



## TECHNICAL DATA **Solid Cast 651**

**Solid Cast 651** is a formulated, two-part epoxy system supplied as a convenient 2 to 1 mix ratio. The low-viscosity pourable system is ideally suited to electrical potting and encapsulation applications. This product may also be used as a general purpose, setting slow cure adhesive for a broad range of substrates. Part A is a liquid epoxy resin containing a reactive diluent. Part B, the curing agent component of the system, is a low viscosity polyamide resin

### Typical Properties

Ultimate Flexural Strength. (ISOR 178) KPa	64,120
0.2% offset flexural Strength KPa	45,510
Flexural Modulus (ISOR 178) KPa x 10 <sup>5</sup>	21.4
Ultimate compressive strength (ASTM D695) KPa	48,260
Ultimate Tensile Strength (ISOR 527)	29,650
Compressive Modulus KPa x 10 <sup>5</sup>	12.5
Elongation at Break (ISOR 527) %	4.4
Dielectric Constant - Condition A, Frequency 1000Hz	3.64
Dissipation Factor - Condition A, Frequency 1000Hz	0.012
Exotherm - Maximum temperature (based on 100 grams)	98° C
Exotherm - Minutes to maximum temperature	80 minutes
Mix Ratio by Volume	
Part A	2
Part B	1
Pot Life min @ 25°C 100g mass	90 minutes

### Application

Do not mix more material than can be used within the pot-life time for the mix.

The larger the mix the shorter the working time.

Accurately measure the Part A and Part B into clean containers.

Add part B to Part A and mix, using a flat edged stirrer for about 2 minutes, scrape the bottom and sides of the container to ensure full incorporation of the resin and hardener and mix until a uniform streak free colour is obtained, about 3 minutes.

Larger volumes should be mixed with a power stirrer operated at 250rpm.

Immediately pour the resin into the encapsulation mould or casing.

### Safety Instructions.

Avoid contact with skin and eyes.

Wear gloves and safety glasses when mixing and using this material.

Refer to the MSDS's before using this product.

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