

25A / Electrical Encapsulant

Soft, abrasion resistant elastomer

Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Excellent electrical properties

Applications

- For room temperature hand-batch processing

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	100
		pbv	90	100
Density	ASTM D-792	g/cm ³	ca. 1.07	ca. 0.96
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 50	ca. 2,200

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,200
Gel time at 77°F (25°C)		min	20-30
Demold time at 77°F (25°C)		h	14-18

Cured / Mechanical Properties (approximate values)

Cure: 7 days at 77°F

			Cure
Aspect	visual		Green
Density	ASTM D-792	g/cm ³	1.01
Shore hardness A	ASTM D-2240		20-30
Tensile strength	ASTM D-638	psi	115
Elongation at break	ASTM D-638	%	100
Tear strength	ASTM D-624	psi	25
Volume Resistivity	ASTM D-270	Ω-CM	2.0 x 10 ¹⁶
Surface Resistivity	ASTM D-270	Ω-CM	2.8 x 10 ¹⁶
Dielectric Strength (25°C)	ASTM D-149	V/MIL	550
Dielectric Constant (25°C)	ASTM D-150		2.5
Dissipation Factor (1 kHz, 25°C)	ASTM D-150		0.015

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The processing and material temperature should be between 68-77°F (20-25°C).

This system has been designed to ease the release of mixed air without degassing or pressure. However, for best results, de-air the material prior to casting, then pressurize to 60 psi.

Agitate the hardener before use to ensure that the formula is homogeneous.

Packaging

IE-3300 Quart Kit	3.5 lbs.
IE-3300 1 Gal. Kit	14 lbs.
IE-3300 5 Gal. Kit	70 lbs.
IE-3300 Drum Kit	700 lbs.

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.
