# Scotchcast™ Electrical Resin 5

Two-Part, Room-Curing, Class B, Rigid, Unfilled Epoxy Liquid Resin

## Data Sheet

### Product Description

Electrical and electronic applications designed to operate @ 130°C (Class B) temperatures are the intended areas of use for 3M™ Scotchcast™ Electrical Resin 5. This transparent resin offers good physical and electrical properties plus low viscosity for maximum impregnating qualities.

- Good physical properties
- Reversion resistant
- Low viscosity

### Handling Properties

| | |
|---|---|
| Mix Ratio (A:B) | Wt 2 : 1 |
| | Vol (%) 63.5 : 36.5 |
| Viscosity | A = 12,500 cps |
| @ 23°C (73°F) | B = 100 cps |
| | Mixed = 3,000 cps |
| Density | A = 1.16 kg/l (9.71 lbs/gal) |
| | B = 0.995 kg/l (8.30 lbs/gal) |
| Flash Point | A = 232°C (450°F) |
| | B = 82°C (180°F) |
| Gel Time | 18 min. @ 60°C (140°F) |
| Curing Guide | 23°C (75°F) 24-48 hrs |
| | 60°C (140°F) 1 hr |
| | 95°C (203°F) 1/2 hr |

### Typical Data/Physical Properties

| Property | Value |
|---|---|
| **Color** | Transparent Yellow |
| **Hardness (BARCOL)** | 15 |
| **Specific Gravity** | 1.12 |
| **Compressive Strength**[1] | 13,200 psi |
| 10% Compression | (928 kg/cm$^2$) |
| **Tensile Strength**[2] | 8000 psi |
| Ultimate | (562 kg/cm$^2$) |
| **Elongation** (% at break)[2] | 7 |
| **Flexural Strength**[3] | 12,000 psi |
| | (844 kg/cm$^2$) |
| **Thermal Conductivity**[4] | 4.4 x $10^{-4}$ |
| (Cal/sec/cm$^2$/°C/cm) | |
| **Linear Thermal Expansion**[4] | 17.7 x $10^{-5}$ |
| (length/unit length/°C) | |
| **Electric Strength**[6] | 325 volts/mil |
| (.125" [3 mm] Sample) | (13 kV/mm) |
| **Mechanical Shock Resistance**[4] | 5 |
| (Weight in lbs. of ball causing fracture) | (5.8 kg) |
| **Moisture Absorption**[4] | 0.5 |
| % weight increase, 240 hrs. @ 96% R.H. | |
| **Thermal Aging** | |
| % weight loss | |
| 7 days @ 105°C | 0.44 |
| 1000 hrs. @ 130°C | 3.5 |
| 1000 hrs. @ 155°C | 6.5 |
| **Boiling Water** | |
| 7 days % weight gain | 1.8 |
| **Hydrolytic Stability**[5] | |
| 120 Days 71°C (160°F) 95% RH | |
| Hardness Loss % (Shore D) | 1.2 |
| **Dielectric Constant**[7] | |
| 1000 Hz 23°C | 3.6 |
| **Dissipation Factor**[7] | |
| 1000 Hz 23°C | 0.06 |
| **Volume Resistivity**[8] | $10^{14}$ ohm-cm |

**Test Methods**

[1]Fed. Std. No. 406, Method 1021
[2]Fed. Std. No. 406, Method 1011
[3]Fed. Std. No. 406, Method 1031
[4]MIL-I-16923E
[5]MIL-I-16923G
[6]Fed. Std. No. 406, Method 4031
[7]Fed. Std. No. 406, Method 4021
[8]Fed. Std. No. 406, Method 4041

***Note: These are typical values and should not be used for specification purposes.***

## Usage Information

**Mixing**
Mix the separate parts before removing them from their containers. They may be warmed to 60ºC (140ºF) to aid mixing. (Gel time is approximately 20 minutes @ 60ºC). Thoroughly mix parts A and B in the correct proportions. Mix until the color is absolutely uniform and a homogeneous mixture is obtained.

**Deaerating**
Air introduced during mixing can be removed by evacuating at 5 to 10 mm of mercury (Hg) absolute pressure. The resin can be warmed to aid air removal. The container side wall should be four times the height of liquid resin to contain the foaming that takes place under vacuum.

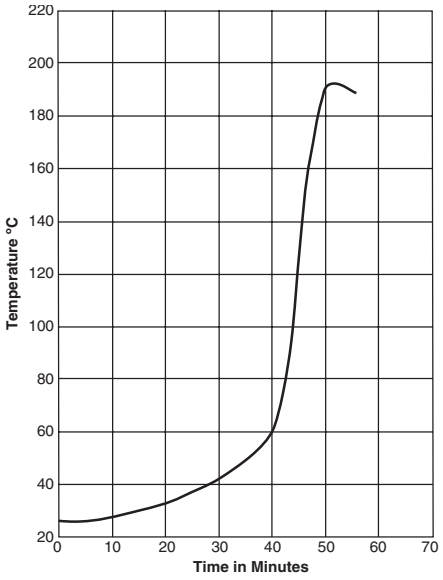
**Casting and Impregnating**
Heating the part, resin and mold aids impregnation. For maximum impregnation, evacuate at 5 mm of mercury (Hg) absolute pressure, or pour under vacuum and hold for several minutes before releasing. Castings, which require a large mass of resin, should be poured in several layers to minimize the temperature rise caused by exotherm. The heat produced by a large mass of this resin might otherwise cause the hardener to become volatile and leave bubbles in the casting.

**Curing**
Where minimum stress and maximum thermal shock resistance are required, the lower temperature cure cycle is recommended. (See "Curing Guide" of **Handling Properties** section). Time should be added to the cure cycle to allow the resin to reach the curing temperature.

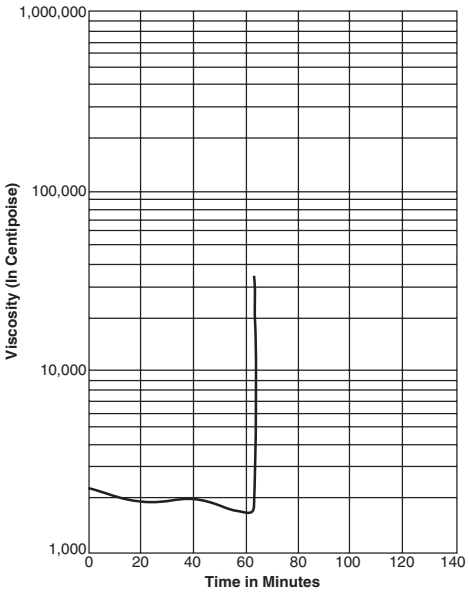
**Storage**
Both parts of this resin system should be stored at temperatures between 20 to 30 degrees Celsius, and 30% to 60% relative humidity. When not in use, containers should be kept tightly closed. Storage at conditions outside those suggested may compromise the performance of the resin.

## Handling and Safety Precautions

Read all Health Hazard, Precautionary and First Aid statements found in the Material Safety Data Sheet (MSDS) and/or product label of chemicals prior to handling or use.

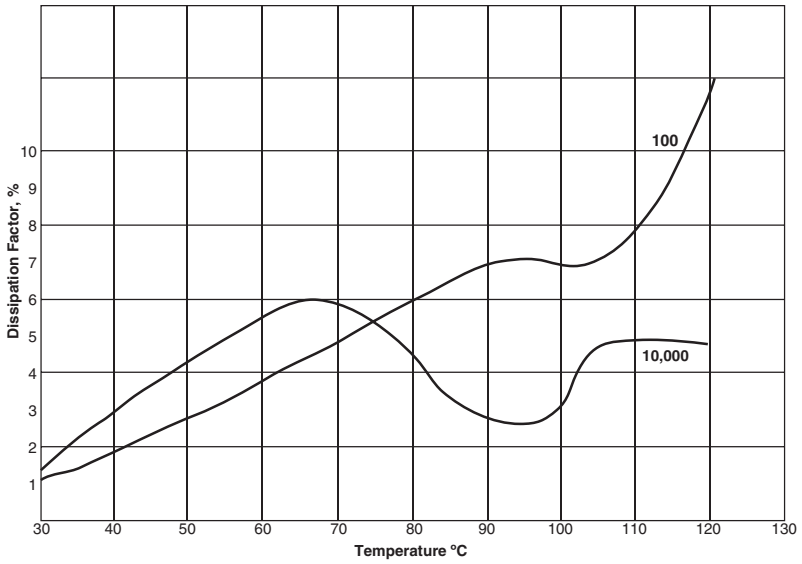



**Exothermic Heat Rise** for 1 lb. Sample

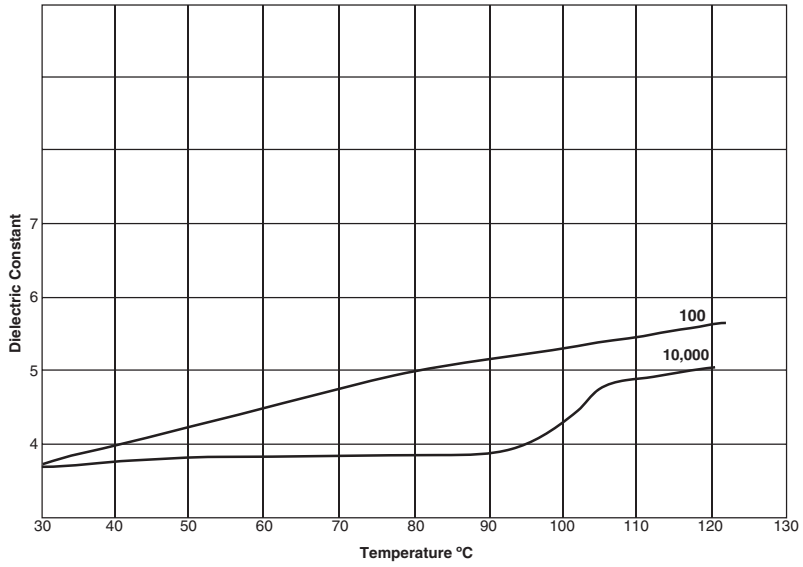



**Brookfield Viscosity vs Time** @ 73∞F (23∞C) 130 gram sample

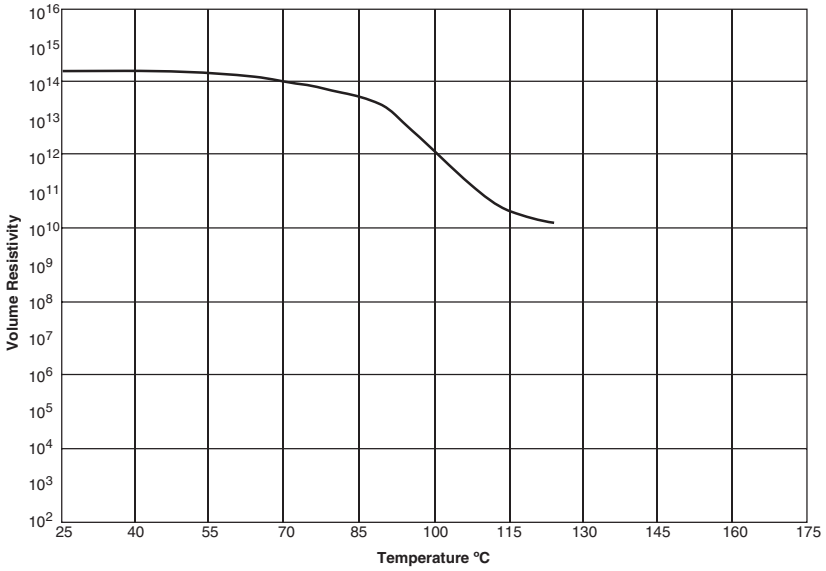
**Dissipation Factor %**
Fed. Std. No. 406, Method 4021
(Test Frequencies in Hertz)




**Dielectric Constant**
Fed. Std. No. 406, Method 4021
(Test Frequencies in Hertz)




**Volume Resistivity - ohm-cm**
Fed. Std. No. 406, Method 4041



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3M
**Electrical Markets Division**
6801 River Place Blvd.
Austin, TX 78726-9000
800/676-8381
Fax: 800/828-9329
www.3M.com/electrical/oem

*Printed on 50% recycled paper with 10% post-consumer*

Litho in USA
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