



Silicone & Epoxy Technology

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Set-Cast 1000 M

Set-Cast 1000 M is a two-component, room cure epoxy design for potting applications filled with non-abrasive fillers Set-Cast 1000 M has a mix ratio of 1:1 by volume.

<u>Properties-Uncured:</u>	<u>Part A</u>	<u>Part B</u>
Color, Visual	Gray	Black
Mixed Viscosity, @25 °C cps	8,000	
Mixed Viscosity @80 °C	5000	
Specific Gravity	1.65	1.38
Mix Ratio, by weight	1:1	
Pot Life @25°C, mim, 100 grams mass	45-60	
Shelf Life @25 °C, months	6	

Physical Properties-Cured:

Durometer (Shore D)	65
Coefficient of Thermal Expansion, °C	50 X 10 ⁻⁶
Thermal Conductivity, BTU-in(ft2)(hr)(°F)	3.1
Service Temperature, °C	-40 to 155
Compressive Strength, psi	6700

Electrical:

Dielectric Strength, volts/Mil	400
Dielectric Constant, 1 khz	4.7
Dissipation Factor, 1 khz	0.02
Volume Resistivity, ohm-cm	1.0 X 10 ¹⁴

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 24 hours at room temperature or 2 hours at 50 °C

See back of Data Sheet for Warranty Information

Warranty

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