



epoxy tech_{mcs inc.}
east system®

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Technical bulletin

ELECTRICAL COMPOUND

1203

CASTING SYSTEM

"FAST GEL TIME, FLAME-RETARDANT"

Description:

The 1203 is a two component, 100% solid, room temperature cure epoxy system. It has a fast gel time convenient in large volume production. Once completely cured, it offer a good hardness and beautiful finish.

Uses:

Used for encapsulation and potting of electrical compound.

Typical uncured properties:

Components	Mixing Ratio		Specific Gravity	Viscosity Brookfield @ 25 ^o C mPa.s (cps)	Packaging			Color
	By weight # Parts	By volume # Parts			Kg ⁽¹⁾			
Resin	100	100	1.65	45 000-70 000				Grey
Hardener	12	19	1.04	1 000-1 500				Amber
Mix			1.55	18 000-25 000				Grey

⁽¹⁾ To be determined

Gel time:

Minutes	Temp. °C	Mass (gr.)
20-22	22	150

Coverage:

One (1) kg covers approximately 640 cm³ (39 in³).

Typical cured properties:

Minimum cure schedule for 7 days @ 22°C (72°F).

Hardness, Shore D: 90-91

Mixing:

1. Mix 1203 resin only with 1203 hardener.
2. Do not use damaged or leaking containers.
3. Premix resin and hardener separately. Then place the hardener into the resin container according to the required mixing ratio.
4. Blend the hardener into the resin thoroughly using a paddle attached to a low speed heavy duty electric drill at 300-600 rpm. Continue to mix for a minimum of 3 minutes or until the mix becomes homogeneous.
5. Never dilute with solvents.

Cleaning of tools:

Tools and equipment should be cleaned immediately after use with Epoxy Tech's #17 solvent or with Epoxy Tech's "Clean tool" #4 for a safer use.

Storage:

Keep containers closed until just before use at a temperature above 15°C.

Caution:

Keep resin and hardener away from eyes and skin. Avoid breathing of vapors and use good ventilation. Like any reactive material, uncured resin and hardener may irritate sensitive skin. Wear protective clothing, goggles and gloves.

First aid:

Eyes:

Flush immediately with plenty of water for 15 minutes and obtain medical aid.

Skin:

Clean skin with warm water and a soft soap. Never use solvents to remove material from skin.

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NOTE:

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