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Set-Cast 1-333 HTC

FLAME RETARDANT EPOXY CASTING COMPOUND

DESCRIPTION

Set-Cast 1-333 HTC is a 100% solids epoxy system. It is a filled, general-purpose epoxy encapsulant and casting compound. Polycast 133 has excellent moisture resistance and is machine dispensable and is flame retardant.

PROPERTIES – UNCURED

	Part A	Part B
Color , visual	Black	Amber
Viscosity, ASTM-D-2393 (c.p.s. @ 25° C)..	20,000	650-700
Specific Gravity	1.6	1.00
Mix Ratio (by weight)	100:9	
Mixed Viscosity, ASTM-D-2393 (@ 25° C)	10000	
Pot Life @ 25°C (100 grams)	60 minutes	
Shelf Life @ 70° F	12 months minimum	

PROPERTIES – CURED

Hardness, ASTM-D-2240(Durometer).....	Shore D 86
Tensile Strength, ASTM-D-638	11,500 psi
Tensile Elongation, ASTM-D-638	2.8 %
Flexural Strength, ASTM-D-790.....	17,500 psi
Coefficient of Thermal Expansion	48 x 10 ⁻⁶
Water Absorption.....	0.08%
Dielectric Strength, ASTM-D-149 (volts/mil)	415
Dielectric Constant, ASTM-D-150	4.4
Dissipation Factor, ASTM-D-150.....	0.02
Volume Resistivity, ASTM-D-257 (ohm-cm).....	1 x 10 ¹⁵
Thermal Conductivity, BTU's.....	10

MIXING INSTRUCTIONS

Pre-mix Part A separately. Then measure 100:9 parts by weight (A to B). Mix thoroughly scraping the sides and bottom of the container. Evacuate and then pour into mold or cavity.

CURE SCHEDULE

Room temperature cure @75°F with full properties after 24 hours.
To accelerate cure, allow 2 hours @ room temperature, then 2 hours @ 125°F.

See back of Data Sheet for Warranty Information

Warranty

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