EPOXIES
INNOVATIVE BONDING SOLUTIONS ETC.

TECHNICAL BULLETIN

20-1615
WATER CLEAR SILICONE POTTING COMPOUND

DESCRIPTION:
20-1615 is a two component, room temperature curing silicone rubber compound. This silicone system is clear, odorless, and low in viscosity. 20-1615 is an excellent choice for potting electronic assemblies that require shock and vibration resistance. It also protects assemblies from moisture, ozone, chemicals and other environmental hazards.

FEATURES:
- Low viscosity
- Contains no solvents
- Operating temperature $^{-}$65 to $^{+}$205°C
- No exotherm during cure
- Hydrolytic stability
- Easy 10:1 Ratio

TYPICAL SPECIFICATIONS:

Color	Water clear
Viscosity, 25°C, cps, mixed	6,000
Specific gravity, 25°C	1.03
Pot life @ 25°C	4 hours
Hardness, shore A	40
Tensile strength, psi	950
Elongation, %	120
Shrinkage, %	0.2
Refractive index	1.4
Dielectric strength,V/mil	500
Dielectric constant @ 1000 Hz	2.7
Dissipation factor @ 1000 Hz	.0004
Volume resistivity, ohm-cm	1.2×10^{15}
Operating temperature, °C	$^{-}$65 to $^{+}$205°C
Thermal conductivity, btu·in/hr·ft^2·°F	0.12
Coefficient of expansion, in/in °F	18.3×10^{-5}

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INSTRUCTIONS FOR USE:

1. By weight mix 100 parts 20-1615A Resin to 10 parts 20-1615B Catalyst.
2. Mix thoroughly and uniformly. Be carful not to whip excess air into mixture.
3. Degas if necessary to remove air from mixture. Select a mixing container 4-5 times larger than the volume of silicone material. Pull a vacuum of about 25mm (29 in.) of mercury. The silicone material will rise and then recede to the original level as the air bubbles break.
4. Pour and follow one of the cure schedules:

25°C	24-48 hours
65°C	4 hours
100°C	1 hour
125°C	45 minutes
150°C	10-15 minutes

Silicone rubber compounds will cure in contact with most clean, dry surfaces. Certain materials, such as butyl and chlorinated rubber, sulfur, amines and certain metal soap-cured silicone compounds can cause cure inhibition.

For improved adhesion contact Epoxies, Etc. Technical Department for the recommendation of a primer.

IMPORTANT:

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