EPOXIES
INNOVATIVE BONDING SOLUTIONS ETC.

TECHNICAL BULLETIN

20-1625
OPTICALLY CLEAR SILICONE POTTING AND ENCAPSULATING COMPOUND

DESCRIPTION:
20-1625 is a low viscosity and easy to use 1:1 ratio silicone system. It is designed for applications that require clarity and protection from shock and vibration. 20-1625 provides good heat resistance and is flame retardant.

20-1625 is formulated without solvents or other toxic materials. It is therefore not regulated or considered hazardous for transportation.

FEATURES:
- Easy 1:1 mix ratio
- Soft
- Excellent electrical properties
- Solvent free
- Optically clear

BENEFITS:
- Simple to use
- Low stress on components and vibration resistant
- Extends life of electronic assemblies
- No by-products released during cure and safe to handle
- Easy component identification

TYPICAL SPECIFICATIONS:

Viscosity, cps, 25 °C	
20-1625ACL Resin	4,500
20-1625BCL Activator	4,000
Color	
20-1625ACL Resin	Clear
20-1625BCL Activator	Clear
Hardness, Shore A	25
Operating Temperature Range, °C	-55 to +200
Specific Gravity, 25 °C	
20-1625ACL Resin	0.98
20-1625BCL Activator	0.98
Working Time, 25 °C	20 Minutes
Dielectric Constant, 60 Hz	2.7
Dielectric Strength, V/mil	500
Volume Resistivity, ohm-cm, 25 °C	1×10^{15}
Coefficient of Thermal Expansion, ppm/°C	270
Thermal Conductivity, W/m·K	0.16
Refractive Index, Liquid	1.403 at 589 nm
Spectral Transmission, Cured	>95% at 360-2100 nm

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INSTRUCTIONS FOR USE:

1. By weight or volume, mix 1 part 20-1625ACL silicone to 1 part 20-1625BCL activator. Mix uniformly, scraping sides and bottom of mixing container. Do not whip air into mixture. If using TriggerBond® cartridges follow dispensing guidelines.
2. Degas by pulling vacuum on mixed material.
3. Cure according to one of the following recommended cure schedules:
   a) 25 °C 3-4 Hours
   b) 60 °C 60 Minutes

SUBSTRATE NOTES:

Certain materials may inhibit the cure of this product. Materials that should be avoided include sulfur containing materials, nitrogen containing materials (i.e. amines) some silicones (tin cured), and butyl and chlorinated rubbers. If in doubt, a patch test should be done.

STORAGE, HANDLING, & SAFETY:

Store both components at 25 °C in original containers. The expected shelf life is 12 months in original containers.

Please read the Safety Data Sheet before using this or any other chemical.

AVAILABILITY:

This product is available in the convenient dual barrel TriggerBond® cartridges 50 mL, 200 mL, and 400 mL cartridges. This is also available in bulk packaging quarts, gallons, 5-gallon pails, and 55 gallon drums.

IMPORTANT:

10/2024

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