



Silicone & Epoxy Technology

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## Set-Cast 1-140

Set-Cast 1-140 is an epoxy casting with high thermal conductivity with thermal expansion.

### Properties-Uncured:

	1-140	Set-Cure 111
Color, Visual	Black	Amber
Mixed Viscosity, cps	120,000	700
Specific Gravity	2.30	0.95
Mix Ratio, by weight	100:4 TO 5	
Pot Life @25°C, hours	2.5	
Shelf Life @25°C, months	6	

### Physical Properties-Cured:

Durometer (Shore D)	90
Tensile Strength, psi	8000
Tensile Elongation,%	<1.0
Coefficient of Thermal Expansion, °C	28 X 10 <sup>-6</sup>
Thermal Conductivity, BTU-in(ft)(hr)(°F)	22
Service Temperature, °C	-55 to 155
Compressive Strength, psi	17,000
Flexural Strength, psi	14,000
Heat Distortion Point,C	155

### Electrical:

Dielectric Strength, volts/Mil	500
Dielectric Constant, 60hz	6.5
Dissipation Factor, 60hz	0.02
Volume Resistivity, ohm-cm	5.0 X 10 <sup>16</sup>

### 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 out equal parts(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; 2 hours at 100°C plus 2 hours @125°C.

**See back of Data Sheet for Warranty Information**

## **Warranty**

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