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Set-Cast 13254

Low Viscosity Filled Epoxy Compound

Set-Cast 13254 is a low viscosity, filled epoxy formulation which is used for encapsulation and embedment of electronic components. **Set-Cast 13254** has excellent electrical properties and exceptional adhesion to most substrates. **Set-Cast 13254** is 100% solids.

PROPERTIES - UNCURED:	**Part A**	**Part B (PC 67)**	
Color, Visual	Blue/Silver/Black	Brown	
Viscosity, cps.	6,000	900	ASTMD2393
Specific Gravity	1.50	1.0	
Mix Ratio (By Weight)		100:18	
Mixed Viscosity, cps.		4,500	ASTMD2393
Pot Life @ 72° F, min.		35	
Shelf Life @ 72° F, months		6	
PROPERTIES - CURED:			
PHYSICAL			
Hardness Durometer (Shore D)		81	ASTMD 2240
Tensile Strength, psi		8000	ASTMD 638
Compressive Strength, psi		13,500	ASTMD 695
Flexural Strength, psi		13,500	ASTMD 790
Coefficient of Thermal Expansion (cm/cm/°C)		9×10^{-6}	
Service Temperature		260°F	
Dielectric Strength, volts/mil		480	ASTMD 149
Volume Resistivity, ohm-cm		5×10^{16}	ASTMD 257
Thermal Conductivity, (BTU/in / ft²°F).....	5		

MIXING INSTRUCTIONS:

1. Premix Set-Cast 13254 in the original container prior to use to ensure any settled filler may be reincorporated. Warming Set-Cast 13254 to 100°F facilitates ease of use.
2. Weigh out the required amount of Set-Cast 13254 Part A and the requisite Part B.
3. Mix thoroughly, scraping both sides and bottom of container.
4. Evacuate mixture at 29 in. Hg for 5-10 minutes (if desired).
5. Pour into mold or cavity.

CURE SCHEDULE:

Overnight at Room temp. (75°F)

Warranty

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