



**TECHNICAL BULLETIN #3118 – INSULCAST 333 NEUTRAL
SELF-EXTINGUISHING EPOXY COMPOUND. UL 94 V-0**

Revised: 05/2018

PRODUCT DESCRIPTION

INSULCAST 333 Neutral is a moderate viscosity, self-extinguishing, epoxy potting/casting compound which conforms to the component program of Underwriters Laboratories' Flame Class 94V-O. File # E86165.

PROPERTIES UNCURED

	INSULCAST 333	INSULCURE 20	SOLIDS %	
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	48x10 ⁻⁶	48x10 ⁻⁶	-
THERMAL CONDUCTIVITY, BTU-in/(ft ²)(hr)(°F)	4.3	4.2	-
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	1x10 ¹⁵	1x10 ¹⁵	ASTM D 257

INSTRUCTIONS FOR USE

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.

ITW PERFORMANCE POLYMERS

130 Commerce Drive | Montgomeryville | PA 18936 | USA | T: 215-855-8450 | E-mail: customerservice.na@itwpp.com | www.itwperformancepolymers.com

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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.