



TECHNICAL BULLETIN #3006 – INSULCAST 116 FR-FC Revised: 05/2018
ROOM TEMPERATURE CURE, EQUAL RATIO, POTTING AND CASTING COMPOUND.
INSULCAST 116 FR-FC IS UL RECOGNIZED FOR FLAME CLASS 94 V-O

PRODUCT DESCRIPTION

INSULCAST 116 FR-FC is a one to one ratio (weight or volume) epoxy potting and casting compound designed for production use. The convenient mixing ratio makes it ideal for production line mixing as well as automatic dispensing. The **INSULCAST 116 FR-FC** 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

	Part A	Part B	
COLOR, VISUAL	Black	Neutral	-
VISCOSITY, cps	7,200	11,000	ASTM D 2393
SPECIFIC GRAVITY	1.50	1.50	-
POT LIFE, 100 gram mass,	30-45 min.		-
GEL TIME, 25°C, hours	1-2		-
MIXED VISCOSITY, cps	9.800		-
SHELF LIFE, 25°C, months	12		-

PROPERTIES CURED

PHYSICAL		
DUROMETER, Shore D	65-75	ASTM D 2240
COMPRESSIVE STRENGTH, psi	11,500	ASTM D 695
TENSILE STRENGTH, psi	9,500	ASTM D 638
FLEXURAL STRENGTH, psi	10,000	ASTM D 790
TENSILE ELONGATION, %	5-7	ASTM D 638
COEFFICIENT OF THERMAL EXPANSION °C in/in	35x10 ⁻⁶	
THERMAL CONDUCTIVITY, BTU in / (ft ²) (hr) (°F)	4.5	
FLAMMABILITY, UL 94V0	Passes	
HEAT DISTORTION POINT, °C	80	
SERVICE TEMPERATURE, °C	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	1x10 ¹⁴	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 out 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

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.