

Circalok™ 6735 Silicone Encapsulant

Description

LORD Circalok™ 6735 encapsulant is a two-component, addition-cure silicone system for use in applications where high temperature service and a flexible system are required. Circalok 6735 encapsulant cures to a clear, flexible elastomer which adheres to most substrates without the use of a primer.

Features and Benefits

Low Viscosity – maintains low viscosity for complete and void-free encapsulation.

Broad Temperature Range – can be used on parts and devices that experience operating temperatures from -55°C to +205°C.

Reversion Resistant – provides excellent reversion resistance at high temperatures; will not cause corrosion.

Application

Mixing – Thoroughly stir each component prior to mixing together. Mix Circalok 6735 A resin with Circalok 6735 B hardener at a 10:1 ratio, by weight.

Applying – Apply encapsulant using automatic meter/mix/dispense equipment.

Avoid applying Circalok 6735 encapsulant to surfaces that contain cure inhibiting ingredients, such as amines, sulfur or tin salts. If bonding surface is in question, apply a test patch of Circalok 6735 encapsulant to the surface and allow it to set for the normal cure time.

Curing – Allow encapsulant to cure for 4 hours at 65°C. This time-at-temperature profile refers to the time the material should be allowed to cure once it reaches the target temperature. Allowance should be made for oven ramp rates, parts with large thermal mass and other circumstances that may delay material actually reaching the target temperature. An overnight post cure at 85°C is recommended to obtain optimum properties, especially for large volumes.

Typical Properties*

	6735 A Resin	6735 B Hardener	Mixed
Appearance	Clear Liquid	Clear Liquid	Clear Liquid
Viscosity, cps @ 25°C	3700	200	3500
Specific Gravity	1.00	1.00	1.00
Working Life, hr @ 25°C	–	–	8

*Data is typical and not to be used for specification purposes.

LORD TECHNICAL DATA

Typical Cured Properties**

Volume Resistivity, ohm-cm @ 25°C ASTM D 257	1 x 10 ¹⁴
Thermal Conductivity, W/mK	0.2
Hardness Shore A	40
Tensile Strength, psi	750
Elongation at Break, %	150
Dielectric Strength, V/mil	450
Dielectric Constant @ 100 Hz	3.0
Dissipation Factor @ 100 Hz	0.001

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Cure schedule of 2 hours at 150°C.

Shelf Life/Storage

Shelf life of each component is six months from date of manufacture when stored at 25°C in original, unopened container.

Cautionary Information

Before using this or any LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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