



PRODUCT INFORMATION

HIGH TECHNOLOGY MATERIALS

MERECO CLN-672

ULTRA HIGH TEMPERATURE RESISTANT AND THERMALLY CONDUCTIVE ENCAPSULATING, POTTING, AND ADHESIVE POLYMER SYSTEM

MERECO CLN-672 is a high temperature resistant epoxy with good heat dissipating properties. Simple mix ratio and good flow properties make it easy to use and apply in encapsulation, potting and adhesive applications. CLN-672 is particularly effective in bonding

Ultra High Temperature Resistance and Stability	Withstands 315°C (600°F) for intermittent use, 260°C (500°F) for prolonged exposure, and 204°C (400°F) for continuous use
Thermally Conductive	Protects electronic components against excessive heat buildup Transmits heat to temperature sensors
Simple Mix Ratio	One to one (1:1) proportioning of Base and Activator simplifies preparation and dispensing operations
High Voltage Resistance	Protects imbedded electronic components against arcing and surface mounted components against corona
Low Shrinkage Coefficient	Minimizes thermal shock to components and loss of adhesion

MERECO CLN-672 is a superior material for electrical components such as insulators, power amplifiers, high voltage bushings, thermostats, thermal switches, thermal sensors and capacitors.

MERECO CLN-672 has superior adhesion to metals, ceramics, glass and bondable plastics including Ryton, surface treated Teflon, Rulon and polypropylene. **MERECO CLN-672** will bond tenaciously to difficult to bond surfaces such as polysulfone, Kapton, and polyimide substrates.

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FORM 1105 REV. 0

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DIRECTIONS FOR USE

1. Stir contents of containers of **MERECO CLN-672** parts A and B prior to mixing. Viscosity may be reduced by warming both Base and Activator to 140°F with some shortening of pot life.
2. Blend, by weight, equal amounts of **MERECO CLN-672** Base and Activator and stir thoroughly.
3. Working life of catalyzed **MERECO CLN-672** is 2-4 hours at room temperature (25°C).
4. Cure Schedule

Preset	200° - 220°F for 2 - 3 hours.
Post Cure	300° - 400°F for 16 - 24 hours.

For optimum high temperature properties, a second post curing operation is recommended at 500° - 550°F for 24 hours.

TYPICAL PROPERTIES**UNCURED LIQUIDS**

Color
Form
Viscosity, cP at 25°C
Viscosity (mixed), cP at 25°C
Specific Gravity, 25°C/25°C

BASE

Off-White
Paste
250,000-300,000
100,000
1.8

ACTIVATOR

Off-White
Syrup
4,500-6,000
1.8

CURED PROPERTIES

Color
Hardness
Operating Temperature Range:
 Intermittent
 Extended Period
 Continuous

Glass Transition Temperature, °C
Coefficient of Thermal Expansion, um/m°C
 Below Tg
 Above Tg
Thermal Conductivity W/m°C

Reddish to black depending on curing schedule
92 Shore D

315°C (600°F)
260°C (500°F)
205°C (400°F)

149
46
123
1.09

CLEAN-UP

METATERGE 1405 is recommended to replace hazardous solvents for general clean-up. **METATERGE 1405**, a unique water soluble resin detergent, dissolves uncured resin systems and renders them water compatible. Soiled equipment, tools or bench areas can then be simply cleaned with a wet sponge or shop rag. Refer to data bulletin for **METATERGE 1405**.