



Silicone & Epoxy Technology

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Set-Cast 1-135

Set-Cast 1-135 is a low viscosity easily machined, general purpose potting/casting material. Set-Cast 1-135 contains no fungus nutrient.

<u>Properties-Uncured:</u>	<u>135</u>	<u>90</u>	<u>111B</u>
Color, Visual	Black	Amber	Amber
Viscosity, cps	56,000	55	700
Specific Gravity	1.62	0.97	0.95
Mix Ratio, by weight	100	6 to 7	9 to 10
Mixed Viscosity, cps@250 °C		6,000	12,000
Pot Life @25 °C, hours		30 min	2.5
Shelf Life @25 °C, months		12	12

Physical Properties-Cured:

Durometer (Shore D)		88	88
Coefficient of Thermal Expansion, °C		40 x 10 ⁻⁶	40 x 10 ⁻⁶
Service Temperature, °C		105	155
Heat Distortion Point, °C		80	155
Tensile Strength. Psi		7,000	7,500
Tensile Elongation.%		2-3	2-3
Compressive Strength. psi		14,500	14,500
Flexural Strength, psi		13,000	13,000
Shrinkage on cure, in/in		0.002	0.002

Electrical:

Dielectric Strength, volts/Mil		440	440
Dielectric Constant, 1Khz		4.6	4.6
Dissipation Factor, 1Khz		0.02	0.02
Volume Resistivity, ohm-cm		1.0 10 ¹⁵	1.0 10 ¹⁴

Mixing Instruction: Weight out required amount of curing system. Mix thoroughly, scraping both sides and bottom of container. Evacuate mixture at 29in.Hg for 5-10 minutes if necessary. Apply to part.

Cure Schedule : Cure Set-Cure 90 16-24 hours, Set-Cure 111B 2hours @100 °C plus 1 hour @125 °C, Post cure 2 hours at 155 °C

See back of Data Sheet for Warranty Information

Warranty

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