

PRODUCT SPECIFICATIONS SHEET

CAT NO. **PRODUCT NAME** www.Action-Electronics.com - Phone: 800-563-9405

19-823 GC Potting Epoxy
19-824
19-824-2G

DESCRIPTION:

A two part unfilled electronic grade epoxy encapsulant designed for small to medium sized castings. It cures slowly at room temperature to a tough, rigid material. It has good wetting and adhesion to most surfaces and is free flowing to penetrate voids and gives good air release. It has very good resistance to water, acids and bases and most organic solvents. It was especially formulated to a 1:1 mix ratio.

Cure is normally achieved at room temperature within 24 hours. Cure time can be accelerated by the application of heat. Times and temperatures from 1 hour at 150° F to 10 minutes at 225° F are typical for small castings (less than 50 grams).

TYPICAL PROPERTIES:

All properties given are at 25°C unless otherwise noted.

Color	Black
Viscosity:	
Part A	12,000 cps
Part B	3,000 cps
Mixed	5,000 cps
Specific Gravity:	
Part A	1.16
Part B	1.02
Mixed	1.09
Pot Life	45 – 60 minutes
Mass	100 grams
Dielectric Constant	3.5*
Dielectric Strength	410 v/mil*
Volume Resistivity	8.3 x 10 ⁽¹⁴⁾ ohm-cm*
Temperature Range	-40 to 300°F
Hardness	80
Method	Shore-D

Linear Coefficient of Thermal Expansion	(x 10 (6))/C 62*
Thermal Conductivity	Btu* in/ft ² hr* F 1.8*

INSTRUCTIONS:

1. Clean and dry surfaces thoroughly.
2. Bring both components to room temperature prior to mixing. Mix 1 part of A to 1 part of B thoroughly.
3. Allow to cure undisturbed.
4. Clean up with a suitable organic solvent such as MEK, Acetone or a Chlorinated Solvent.

MIX RATIO:

1A:1B by weight or 1A:1B by volume.

*Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results.

Notes:

Values presented above are considered typical properties, not to be used for specification purposes.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). In extreme cases it may appear solid and cured. Fluctuating temperatures (within 35 to 120° F) aggravate this phenomena. Products can usually be restored by heating to 120 to 140° F with stirring. Storage at 75+/-15° F is optimum for most products.

COMMENTS:

Can be submerged in water but not recommended for continuous water immersion.

SHELF LIFE, CLOSED CONTAINERS:

12 months