



**“Our strength is in our formulations”**

**TECHNICAL BULLETIN:**

**XRD 1116 / XHD 1281**

**DESCRIPTION:** A FILLED, ROOM TEMPERATURE CURE, TWO COMPONENT EPOXY SYSTEM. THE PRODUCT IS SUITABLE FOR POTTING/ENCAPSULATING ELECTRICAL AND ELECTRONIC COMPONENTS. THE USE OF NON-ABRASIVE FILLERS AND THE CONVENIENT MIX RATIO MAKES IT SUITABLE FOR PROCESSING IN AUTOMATIC DISPENSE EQUIPMENT.

**SALES SPECIFICATION:**

**XRD 1116**

**XHD 1281**

COLOUR:	BLACK	NATURAL
VISCOSITY (cps) (NOTE 1):	12,000 – 24,000	2,500 – 5,000
SPECIFIC GRAVITY (gm/cm <sup>3</sup> ):	1.60 +/- 0.3 gm/cm <sup>3</sup>	1.58 +/- gm/cm <sup>3</sup>
SHELF LIFE:	12 MONTHS	12 MONTHS

**HANDLING:** (NOTES 1,2 & 5)

MIX RATIO BY WEIGHT (A : B)	100:50 (2:1 BY VOL.)
MIXED VISCOSITY (cps):	5,000 – 10,000
POT LIFE (200 gm mass):	45 MINUTES
GEL TIME (200 gm mass):	55-65 MINUTES

**CURE SCHEDULE:** (NOTE 3)

24 HRS @ RT OR 6 HOURS @ 60°C OR 2 HOURS @ 100°C

**CURED PROPERTIES:** (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR:		BLACK
SPECIFIC GRAVITY (gm/cm <sup>3</sup> ):		1.59
SHORE HARDNESS:		87D
FLEXURAL STRENGTH (psi):		11,500
LINEAR SHRINKAGE (in/in):	(ASTM D 2566)	< 0.002
TENSILE STRENGTH (psi.):	(ASTM D 638)	5,200
ELONGATION (%)	(ASTM D 638)	4%
MEETS FLAMMABILITY TEST (CSA C22.2)	NO. 0.6 1982	CLASS 0.6 V-1
MEETS FLAMMABILITY TEST		U.L 94 V-1
HEAT DISTORTION TEMPERATURE		70°C.

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**ELECTRICAL CHARACTERISTICS:** (NOTE 6)

DIELECTRIC STRENGTH (v/mil):		400
ARC RESISTANCE:		150 seconds
DIELECTRIC CONSTANT:	@ 1 KHz	4.0
DISSIPATION FACTOR:	@ 1 KHz	0.02
VOLUME RESISTIVITY (ohm – cm):		4X10 <sup>15</sup>

**NOTES:**

- 1) If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.
- 2) The mix ratio must be within ± 2% of the stated value and thorough mixing is required to avoid degraded properties.
- 3) Other cure schedules may yield satisfactory results however; these should be determined by the customer for his given application.
- 4) Unless otherwise specified, all measurements are taken at 22<sup>0</sup>C.
- 5) These products may trigger allergic reactions in some individuals. Prevent contact with skin; wash with plenty of soap and water if contact occurs and **Read the Material Safety Data Sheet** before using the materials. **Do Not Breathe Vapours** provide good ventilation and exercise good housekeeping at the work area.
- 6) If stated, the values under “**Electrical Characteristics**” may be based on supplier data for products with similar compositions. They are provided only as a guide and the recipient must test each material to determine its suitability for the intended application.
- 7) If indicated, the “**Guide to Operating Temperature**” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of a product for a particular operating temperature is application dependent and **may change according to the demands placed upon it in service.**

**IMPORTANT**

**THE INFORMATION IN THIS BULLETIN IS BASED ON DATA OBTAINED BY OUR OWN RESEARCH AND IS CONSIDERED ACCURATE. ALL INFORMATION SUPPLIED BY CROSSLINK TECHNOLOGY INC., IS FURNISHED UPON THE EXPRESS CONDITION THAT THE PERSON RECEIVING THE PRODUCT SHALL MAKE THEIR OWN ASSESSMENT TO DETERMINE ITS SUITABILITY FOR THEIR PARTICULAR PURPOSE. NO WARRANTY IS EXPRESSED OR IMPLIED REGARDING SUCH INFORMATION, OR THE RESULTS TO BE OBTAINED FROM THE USE THEREOF; THAT ANY PRODUCT SHALL BE MERCANTABLE OR FIT FOR ANY PARTICULAR PURPOSE; OR THAT THE USE OF SUCH OTHER INFORMATION OR PRODUCT WILL NOT INFRINGE ANY PATENT.**

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