# Set-Cast 1000M

Set-Cast 1000M is a two-component, room temperature cure epoxy designed for potting applications, filled with non-abrasive fillers. Set-Cast 1000M has a mix ratio of 1:1 by volume.

| Properties-Uncured: | Part A | Part B |
|---|---|---|
| Color, Visual | Neutral | Black |
| Viscosity, cps | 16,500 | 1,700 |
| Specific Gravity | 1.65 | 1.38 |
| Mix Ratio, by volume | 1:1 | |
| Mixed Viscosity, @25 $^{\circ}$C cps | 8,000 | |
| Mixed Viscosity @80 $^{\circ}$C | 5000 | |
| Pot Life @25$^{\circ}$C, min, 100 grams mass | 45-60 | |
| Shelf Life @25 $^{\circ}$C | 6 Months, Store in a Cool, Dry area, Rotate Weekly. | |

| Physical Properties-Cured: | |
|---|---|
| Durometer (Shore D) | 65 |
| Coefficient of Thermal Expansion, $^{\circ}$C | $50 \times 10^{-6}$ |
| Thermal Conductivity, BTU-in (ft2) (hr) ($^{\circ}$F) | 3.1 |
| Service Temperature, $^{\circ}$C | -40 to 155 |
| Compressive Strength, psi | 6700 |

| Electrical: | |
|---|---|
| Dielectric Strength, volts/Mil | 400 |
| Dielectric Constant, 1 kHz | 4.7 |
| Dissipation Factor, 1 kHz | 0.02 |
| Volume Resistivity, ohm-cm | $1.0 \times 10^{14}$ |

Mixing Instruction:

1. Pre-mix both components in their original containers to insure consistency.
2. Measure out equal parts (by weight) of both components.
3. Mix thoroughly, scraping the sides and bottom of container.
4. Evacuate @29in. Hg for void-free casting.
5. Pour into unit or cavity.

Cure Schedule 24 hours at room temperature or 2 hours at 50 $^{\circ}$C

# __Warranty__

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