



TECHNICAL INFORMATION

EPOCAP® 16505 Epoxy Encapsulation System

PRODUCT DESCRIPTION

EPOCAP 16505 is a filled, two-component, room temperature cure general purpose potting and encapsulating system. It is recommended for potting low voltage devices such as transformers, coils, switches, time delay relays, connectors and other electrical or electronic components.

HOW TO USE

The individual components containing fillers should be stirred or agitated without introducing excessive air before use to ensure that all fillers are properly dispersed. To obtain the best cured properties, accurate proportioning and thorough mixing are essential. To obtain void free castings, the mixed system should be degassed under vacuum at approximately 29 inches of mercury (or better) for a few minutes, both immediately after mixing and then again after castings are poured, if the work life of the system allows.

MIXING AND CURING SCHEDULE

Ratio	Part A	Part B
By weight	100	10
By volume	100	16

The cure schedule is dependent upon the temperature. The recommended cure schedule will vary with the desired properties. The recommended schedule to achieve the typical properties is shown below:

7 days at 25 °C (77 °F) **OR** 2 hours at 65 °C (150 °F)

TYPICAL UNCURED PROPERTIES

	Part A	Part B	Mixed
Color	Off White	Blue	Blue
Viscosity @ 25 °C, cps	20,000	80	8,000
Weight per Gallon, lbs.	12.9	8.1	12.3
Specific Gravity @ 25 °C	1.55	0.97	1.47
Gel time, minutes			
200 gm mass @ 25 °C	---	---	50
Filler Type	Non-Abrasive	None	Non-Abrasive
Shelf Life (in separate sealed containers), months	12	12	---

TYPICAL CURED PROPERTIES

(Tested at 25 °C unless otherwise indicated)

Test	Result
Hardness, Shore D	90
Tensile Strength, psi	7,200
Compressive Strength, psi	17,000

Flexural Strength, psi	9,800
Flexural Modulus, psi	925,000
Linear Shrinkage, in./in.	0.0007
Water Absorption, % Weight Gain After: 7 days immersion	0.38

TYPICAL THERMAL PROPERTIES

Test	Result
Heat Distortion Temperature, °C	59
Coefficient of Linear Thermal Expansion, in./in./ °C (+30 to 90 °C)	62 x 10 ⁻⁶
Thermal Conductivity, cal. x cm./sec. x cm ² x °C	6.4 x 10 ⁻⁴
Recommended Service Temperature	105 °C

TYPICAL ELECTRICAL PROPERTIES

Dielectric Constant	100 Hz	100 kHz
Test Temperature, °C		
25	4.5	4.3
100	6.6	5.3

Dissipation Factor	100 Hz	100 kHz
Test Temperature, °C		
25	0.018	0.006
100	0.2	0.032

Volume Resistivity, ohm-cm

Test Temperature, °C	100 Hz	100 kHz
25	5.20 x 10 ¹⁵	
105		1.10 x 10 ¹⁰

Dielectric Strength, Volts/mil	497
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STORAGE AND HANDLING

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60°F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials. Introduction of a nitrogen blanket into the containers before closing will improve the storage life of the products.

A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes. For more information on proper recommendations and procedures, contact the Technical Department.

SAFETY

These materials are intended for industrial use only and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

Although the system contains low volatility materials, care should be taken in handling. Adequate ventilation of work place and ovens is essential.

These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheets for additional information.

ADDITIONAL INFORMATION

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