



# PRODUCT INFORMATION

**HIGH TECHNOLOGY MATERIALS**

## MERECO 4501-130\*

### **CRYSTAL CLEAR TRANSPARENT EPOXY RUBBER FOR EMBEDMENT OF ELECTRONIC COMPONENTS**

**MERECO 4501-130** is an epoxy resin system that contains no solvents, but is designed to cure into a transparent crystal clear rubber-like gel. The cured material is tough, yet firm and flexible. **MERECO 4501-130** is designed for use in encapsulation where “see through” visibility is desired for inspection and repair purposes. Test probes can be pushed through the cured material, which also can be cut away and then repaired again with freshly mixed compound.

The low viscosity of **MERECO 4501-130** (approx 750 cps) coupled with the long working life at room temperature, allows easy air bubble release and mixing. Just mix together equal portions by weight of activator and base. **MERECO 4501-130** is a simple-to-use, long pot life impregnant as well.

**MERECO 4501-130** can be used as a laminating adhesive for safety glass, and also because of its crystal clarity, to laminate safety shields to television picture tube faces.

Although some darkening occurs at higher temperatures, **MERECO 4501-130** may be operated continuously at 150°C, with some decrease of flexibility, however, on aging at this temperature.

#### DIRECTIONS FOR USE:

1. Mix together equal portions by weight of **MERECO 4501-130**.  
Mix until turbidity disappears.
2. Deaerate if desired. The low viscosity eliminates this step to remove air bubbles.
3. Cure the mixed **MERECO 4501-130** at any one of the following schedules:  
(Use lower temperatures for large masses)

78 hours at 25°C ( 77°F)

48 hours at 50°C (122°F)

15 hours at 85°C (185°F)

\***MERECO 4501-130** is a special grade of **MERECO 4501** epoxy elastomer to replace silicone rubber in applications which require high adhesion, cushioning and shock resistance, with no age-hardening.

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**TYPICAL PROPERTIES OF UNCURED LIQUID COMPONENTS**

	<u>PART A</u> <u>ACTIVATOR</u>	<u>PART B</u> <u>BASE</u>	<u>MIXTURE EQUAL</u> <u>PARTS A &amp; B</u>
Appearance	Clear	Clear	Crystal Clear
Physical Form	Liquid	Liquid	Transparent Liquid
Specific Gravity 25°C/25°C	0.98	1.16	1.03
Viscosity, 25°C, cps	100	8-10,000	750
Storage Life 77°F	6 months	6 months	
Pot Life			24 hours

**TYPICAL PROPERTIES OF CURED MERECO 4501-130**

Appearance	Clear, rubbery plastic
Tensile Strength, psi	750
Elongation, %	150
Hardness, Shore A @ 150°C	29
@ 25°C	25
@ -55°C	90
Impact Resistance, Izod ft. lb./in notch	2.08
Water Absorption, % 24 hrs	1.50
Weight Loss, % (24 hr. at 300°F)	1.80
Dielectric Constant, 10 <sup>3</sup> to 10 <sup>10</sup> cps	3
Dissipation Factor, 10 <sup>3</sup> to 10 <sup>10</sup> cps	0.02
Volume Resistivity, (ohm-cm 25°C)	10

**MERECO 4501-130** is also available for a dip coating as a thixotropic gel.