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TECHNICAL DATA SHEET 675

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OptiCLEAR™ Liquid Encapsulant Fill SF801 A&B

DESCRIPTION

OptiClear SF801 A & B is a 2 component epoxy designed for bonding, encapsulating and sealing applications requiring good optical clarity. OptiClear SF801 A & B will cure at ambient temperatures, but will cure rapidly, and with optimum properties with moderate heat. The product has excellent adhesion to many substrates, including: metals, glass, and ceramics.

FEATURES

- Low Viscosity
- Long work life
- Optically clear

USAGE

Add Part B to Part A at a weight ratio of 50 parts to 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. If mixed in a container, the product should be left to stand until any foam or air is removed. This can be done quickly by placing the mixture in a dessicator attached to a vacuum pump. The mixture can be vacuumed until, foaming stops.

UNCURED (WET) PROPERTIES

	SF801A	SF801B	SF801A&B
Type	Epoxy Resin	Amine Mixture	
Color	Clear, Colorless	Clear, Colorless	Clear, Colorless
Viscosity	1500 cps	<20cps	250
Specific Gravity	1.20	0.95	1.10

PROCESS PARAMETERS

Mix Ratio

	SF801A	SF801B
By Weight	100	50
By Volume	1.6	1.0
Pot Life	@ 25°C ~3 hours (100 grams of mixed product)	

CURE CYCLE

For minimal yellowing, especially in sections >3mm, the product is best cured <70°C.

SF801 can be cured by any of these cycles:

Temperature °C	Time
25	3 days
60	3 hours
70	1.5 hours
80	1 hour

CURED PROPERTIES

	Units	Value
Durometer	Shore D @ 25°C	70 @ 25°C
Color	Gardener Scale	1
Temp Range of use	°C	-50 thru + 160*

*Under low stress conditions and for intermittent exposures, higher temperature resistance is likely.

STORAGE AND HANDLING

Storage: Room Temperature

Safety: Refer to MSDS for details

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

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