

Part B

AMBER

Pot Life @25 °C , hours

1

Shelf Life @25 °C , months

12

Physical Properties-Cured:

Durometer (Shore D)

45-80 VARIES WITH RATIO

Flexural Strength, psi

5,700

Tensile Strength, psi

5,500

Tensile Elongation, %

2-10

Lap Shear Strength, psi

3000

Service Temperature °C

105

Electrical:

Dielectric Strength, volts/Mil

400

Dielectric Constant, 60hz

3.0

Dissipation Factor, 60hz

0.01

Volume Resistivity, ohm-cm

1.0 X 10¹⁴

Thermal Conductivity, btu-in/(ft²)(hr)(°F)

1.6

Mixing Instruction:

1. Pre-mix both components in their original containers to insure consistency.
2. Measure out equal parts(by weight) of both components.
3. Mix thoroughly, scraping the sides and bottom of container
4. Evacuate @29in. Hg for void-free casting.
5. Pour into unit or cavity.

Cure Schedule: 16 to 24 hours at Room Temperature, 4-6 hours at 55 °C, 30 minutes at 80 °C , or 15 minutes at 105 °C. Note ultimate properties attained after 4-6 days at room temperature (25 °C)

See back of Data Sheet for Warranty Information

Warranty

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