



CROSSLINK TECHNOLOGY INC.

FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS

ISO

9001

REGISTERED
QUALITY SYSTEM

SINCE 1981

TECHNICAL BULLETIN: CLR 1946 / CLH 6500

PRODUCT DESCRIPTION:

A TWO COMPONENT, ROOM TEMPERATURE CURE SEMI-FLEXIBLE EPOXY SYSTEM. THE SYSTEM WAS DEVELOPED FOR POTTING/CASTING OF ELECTRICAL AND ELECTRONIC COMPONENTS. ITS USE OF NON ABRASIVE FILLERS AND CONVENIENT 1:1 RATIO BY VOLUME, MAKES IT IDEAL FOR USE IN MACHINE DISPENSING EQUIPMENT.

SALES SPECIFICATION	CLR 1946	CLH 6500
COLOUR	BLACK	TAN
VISCOSITY (NOTE 1, NOTE 4)	8000 - 15000 CPS @ 22 °C	6000 - 12000 CPS @ 22 °C
SPECIFIC GRAVITY	1.60 ± 0.03 gm/cm ³	1.53 ± 0.03 gm/cm ³
SHELF LIFE	12 MONTHS	12 MONTHS

HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 2)	100:100 (by vol. 100:100.0)
MIXED VISCOSITY (NOTE 4)	7500 cps @ 22 °C
POT LIFE OF 200 gm. mass (NOTE 4)	60.00 Min. @ 22 °C
GEL TIME OF 200 gm. mass (NOTE 4)	2.50 Hrs. @ 22 °C

HANDLING STRENGTH/DEMOULD TIME~12-24 Hrs @ 22°C

CURE SCHEDULE (NOTE 3):

RECOMMENDED CURE SCHEDULE	6 Hrs. @ 60 °C
ALTERNATE CURE SCHEDULE	7 Days. @ 22 °C

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	BLACK
DENSITY (gm/cm ³)	1.57
SHORE HARDNESS	65D
TENSILE STRENGTH (psi) (ASTM D 638)	1100
TENSILE ELONGATION (%) (ASTM D 638)	50.0
GUIDE TO OPERATING TEMPERATURE(°C)(NOTE 6)	130
THERMAL CONDUCTIVITY W/(m•K)	0.705

ELECTRICAL PROPERTIES

DISSIPATION FACTOR A	@1	0.0200
DIELECTRIC STRENGTH	380 Volts/Mil	125.0 Mil/Section
VOLUME RESISTIVITY		2.0 x10 ¹⁴ ohm•cm Ω•cm

NOTES

Note1 If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.

Note2 Mix ratio must be within ± 2% of the stated amount and thorough mixing is required to avoid degraded final properties.

Note3 Other cure schedules may give satisfactory results, however, these should be determined by the customer for their given circumstances.

Note4 All measurements taken at 22°C unless otherwise specified.

Note5 These products may trigger allergic responses in some individuals. Prevent contact with skin, wash with plenty of soap and water immediately if contact occurs. Do not breathe vapours, provide good ventilation and exercise good housekeeping at work area. Read the Material Safety Data Sheet.

Note6 The “Guide to Operating Temperature” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of this product for a given operating temperature is application dependent and may change according to the demands placed upon it in operation.

Note7 If indicated, 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.

IMPORTANT

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