**PRODUCT DESCRIPTION**

**INSULCAST 116 FR** is a one to one ratio (weight or volume) epoxy potting and casting compound designed for production use. The convenient mixing ratio of the material makes it ideal for production line mixing as well as automatic dispensing. **INSULCAST 116 FR** is among the safest epoxy compounds available. It appreciably reduces the risk of eye, skin or respiratory problems generally associated with the use of epoxy compounds.

**PROPERTIES UNCURED**

<table>
<thead>
<tr>
<th></th>
<th>Part A</th>
<th>Part B</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>COLOR, VISUAL</strong></td>
<td>Black</td>
<td>Neutral</td>
</tr>
<tr>
<td><strong>VISCOSITY, cps</strong></td>
<td>7,200</td>
<td>11,000</td>
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<tr>
<td><strong>SPECIFIC GRAVITY</strong></td>
<td>1.5</td>
<td>1.45</td>
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<tr>
<td><strong>MIXED VISCOSITY</strong></td>
<td>8.100</td>
<td>-</td>
</tr>
<tr>
<td><strong>POT LIFE, 100 gram mass, hrs</strong></td>
<td>1.5</td>
<td>-</td>
</tr>
<tr>
<td><strong>GEL TIME, 25°C, hours</strong></td>
<td>3-4</td>
<td>-</td>
</tr>
<tr>
<td><strong>SHELF LIFE, 25°C, months</strong></td>
<td>12</td>
<td>-</td>
</tr>
</tbody>
</table>
**PROPERTIES CURED**

**PHYSICAL**
- DURAMETER (Shore D) 75 ASTM D 2240
- COMPRESSIVE STRENGTH, psi 12,500 ASTM D 695
- TENSIILE STRENGTH, psi 9,500 ASTM D 638
- FLEXURAL STRENGTH, psi 10,000 ASTM D 790
- TENSIILE ELONGATION, % 8.0 ASTM D 638
- COEFFICIENT OF THERMAL EXPANSION °C 30x10⁻⁶
- THERMAL CONDUCTIVITY, W/m-K 0.649
- FLAMMABILITY, UL 94V0 Passes
- HEAT DISTORTION POINT, °C 70
- SERVICE TEMPERATURE, °C -40 to +105

**ELECTRICAL**
- DIELECTRIC STRENGTH, volts/mil 420 ASTM D 149
- DIELECTRIC CONSTANT, 1 KHz 4.4 ASTM D 150
- DISSIPATION FACTOR, 1 KHz 0.02 ASTM D 150
- VOLUME RESISTIVITY, ohm/cm 1x10¹⁴ ASTM D 257

**USE INSTRUCTIONS**
1. Premix contents of each container before use to insure uniformity. Some light settling may occur, but it will be soft and easily reincorporated.
2. Measure our equal volume or weight of each component and mix together thoroughly. Be careful to scrape sides and bottom of container to incorporate all unmixed material, or serious loss of physical and electrical properties will result.
3. De-air (if necessary) at 29 in. Hg for 10 minutes.
4. Pour into cavity or mold.
5. Recover both containers immediately after each use to prevent contamination.

**CURE SCHEDULE**
Allow to cure 16-24 hours at room temperature (72°F).
To accelerate cure, allow 2 hours at room temperature (72°F), then 130°F for 2 hours.

**STORAGE REQUIREMENTS: IMPORTANT**
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.

**IMPORTANT:**
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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.**