



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 1-270 LV

Set-Cast 270LV is an aluminum filled epoxy formulation which is used for tooling in both small and large applications. It is also suitable for use in making molds that have excellent wear resistance. Set Cast 270 LV can withstand elevated temperatures as well.

<u>Properties-Uncured:</u>	Part A	Part B	
Color, Visual	Gray	Brown	
Mixed Viscosity, cps	7000	500	ASTMD 2393
Specific Gravity	1.63	1	
Mix Ratio, by weight	100:10		
Pot Life @25°C, minutes	240		
Shelf Life @25 °C, months	6		

<u>Physical Properties-Cured:</u>		
Durometer (Shore D)	80-85	ASTM D 2240
Tensile Strength, psi	9500	ASTMD 638
Tensile Elongation,%	1	ASTMD 638
Compressive Strength, psi	1500	ASTMD 695
Flexural Strength, psi	10,000	ASTMD 790
Service Temperature, °F	400	
Shrinkage (in/in C)	0.0005	

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 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: Set-cast 270 LV overnight at room temperature and post cure 2 hours at 200 °F or 1hour at 250 °F.

Note for service temperature above 300 °F, post cure 3-4 hours at 325-350 °F.

Note: after post cure or exposure to heat, Set-cast 270 LV turns to an olive drab color to indicate full cure.

See back of Data Sheet for Warranty Information

Warranty

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

Place Orders To: SalesSET@optonline.net

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