20-1634
LIGHTWEIGHT SILICONE POTTING AND ENCAPSULATING COMPOUND

DESCRIPTION:
20-1634 is a low density, two component silicone elastomer. The 20-1634 is less than half the weight of most commercially available potting and encapsulating compounds.

20-1634 utilizes an advanced micro balloon technology filler. This system is ideal for applications that require low weight, flexibility, high heat resistance, and excellent electrical insulation properties.

20-1634 is formulated without solvents or other toxic materials. It is therefore not regulated or considered hazardous for transportation.

FEATURES:
• Low density
• Flexible
• Deep section curing
  (beyond 1-2 inches)
• High operating temperatures
• Solvent free

BENEFITS:
• Does not add much weight to products
• Low stress on components and vibration resistant
• No need for multiple pours due to low exotherm
• Good protection in extreme environmental applications
• No by-products released during cure and safe to handle

TYPICAL SPECIFICATIONS:
Color
Resin (Part A) White
Activator (Part B) Clear

Viscosity, @ 25°C, cps
Resin (Part A) 45,000
Activator (Part B) 100
Mixed 30,000

Specific Gravity, @ 25°C
Resin (Part A) 0.80
Activator (Part B) 0.97
Mixed 0.82

Pot Life, 25°C, 100 grams 1 Hour

Hardness, Shore A 34
Elongation, % 225
Tensile Strength, psi 125
Tear Strength, pli 16.5

Thermal Conductivity, btu-in/hr·ft²·°F 1.1
Coefficient of Thermal Expansion, per °C $2 \times 10^{-4}$
TYPICAL SPECIFICATIONS (continued):
Volume Resistivity, ohm-cm, 25°C 1 x 10^{14}
Dielectric Constant @ 100 Hz 3.1
Dielectric Strength, V/mil 450
Operating Temperature, °C -65 to +235

INSTRUCTIONS FOR USE:
1. Mix base and hardener separately since some settling of fillers may occur.
2. By weight, mix 100 parts base silicone to 10 parts activator. Mix uniformly, scraping sides and bottom of mixing container. Do not whip air into mixture.
3. De-air by pulling vacuum on mixed material.
4. Pour and let cure overnight at room temperature or follow one of the schedules below:
   - 25°C 24-48 Hours
   - 65°C 2-4 Hours
   - 100°C 1 Hour
   - 150°C 20 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:
When stored in the original, unopened container, in a dry location at 65° - 80°F, 20-1634 has a shelf life of approximately six months.

AVAILABILITY:
20-1634 silicone is available in quart, gallon, five gallon pail, and 55 gallon drum kits.

IMPORTANT:
EPOXIES, ETC. MAKES NO EXPRESS OR IMPLIED WARRANTIES OR MERCHANTABILITY, FITNESS OR OTHERWISE WITH RESPECT TO ITS PRODUCTS. The information in this brochure is based on data obtained by our own research and is considered reliable. However, no warranty is expressed or implied regarding the accuracy of these data, the results to be obtained from the use thereof, or that any such use will not infringe any patent. The properties given are typical values and are not intended for use in preparing specifications. This information is furnished upon the condition that the person receiving it shall make his own tests to determine the suitability thereof for his particular purpose.

10/12