

TECTORIUS® TEC-FIL™ Series

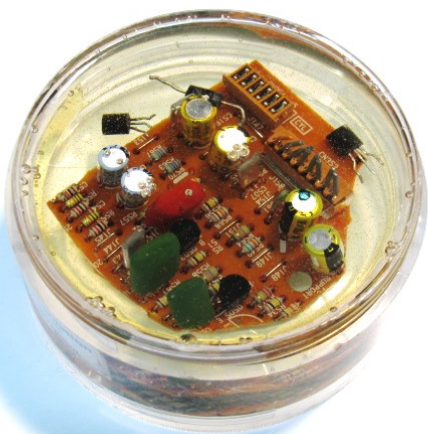
Reactive Filling Compound

DESCRIPTION:

Tec-Fil products are reactive filling compounds used in a variety of assembly operations for encapsulating, potting, and ruggedizing.

These two-component materials are available in many grades, designed for various special purposes. The most popular grades include those formulated for control modules, electronics, and electrical markets. Several grades are specifically designed for applications where Class H performance is needed.

In the final cured state, Tec-Fil products are heat-stable, with varying hardness and extreme durability. They are available in a standard opaque black color to hide proprietary electrical circuit design, but can also be made to color code your assembly for easy identification. In fact, Tec-Fil materials may be custom formulated to meet the property requirements for your specific application.



PRODUCT FEATURES:

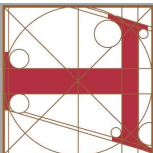
- » **Durable:** Tec-Fil products are strong and long lasting once fully cured.
- » **Customizable:** These products may be formulated to meet a wide range of requirements for color, cure time, hardness, shrinkage, and/or other properties.
- » **Inexpensive:** Compared to competing products, these reactive filling compounds are low-cost.
- » **Multiple Applications:** Can be used for applications such as microelectronics or PCB assembly, wire tacking, lamination, ruggedizing, potting, or encapsulating electronic components.



*The information provided is based on technical data that Tectorius believes to be reliable. Since we cannot anticipate or control the various conditions under which this information and our product may be used, we cannot guarantee the applicability of this information or the suitability of our product in any individual situation. Therefore, the product is sold without warranty expressed or implied.

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TECTORIUS® TEC-FIL™ 1800 Series

Reactive Filling Compound

SPECIFICATIONS:

Finished Product	1800	1801	1802	1803	1804	1805						
Product												
Mixed Ratio by Weight	2:1	2:1	2:1	2:1	2:1	2:1						
Gel Time	75 minutes @ 200°F (93°C)	75 minutes @ 200°F (93°C)	90 minutes @ 70°F (21°C)	90 minutes @ 70°F (21°C)	30-60 minutes 70°F (21°C)	30-60 minutes 70°F (21°C)						
Cure Schedule	120 minutes	120 minutes	24 hours	24 hours	24 hours	24 hours						
Shore A Hardness @ 73°F (23°C)	97	97	97	97	95	95						
Shore D @ 70°F (21°C)	52	52	52	52	46	46						
Shore A @ 356°F (180°C)	84	84	84	84	82	82						
Weight Loss after 7 days @ 356°F (180°C)	0.3%	0.3%	0.3%	0.3%	0.3%	0.3%						
Individual Components	1800A	1800B	1801A	1801B	1802A	1802B	1803A	1803B	1804A	1804B	1805A	1805B
Color	Clear Straw	Amber	Clear Straw	Black	Clear Straw	Amber	Clear Straw	Black	Clear Straw	Amber	Clear Straw	Black
Specific Gravity	1.16	1.2	1.16	1.2	1.16	1.2	1.16	1.2	1.16	1.2	1.16	1.2
Viscosity @ 77°F (25°C) (cPs)	12000-14000	50-60	12000-14000	50-60	12000-14000	50-60	12000-14000	50-60	12000-14000	50-60	12000-14000	50-60
Shelf Life (unmixed)	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.	1 yr.

Note: Custom grades may be formulated for specialized applications, color or property requirements.

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