S.E.T.
Silicone & Epoxy Technology

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Set-Gel SY5230

Epoxy 2-Component

Set-Gel SY5230 is formulated for electrical Encapsulation, Sensitive Electronics, Imbedments. **Set-Gel SY5230** features Low Viscosity, Thermal Shock Resistance, Low Stress, Room Temperature curing, and a convenient mix ratio.

Mixing and Curing (Uncured) @77 ºF:

Mix Ratio: A to B by weight	100:25	
Viscosity, cps	Part A	1200
	Part B	1200
	Mixed	1200
Specific Gravity	Part A	1.13
	Part B	1.00
Pot Life 100 Gram mass, minutes		60-90
Shelf Life factory sealed cans	minimum	1 year

Physical Properties (Cured) @77 ºF:

Color	Amber Clear
Durometer, Shore A	30-35
Tensile Strength (psi)	350
Tensile Elongation, %	160
Specific Gravity	1.10

Electrical Properties (Cured) @77 ºF:

Dielectric Strength, volts/mil	375	ASTM D149
Dielectric Constant, 1 KHz	4.3	ASTM D150
Volume Resistivity, ohm-cm	10^{14}	ASTM D257
Dissipation Factor, 1MHz	0.03	

Cure Schedule:
8-16 hours @77 ºF minimum cure
Full cure 3-7 days @77 ºF or 2 hours @ 175 ºF

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IMPORTANT-MFORMATION-.READ BEFORE USING PRODUCT

Directions for Use: Because of differences in density, *pigments and fillers, when present, may separate* from the liquid components during storage. To insure product homogeneity and maximum performance, check the containers for settling. Loosen any settled pigments from the bottom of the container and ***thoroughly mix contents prior to use***. Use a mixing stick or power mix at slow speed with a drill press and dispersion blade. *This product might crystallize* in its shipping container during storage, if it appears hard or has a granular consistency, or if it is normally clear but appears cloudy, warm it thoroughly at 120 ºF to reconstitute. Remix the product and allow it to cool back to room temperature before using.

Measuring: Carefully weigh Part A and Part B components with an accurate scale. If measuring volumetrically, use precise metering pumps, graduated/pre-marked containers or pre-measured kits. Place the correct proportions of Part A and Part B into a straight-sided container. Note: Altering the mix ratio from what is specified on the data sheet is not recommended. Cured properties could be adversely affected.

Mixing: Mix thoroughly with a flat-ended stick or a slow speed drill press with a dispersion blade. Scrape the sides and bottom occasionally to assure a thorough blend. Do not whip excessive air into the mixture. To guard against partway-cured sections, never apply material scraped from the original mixing container. For best results, transfer the mixture into a second container and stir it again before application. This will help insure consistent properties and maximum performance.

De-Airing:
Low viscosity resins will de-air naturally on their own. Some applications require a totally air-free product. If a vacuum pump and chamber are used, evacuate the Material for 5-15 minutes @ 28-29 inches of mercury. Allow sufficient space above the liquid for expansion; about four times the liquid volume. Resins that are slightly warmed are thinner and will de--air faster. Also, the use of an air-out additive will lower the surface tension and hasten air release. Caution: Warming a catalyzed mixture will shorten pot life and decrease gel time.

Do not use until MSDS has been read and understood.

Warranty

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