

## Product Data Sheet

### ISO-CAST A 765 MI

#### Description:

ISO-CAST A 765 MI is a mineral filled cold-curing 2-component polyurethane cast resin. The resin and hardener are based upon hydrocarbon-resins. The cast resin was developed for casting electronic parts.

ISO-CAST A 765 MI exhibits a strong thixotropic effect. Therefore the material won't leak out of a mould even when there are small openings or slits in it.

Cured samples of ISO-CAST A 765 MI do not become brittle. The system has a good thermal conductivity and minimum shrinkage while curing. ISO-CAST A 765 MI protects against corrosion and shows good adhesion to metal, ceramics and many plastics. The hydrolytic resistance is excellent. ISO-CAST A 765 MI contains flame retardants and cured samples achieve an UL 94V-0 rating.

#### Technical Data:

resin	viscosity / 20°C	app. 70000 mPa s
	colour	black*
	density / 20°C	1.6 g / cm <sup>3</sup>
hardener	viscosity / 20°C	1000 - 2000 mPa s
	colour	clear
	density / 20°C	1.1 g / cm <sup>3</sup>
mixture	mixing ratio resin : hardener	5.8 : 1 pbw (4 : 1 pbv)
	colour	black*
	density / 20°C	1.55 g / cm <sup>3</sup>
	potlife / 20°C	Standard: App. 15 min *
	geltime / 20°C	Standard: App. 20 min *

\* or on request

## Continuation Technical Data ISO-CAST A 765 MI

### Properties of cured product (typical values):

mixing ratio resin : hardener	5.8 : 1 pbw
hardness	70 Shore A
temperature resistance	long-time: 120°C short-time: 180°C
elongation at break	150%
dielectric strength	> 15 kV/mm
dielectric strength while still liquid	5 kV/mm
dissipation factor $\tan \delta$ / 25°C / 50Hz	< 0.01
dielectric constant $\epsilon$ / 25°C / 50Hz	app. 3
thermal conductivity	0.6 W/K m
tracing resistance	KA 3 c
water absorption after 30 days / 23°C	0.5 %
chemical resistance against mineral oil, 2n H <sub>2</sub> SO <sub>4</sub> , CaCO <sub>3</sub> -solution	no visible degradation

### Storage:

Store dry and well closed.

### Processing:

Stir up resin component well. Then mix resin and hardener carefully in recommended ratio for 1 - 3 minutes (depending on size of mixture and potlife). The mixture has to be poured into the mould immediately after mixing. Air bubbles that have been stirred in the mixture can be removed before end of potlife by evacuating or by blowing hot air over the surface causing the bubbles to collapse.

Please see material safety data sheet for additional information.