

# THERMOSET® 300 RESIN

## Technical Data Sheet

Thermoset® 300 epoxy resin is a general purpose, filled epoxy resin formulated for use with several Thermoset hardeners to obtain a variety of handling and cured properties. Thermoset 300 epoxy resin offers improved shock resistance and lower coefficient of thermal expansion compared to unfilled epoxy resins.

### Features and Benefits

Handling and cured properties of the two-component epoxy system are dependent on the hardener used with Thermoset 300 epoxy resin.

#### Thermoset Hardener No. 18

- **Heat Resistant:** provides superior heat resistance for room temperature cured system; can be used in applications up to 130°C.

#### Thermoset Hardener No. 65

- **Low Viscosity:** maintains low viscosity for complete and void-free encapsulation.
- **Excellent Appearance:** cures to a high gloss surface, free of "blush" or "sweat-out".
- **Environmentally Resistant:** high surface hardness provides good impact and mar resistance.
- **Moisture Insensitive:** cured properties obtained even when cured in high humidity environments.

#### Thermoset Hardener No. 67

- **Elevated Temperature Cure:** requires an elevated temperature cure to obtain a rigid bond.
- **High Temperature Resistant:** provides good resistance for cured system that experiences continuous operating temperature up to 155°C.

#### Thermoset Hardener No. 70

- **Low Viscosity:** provides low viscosity and surface tension, enabling void-free casting without a vacuum step.
- **Environmentally Resistant:** cured system provides excellent thermal shock resistance and high impact strength.

#### Thermoset Hardener No. 72

- **Low Exotherm:** exhibits low exothermic heat rise during room temperature cure.
- **Environmentally Resistant:** cured system provides excellent mechanical and thermal shock resistance; retains flexibility even after severe heat aging.
- **UL Rated:** cured system is UL 94 HB certified.

### Application

**Mixing:** Transfer amount of resin needed to a clean container and add proper amount of hardener by weight. Thoroughly mix resin and hardener together. Automatic meter/mix/dispense equipment may be used for high volume production.

Unless a closed-chamber mechanical mixer is used, air may be introduced when catalyzing the mixture. Electrical properties of the epoxy are best when air bubbles and voids are minimized. Therefore, in extremely high voltage or other critical applications, vacuuming may be appropriate.

**Applying:** Apply epoxy system using automatic meter/mix/dispense equipment.

**Curing:** Cure time will vary depending on hardener used. Refer to cure schedule indicated below. 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 reaching the target temperature.

**Cleanup:** Disposable containers and utensils are recommended when working with epoxies. However, when disposable materials are impractical, uncured epoxy can be removed by cleaning equipment with solvent. Solvent-cleaned utensils should be thoroughly dried before reuse; any remaining solvent can contaminate the next mixture.

### Shelf Life/Storage

Shelf life is one year when stored at 25°C in original, unopened container. The material must be periodically rotated within its container to minimize settling.

#### Typical Properties\*

Appearance	Black Liquid
Viscosity, cP @ 25°C	68,000
Specific Gravity	1.62

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

## Cautionary Information

Before using this or any Parker 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.*

## Typical Properties\* of Resin Mixed with Hardener

	Thermoset Hardener No. 18	Thermoset Hardener No. 65	Thermoset Hardener No. 67	Thermoset Hardener No. 70	Thermoset Hardener No. 72
Mix Ratio, Resin to Hardener					
by Weight	100:7	100:20	100:12	100:15	100:100
by Volume	100:11	100:34	100:21	100:24	100:110
Mixed Viscosity, cP @ 25°C	12,000	7000	8000	2000	40,000
Working Life, minutes @ 25°C	25 (100g)	60 (200g)	90 (454g)	35 (125g)	75 (200g)
Cure Time, hours	24 @ 25°C	24 @ 25°C	2** @ 100°C	24 @ 25°C	24 @ 25°C

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

\*\* Optional post cure - 2 hours @ 150°C.

## Typical Cured Properties\*

	Thermoset Hardener No. 18	Thermoset Hardener No. 65	Thermoset Hardener No. 67	Thermoset Hardener No. 70	Thermoset Hardener No. 72
Hardness Shore D	90	90	94	88	65
Tensile Strength, MPa (psi) @ 25°C	59.3 (8601)	51.7 (7498)	59.3 (8601)	67.6 (9804)	13.9 (2016)
Elongation at Break, %	2.4	3.2	4.0	4.4	27
Moisture Absorption, % 24 hours @ 25°C	0.15	0.12	0.15	0.21	0.47
Volume Resistivity, ohm-cm @ 25°C	2 x 10 <sup>6</sup>	3 x 10 <sup>15</sup>	3 x 10 <sup>16</sup>	7 x 10 <sup>15</sup>	1 x 10 <sup>14</sup>
Dielectric Strength, kV/mm (V/mil) ASTM D 149	17.7 (450)	14.6 (370)	18.1 (460)	15 (380)	14.6 (370)
Dielectric Constant @ 25°C 1MHz, ASTM D 150	4.1	4.0	4.5	3.9	3.8
Dissipation Factor @ 25°C 1MHz, ASTM D 150	0.022	0.025	0.040	0.032	0.029

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### Parker Lord Engineered Materials Group

111 LORD Drive  
Cary, NC 27511-7923  
USA  
phone +1 877 275-5673  
www.parker.com/APS

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