



Silicone & Epoxy Technology

53 C Otis Street
West Babylon, NY 11704
Tel. 631-920-5079 Fax. 631-920-0503
E-mail SalesSET@optonline.net
www.SET-mfg.com

Set-Cast 1-140

Set-Cast 1-140 is an epoxy casting with high thermal conductivity with thermal expansion.

Properties-Uncured:

	1-140	Set-Cure 111
Color, Visual	Black	Amber
Mixed Viscosity, cps	120,000	700
Specific Gravity	2.30	0.95
Mix Ratio, by weight	100:4 TO 5	
Pot Life @25°C, hours	2.5	
Shelf Life @25°C, months	6	

Physical Properties-Cured:

Durometer (Shore D)	90
Tensile Strength, psi	8000
Tensile Elongation,%	<1.0
Coefficient of Thermal Expansion, °C	28 X 10 ⁻⁶
Thermal Conductivity, BTU-in(ft)(hr)(°F)	22
Service Temperature, °C	-55 to 155
Compressive Strength, psi	17,000
Flexural Strength, psi	14,000
Heat Distortion Point,C	155

Electrical:

Dielectric Strength, volts/Mil	500
Dielectric Constant, 60hz	6.5
Dissipation Factor, 60hz	0.02
Volume Resistivity, ohm-cm	5.0 X 10 ¹⁶

Mixing Instruction:

1. Pre-mix both components in their original containers to insure consistency.
2. Pre-heat both components to 100°F, to lower viscosity for ease of mixing.
3. Measure out equal parts(by weight) of both components.
4. Mix thoroughly, scraping the sides and bottom of container
5. Evacuate @29in. Hg for void-free casting.
6. Pour into unit or cavity.

Cure Schedule; 2 hours at 100°C plus 2 hours @125°C.

See back of Data Sheet for Warranty Information

Warranty

Silicone & Epoxy Technology accepts no liability, in negligence or otherwise, in this communication. Under no circumstances shall the company be liable for incidental, consequential or other damages from alleged negligence, breach of warranty, strict liability or any other theory, arising out of the use or handling of this product. The sole liability shall be the purchase price of the product. You should test the material to determine if the material is suitable, and/or claims are valid, in your particular circumstances. None of the possible or suggested uses of the materials in this communication are licensed under any Silicone & Epoxy Technology patent covering such use or a recommendation for use of such materials in the infringement of any patent.

Silicone & Epoxy Technology

Phone: 631-920-5079 Fax: 631-920-0503

Place Orders To: SalesSET@optonline.net

www.SET-mfg.com