

Technical Information

MICARES[®] 736 R10

Two-component casting resin

TYPE

Micares[®] 736 R10 is a casting resin system based on polyurethane, consisting of resin and hardener. This two component potting compound designed for use in the electro - engineering and the electronics has especially low viscosity and is cold to thermo-curing. It is solvent-free and liquid at ambient temperature (RT). The resin component contains the filler and is degassed.

GENERAL PROPERTIES

Flexible, synthetic material. The resin adheres well to metals and other materials. Low dielectric losses.

Hardness, Shore D: 50 - 60

USE

Highly filled electro - casting resin especially used for hard to cast-in electronic components. It is easy to process under normal conditions, e.g. ambient temperature and atmospheric pressure.

SUPPLY

Micares[®] 736 R10 consists of two components (resin and hardener):

- Resin 736 R10 = filled PUR - resin system
- Hardener P 980 = unfilled modified MDI - hardener

Containers / Weights	Resin 736 R10	Hardener P 980
200 l - steel drum	300 kg	250 kg
25 l - bucket (resin); 10 l - can (hardener)	37,5 kg	6 - 24 kg
630 / 1000 l - container	on request	
Mixing ratio (parts by weight)	5	1
Minimum shelf life (months)	6	9
Storage temperature	<40 °C	15 – 35 °C
Toxicity (Swiss classification) / BAG #	4 / 619004	3 / 614463



STORAGE

Both components should be stored in appropriate room in their originally sealed containers. **Avoid storage outside!**

The resin is chemically stable. However, before use, the resin must be carefully stirred with a suitable equipment since all resins containing mineral filler tend to build deposits. Stirring with particular care is necessary, when the resin has been stored for a long period of time.

Important:

The hardener must be kept away from any exposure to humidity. It should always be stored well sealed.

MIXING

The resin and hardener are mixed according to the specified ratio at ambient temperature, preferably using automatic dosing and mixing equipment.

If the resin has been stored for a long period of time, it is recommended to stir well the complete content of the container and to check the viscosity before the processing is being started. Formation of lumps has to be prevented by applying appropriate stirring conditions.

CASTING

The mixture is applied at ambient temperature (above 18°C). The moulds should be treated with a release agent (e.g. MICAFIL 8055) to facilitate subsequent mould removal. The moulds should be designed for bottom-filling. Such a design would allow the air in the mould to escape at the highest point. The moulds should preferably be slightly inclined for filling. For sophisticated components, or if optimal electrical properties are specified, casting under vacuum is required.

Cycle times could be significantly reduced by preheating the moulds to approx. 40 - 80°C depending on the shape and the size of the components. It is also possible to increase the reactive capacity of the casting resin compound by adding a catalyst (0,1 to 1%) without adverse effects on the final properties of the resin. The catalyst can be delivered separately.

HARDENING CONDITIONS

This resin is especially designed for hardening at ambient temperature. The final hardness will be achieved after 24h at temperature of 25°C. Hardening at higher temperature makes this process a lot quicker. To achieve fast hardening and obtain optimal final properties, a post-hardening at T=80°C, for 7h is necessary.

Under ideal conditions, e.g. optimal material mass distribution, well-designed moulds, etc. and if the moulds are preheated, the resin will often generate sufficient heat by exothermal reaction. Hence, there is no post-hardening (in oven) required.

SAFETY PRECAUTIONS

Many synthetic resin components are found to be liable for causing skin irritation, or otherwise affect health, if placed into a direct contact with the skin, or if their vapors have been inhaled. Adequate ventilation, use of protective clothing, goggles, gloves and chem. resistant shoes, clean working conditions and careful personal hygiene are usually sufficient as accident prevention measures. Medical advice is essential in all severe cases. MICARES resins are not to be considered a health hazard.

MICARES hardener is a toxic substance, but has a low vapour pressure at ambient temperature and it may be applied without special equipment, providing that care is taken to avoid possible skin, mucous membranes, or eye contact. For further details regarding safety, please refer to the safety datasheet.

MICARES^â 736 R10

	Properties		Standards	Units	Values
Resin 736 R10	Colour		RAL		~9011 black
	Density		DIN 51757	g/cm ³	1,6 - 1,7
	Viscosity as supplied	25°C	Brookfield	Pa s	2 - 5
Hardener P 980	Density		DIN 51757	g/cm ³	1,21 - 1,23
	Viscosity as supplied	25°C	Brookfield	mPa s	30 - 60
	Vapour pressure	25°C		mbar	< 10 ⁻⁴
Casting resin compound	Mixing ratio (resin / hardener)			parts by weight	5 : 1
	Initial viscosity	25°C	Brookfield	Pa s	0,8 - 1,0
	Gel time	23°C	DIN 16945	min	150 - 250
	Hardening conditions				7h / 80°C 28h / 60°C
	Density		ISO 1183	g/cm ³	1,6
Electrical properties	Dielectric strength 50 Hz, h = 2mm	20 s	IEC 243	kV/mm	18
	Spec. surface resistivity	20°C	IEC 93	Ω	10 ¹⁴
	Spec. volume resistivity	20°C	IEC 93	Ω cm	10 ¹⁴
	Dissipation factor tan δ 50 Hz	23°C	IEC 250		<0,03
	Relative permittivity ε _r 50 Hz	23°C	IEC 250		5
Thermal properties	Thermal class		IEC 85		B
	Glass transition temperature T _g		IEC 1006		25 – 35 °C
Physical and chemical properties	Cold water absorption 24 h / H ₂ O (method 1)		ISO 62	weight %	0,3
	Hardness, Shore D	25°C	DIN 53505		50 - 60

These properties have been determined by the above shown methods. The data given are valid for standard test specimen only. Unless otherwise specified, all data were measured at ambient temperature on specimen as manufactured and without particular treatment.

The contents of this publication are based on our present experience. They are an indication for application of our products without any liability for ourselves. Notice of legal requirements and existing patent rights has to be taken.

Due to the many application and manufacturing process possibilities, we cannot give any warranty for the technical results in individual cases.



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