

TECHNICAL DATA SHEET 890

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OptiCLEAR™ Liquid Encapsulant Fill 71372 A & B

OptiClear 71372 A & B is a 2 component epoxy designed for bonding, encapsulating and sealing applications requiring optical clarity and a moderate degree of flame resistance. **OptiClear 71372 A & B** will cure at ambient temperature, but will cure more rapidly with heat. The product has good adhesion to many substrates, including: metals, glass, and ceramics.

FEATURES

- Low Viscosity
- Good Clarity
- High Strength, and Rigid
- Fire Resistant to UL94HB
- Non-Halogen Based

UNCURED PROPERTIES (VALUES APPROXIMATE)

	PART A	PART B
TYPE	Epoxy Resin	Amine Mixture
COLOR	Clear, Colorless	Clear, Colorless
VISCOSITY, CPS	4000	>20

	MIXTURE
TYPE	
COLOR	Clear, Colorless
VISCOSITY	1000

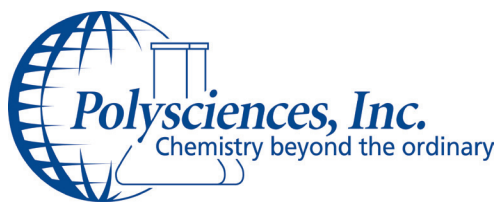
USAGE

Add Part B to Part A at a weight ratio of 15 parts 100 parts.

Mix the components together avoiding air entrapment as much as possible. This is best done by adding the components to a small clear bag with a zipper type closure, squeezing out the air, sealing the bag and kneading the product together for approximately 1 minute. A small cut in the corner of the bag can then be used to extrude the mixed product.

CURING

OptiClear 71372 A & B will cure at room temperature. However superior properties will result from heat curing the product. The product can be heat cured directly after mixing and application, or it can be post heat cured after initial curing at room temperature.



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RECOMMENDED HEAT CURE CYCLES

@ 25°C 48 hours (optimum: 24 hours @ 25°C + 1 hour @ 80 °C)

@ 60°C 3 hours

@ 80°C 1 hour (in thick sections, > 1/8" excessive exotherm may cause a darkening of the product)

CURED PROPERTIES

Property	Units	Value
Durometer @25°C	Shore D	80
Color	Gardener Scale	<2
Fire Resistance, UL94HB		Flame spread<40mm/minute

STORAGE AND HANDLING

- Store at room temperature
- Refer to MSDS for details

All values are considered typical on tests believed to be accurate. Polysciences, Inc may change the data as appropriate.

TO ORDER

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