

**PRODUCT DESCRIPTION:**

AA-Cast 156 is low cost epoxy formulation used in the general purpose casting applications and it is recommended for potting and encapsulating with the combination of good mechanical and electrical insulator are required.

AA-Cast 156 develops good adhesion to metals, ceramics and plastics.

AA-Cast 156 is strong cured epoxy and electrical insulator with high heat stability and a low thermal coefficient if expansion that provide good performance over a wide temperature range.

AA-Cast 156 has good resistance to water and weathering, most petroleum solvents, mild acids and alkalis and other chemicals.

**GENERAL PROPERTIES:**

Color	Black
Cure	Room temperature cure or Heat cure
Operating temperature	-50 to 105 °C Low viscosity Low shrinkage
Product Benefits	Good mechanical resistance Good electrical insulator
Mix Ratio, by weight- Resin : Hardener	100 : 7
Application	Manufacturing and Assembly
Typical Optic Application	Casting and potting applications
Substrates	Glass, Rigid plastics, Ceramic and Metals

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity @ 25 °C, cP:	24500 mixed
Specific Gravity, mixed	1.50 gm/cc
Pot Life, minutes	25

**TYPICAL CURING PERFORMANCE**

<i>Cure Schedule</i>	
25°C	24 hours
4 hrs @25°C+2 hrs@60°C	6 hours

**PHYSICAL PROPERTIES:**

Glass Transition Temperature (Tg), °C	82
Shore D	86
Water Absorption after 24 hrs	0.50%

**ELECTRICAL PROPERTIES:**

Dielectric Strength, volts/mil	450
Dielectric Constant @ 25°C : 1kHz	3.9
Dissipation Factor @ 25°C : 1kHz	0.01

**TYPICAL PERFORMANCE OF CURED MATERIAL**

Lap Shear Strength, psi:

Substrate	
Aluminum to Aluminum	1350

**GENERAL INFORMATION**

**For safe handling information on this product, consult the Safety Data Sheet, (SDS).**

**DIRECTIONS FOR USE**

- Carefully clean and dry all surfaces to be bonded
- Burst the pouch and thoroughly mix the AA-CAST 156 epoxy adhesive system components in the handy plastic pouch until color is uniform throughout.
- Apply this completely mixed adhesive to the prepared surfaces, and gently press these surfaces together. Contact pressure is adequate for strong, reliable bonds; however, maintain contact until adhesive is completely cured.
- Some ingredients in this formulation provided in the plastic pouch, and bulk packaging may crystallize when subjected to low temperature storage. A gentle warming cycle of 50°C for 30 minutes prior to mixing components may be necessary. Crystallized epoxy components do not react as well as liquid components and should be redissolved prior to use for best results.

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