

## Set-Cast 13254 SP Blue Epoxy Encapsulant

**Set-Cast 13254** is a low viscosity epoxy system designed for encapsulation and embedment of components. It displays excellent electrical characteristics, and good adhesion to metals, glass, and most plastics. This system provides good thermal and mechanical stress relief. It is difficult to machine offering a high degree of security protection. **Set-Cast 13254** is 100% solids, has a very low odor, and is black in color, but other tints are available.

### TYPICAL PROPERTIES :

Viscosity, cps.	5,000 - 6,000
Specific Gravity	1.5
Tensile Strength, psi	7,500
Shore Hardness, D	80 - 85
Compressive Strength, psi	13,000
Flexural Strength, psi	13,000
Dielectric Strength, volts/mil	475
Volume Resistivity, ohm-cm	$5 \times 10^{16}$
Coefficient Thermal Expansion, °C	$9 \times 10^{-6}$
Thermal Conductivity, BTU/in / °F	5
Service Temperature, °F	250

### INSTRUCTIONS FOR USE :

Set-Cast 13254 should be gently stirred to a uniform consistency, prior to using. Weigh out the quantity of resin to be used, and add the correct amount of hardener by weight. Stir thoroughly. Working time will depend on the amount of material mixed. The ratio of Set-Cast 13254 resin to hardener is:

<u>Hardener</u> Type	<u>Ratio</u> PHR	<u>Work Time</u> 150 gram mass	<u>Cure Cycle</u> Time - Temperature
Set-cure 170	100:18	1/2 hr	24 Hr. @ Room Temp
# 112	100: 8	35 minutes	24 Hr, @ Room Temp
# 176	100:20	120 “	24 Hr. @ Room Temp
# 046	100:12	120 “	2 Hr @ Room Temp followed by 2 Hr. @ 75 °C

See back of Data Sheet for Warranty Information

## **Warranty**

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