



Technical Data Bulletin No.
MEREKO XL-330LV

PRODUCT INFORMATION

High Technology Materials for Electronics and Industry

PRODUCT NUMBER: MEREKO XL-330LV DESIGNATION: TWO PART HIGH TEMPERATURE EPOXY

INTENDED APPLICATION:

DESCRIPTIVE DATA:

	RESIN PORTION	ACTIVATOR	MIXTURE
FORM	LIQUID	LIQUID	LIQUID
COLOR	AS SPECIFIED	AMBER	AS SPECIFIED
SP. GR.:	1.21	1.23	1.22
*VISCOSITY:	50,000-80,000 CPS	600-1600 CPS	5,200 CPS

INSTRUCTIONS FOR USE:

MIX RATIO: (BY WEIGHT) MIX TOGETHER 100 PARTS ACTIVATOR AND 100 PARTS RESIN.

POT LIFE: (100GM MASS) (WORKING LIFE OF MIXTURE) 2 ½ HOURS AT 25°C

CURE TIMES: CURE 2 HOURS AT 100°C AND POST CURE FOR 16 HOURS AT 175°C

SPECIAL INSTRUCTIONS: BASE MAY BE PREHEATED TO 125°F TO FACILITATE POURING AND MIXING

CHARACTERISTICS OF CURED COMPONENTS:

	TEST METHOD	AVERAGE VALUES**	PHYSICAL UNIT
IMPACT RESISTANCE	IZOD		ft-lbs/in notch
EXPANSION COEFFICIENT	ASTM D 696		
THERMAL SHOCK RESIST.	MIL-I-16923C		
OPERATING TEMP. RANGE		TO 475 (112 HOURS)	°F
WEIGHT LOSS		<5% (112 HOURS)	475°F (246°C)
HARDNESS TESTS	ASTM D 2240	90	SHORE D
MOISTURE TESTS			
FLEXURAL STRENGTH	ASTM D 790	14,000	psi
COMPRESSIVE STRENGTH	ASTM D 695	30,000	psi
TENSILE STRENGTH	ASTM D 638	7,000	psi
Tg		121	°C
TENSILE LAP SHEAR (A1-A1)	ASTM D 1002		psi
DIELECTRIC STRENGTH	ASTM D 149	350	volts/mil
VOLUME RESISTIVITY	ASTM D 257	10 ¹⁶	ohm-cm
DISSIPATION FACTOR	ASTM D 150		
DIELECTRIC CONSTANT	ASTM D 150	3.0	

* Thixotropic materials list viscosity obtained by Helipath test method.

** Test values are average values obtained by standard laboratory tests. These are not intended as final specification limits and are not to be used for the preparation of specifications.

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