



Silicone & Epoxy Technology

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Set-Cast 125

Set-Cast 125 is a low viscosity easily machined, general purpose potting/casting material. .

| <u>Properties-Uncured:</u> | <u>125</u> | <u>9</u> |
|-----------------------------|------------|----------|
| Color, Visual | Black | Amber |
| Viscosity, cps | 7500 | 55 |
| Specific Gravity | 1.55 | 0.97 |
| Mix Ratio, by weight | 100 | 6 to 7 |
| Mixed Viscosity, cps@250 °C | | 3000 |
| Pot Life @25 °C, hours | | 60 min |
| Shelf Life @25 °C, months | | 12 |

Physical Properties-Cured:

| | |
|--------------------------------------|-----------------------|
| Durometer (Shore D) | 80 |
| Coefficient of Thermal Expansion, °C | 48 x 10 ⁻⁶ |
| Service Temperature, °C | 105 |
| Heat Distortion Point, °C | 80 |
| Tensile Strength. Psi | 11,000 |
| Tensile Elongation.% | 2.0 |
| Compressive Strength. psi | 12,500 |
| Flexural Strength, psi | 14500 |
| Shrinkage on cure, in/in | 0.002 |

Electrical:

| | |
|--------------------------------|------------------------|
| Dielectric Strength, volts/Mil | 415 |
| Dielectric Constant, 1Khz | 4.2 |
| Dissipation Factor, 1Khz | 0.02 |
| Volume Resistivity, ohm-cm | 9.0 x 10 ¹⁴ |

Mixing Instructions: Weigh out required amount of curing system. Mix thoroughly, scraping both sides and bottom of container. Evacuate mixture at 29in.Hg for 5-10 minutes if necessary. Apply to part.

Cure Schedule : Cure Set-Cure 9 16-24 hours

See back of Data Sheet for Warranty Information

Warranty

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