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**LEECAST 29-192-1
 FLAME RETARDANT EPOXY**

Description

LEECAST 29-192-1 is a two-part epoxy compound designed for potting electrical and electronic components. The advantages of LEECAST 29-192-1 include, good thermal shock resistance, good electrical properties, non-abrasive filler, and room temperature cure.

| TYPICAL PROPERTIES | | |
|------------------------|--------------|--------------|
| | Part A | Part B |
| Appearance | White liquid | Amber liquid |
| Viscosity, 25°C, cps | 14,500 | 250 |
| Mixed Visc., 25°C, cps | 2,300 | |
| Density, lbs/gal | 12.8 | 7.9 |
| Shelf Life, months | 6 | 12 |

Mixing and Curing

LEECAST 29-192-1 can be mixed, de-aired, poured and cured at room temperature. Measure out Part A and B and mix thoroughly, scraping the sides and bottom of the container. The final mixed color is white. For void-free castings, de-air under vacuum and cast around components.

| TYPICAL HANDLING PROPERTIES | | |
|-----------------------------|--------|--------|
| | Part A | Part B |
| Mix Ratio, by volume | 100 | 30 |
| , by weight | 100 | 19 |
| Gel Time, 25°C, 100g, min | 160 | |

The gel time of LEECAST 29-192-1 depends on temperature and mass of material. Large masses and/or elevated temperatures will shorten the gel time. Cure can be accomplished at room temperature or with heat if faster cures are desired. Typical cure schedules for small masses are:

50°C 4 – 8 hours
 80°C 1 – 2 hours

| TYPICAL PERFORMANCE | |
|---|-------------------------|
| Hardness, Shore D | 84 |
| Glass Transition Temperature, °C | 58 |
| Dielectric Strength, 25°C, volt/mil | 400 |
| Dielectric Constant, 25°C, 1 mHz | 4.4 |
| Dissipation Factor, 25°C, 1 mHz | 0.022 |
| Volume Resistivity, 25°C, ohm-cm | 1.0 x 10 ¹⁴ |
| Thermal Conductivity, cal cm/sec cm ² °C | 1.15 x 10 ⁻³ |
| Coefficient of Thermal Expansion, -40 – 110°C, in/in °C | 76.5 x 10 ⁻⁶ |
| Coefficient of Thermal Expansion, 120 – 180°C, in/in °C | 144 x 10 ⁻⁶ |

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