

Technical Bulletin # 3118

Product Description

INSULCAST 333 is a moderate viscosity, self-extinguishing, epoxy potting/casting compound which is recognized under the component program of Underwriters Laboratories' Flame Class 94V-O.

Properties Uncured

	INSULCAST 333	INSULCURE 20	INSULCURE 11B	
COLOR, VISUAL:	Neutral	Amber	Amber	
VISCOSITY @ 25°C, cps:	13,000	700	700	ASTM D 2393
SPECIFIC GRAVITY:	1.55	0.98	0.95	
MIX RATIO (by wt.):		100:12-16	100:8	
MIXED VISCOSITY, cps:		3,000	3,000	ASTM D 2393
POT LIFE (100g.) @ 25°C, hrs:		1	2.5	
SHELF LIFE @ 25°C, months:	12	12	12	

Properties Cured**PHYSICAL**

HARDNESS, DUROMETER (Shore D):	85	85	ASTM D 2240
TENSILE STRENGTH, psi:	11,500	12,000	ASTM D 638
TENSILE ELONGATION, %:	2.75	3.75	ASTM D 638
FLEXURAL STRENGTH, psi:	17,500	19,500	ASTM D 790
COMPRESSIVE STRENGTH, psi:	14,000	14,500	ASTM D 695
COEFFICIENT OF THERMAL EXPANSION, °C:	48 x 10 ⁻⁶	48 x 10 ⁻⁶	
THERMAL CONDUCTIVITY, BTU-in/(ft ²)(hr)(°F):	4.3	4.2	
FLAMMABILITY RATING 94 V-O:	Pass	Pass	
HEAT DISTORTION POINT, °C:	80	155	
SERVICE TEMPERATURE, °C:	105	155	

Electrical

DIELECTRIC STRENGTH, volts/mil:	410	430	ASTM D 149
DIELECTRIC CONSTANT, 1 KHz:	4.4	4.5	ASTM D 150
DISSIPATION FACTOR, 1 KHz:	0.02	0.02	ASTM D 150
VOLUME RESISTIVITY, ohm-cm:	1 x 10 ¹⁵	1 x 10 ¹⁵	ASTM D 257

Use Instructions

1. Premix **INSULCAST 333** in original container being certain to reincorporate any fillers that may have settled.
2. Weigh out required amount of **INSULCAST 333**.
3. Weigh into **INSULCAST 333**, the proper amount of curing agent according to the ratios indicated.
4. Mix thoroughly, being careful to scrape sides and bottom of container to ensure proper blending.
5. Evacuate for 2-5 minutes if void-free castings are required.
6. Pour into cavity or mold.

Cure Schedule

Insulcure 20: 8-12 hours at room temperature (25°) or 2 hours at 50°C.

Insulcure 11B: 2 hours at 100°C, (212°F) for masses less than 1/2 lb.
For masses above 1/2 lb. cure 2 hours at 80°C, (177°F) plus 2 hours at 100°C (212°F).
For optimum high temperature properties, post cure 1 hour at 150°C (302°F).

Storage Requirements

This product has a tendency to settle upon shipment or storage. The product should be re-mixed well prior to use. Store material in a cool dry place.

Date 08/2009

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HEALTH CAUTION:

Avoid breathing possible fumes, mists and vapors which can cause severe respiratory damage. Use of NIOSH approved breathing apparatus is required for more than minimal exposure. Always work in areas with adequate ventilation to allow dissipation of polyamine and other chemical fumes, and where applicable, solvent fumes. Use of goggles, protective garments, rubber gloves, protective cream is required. If material gets into eyes, flush thoroughly with clean water for twenty (20) minutes; then seek medical treatment. Avoid skin contact. Material can cause contact dermatitis. Always wash exposed areas immediately, using warm water and soap, followed by rinsing with clean water. Observe all safety precautions. It is important when using solvent based materials or solvents to keep away from open flame or ignition source.

PLEASE REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER FIRST AID INFORMATION. FOR CHEMICAL EMERGENCY, CALL CHEMTREC (DAY OR NIGHT) 800 424-9300.