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**POLYCAST 240 FR**  
**FLAME RETARDANT SHOCK RESISTANT EPOXY COMPOUND**

**DESCRIPTION**

PC 240 FR is a flexible filled epoxy resin system that exhibits low coefficient of thermal expansion and excellent shock resistance. It has the advantage of also being flame retardant. PC 240 FR is suitable for use in automated dispensing equipment

**PROPERTIES – UNCURED**

	<b>(Part A)</b>	<b>Part B</b>
Color , visual .....	Black	Clear
Viscosity, ASTM-D-2393 (c.p.s. @ 25° C)..	6200	500
Specific Gravity .....	1.45	1.14
Mix Ratio (by wt.).....	100:6	
Mixed Viscosity, ASTM-D-2393 (@ 25° C)	3900	
Pot Life @ 25°C (100 grams) .....	45 minutes	
Shelf Life @ 70° F .....	12 months	

**PROPERTIES – CURED**

**PHYSICAL**

Hardness, ASTM-D-2240 (Durometer).....	Shore A 90
Tensile Strength, ASTM-D-638 .....	3,000 psi
Tensile Elongation, ASTM-D-638 .....	75-100 %
Coefficient of Thermal Expansion .....	15 x 10 <sup>-6</sup>
Temperature Class .....	B
Moisture Absorption.....	0.07%
Dielectric Strength, ASTM-D-149 (volts/mil) .....	420
Dielectric Constant, ASTM-D-150 .....	4.5
Dissipation Factor, ASTM-D-150.....	0.08
Volume Resistivity, ASTM-D-257 (ohm-cm).....	7 x 10 <sup>12</sup>
Thermal Conductivity, (BTU/in / ft <sup>2</sup> °F).....	4-5
Thermal Cycling -55°C to 80°C .....	Passes

**MIXING INSTRUCTIONS**

Pre-mix Part A and Part B separately. Then measure 100:6 parts by weight (A to B). Mix thoroughly scraping the sides and bottom of the container. Evacuate and then pour into mold or cavity.

**CURE SCHEDULE**

Room temperature cure @75°F for 24 hours.

Post cure @ 250°F for 2 hours.

**CAUTION:** Good housekeeping rules are always important. Provide ample ventilation in all areas of handling, mixing and use. Avoid prolonged breathing of possible fumes. Minimize skin contact. Use of goggles, rubber gloves and protective creams is recommended. Always wash exposed areas immediately using warm water and soap, followed by rinsing with clear water. If material comes in contact with eyes, flush with clean water for 15 minutes and consult a physician immediately.

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All data given in this bulletin is based on our own research and research of others. They are believed to be accurate, however, no guarantee of accuracy is made. Product described is sold without warranty, except conformity to specifications, and on condition that purchasers shall determine suitability for their particular purpose.