

DAPCO™ 3050 LOW DENSITY, SELF-EXTINGUISHING EPOXY POTTING COMPOUND

TECHNICAL DATA SHEET



DESCRIPTION

DAPCO™ 3050 is a single component, self-extinguishing epoxy compound.

FEATURES & BENEFITS

- Low shrinkage
- Low density
- Self-extinguishing
- Excellent adhesion to metals
- High heat distortion
- Good compressive strength
- Qualified to Bell's 299-947-097 type 4

SUGGESTED APPLICATIONS

DAPCO 3050 is commonly used for honeycomb core filling, encapsulation and insert potting.

CHARACTERISTICS

Table 1 | Product Description

Color	Off-white
Solids, %	100
Appearance	Dry paste
Viscosity at 72°F (22°C), cps	Thixotropic paste
Density, lbs/gal	2.0 (loose bulk)

PROPERTIES

Table 2 | Typical Cured Properties

Property	Value
Hardness, Shore D	60
Compression Strength, psi (MPa)	2300 (15.86)
Shrinkage, %	0.4
Water absorption (72 hours), %	0.25
Density, lb/ft ³	30
Heat Distortion, °F (°C)	300 (149)

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APPLICATION NOTES

Processing

DAPCO 3050 is supplied ready to use.

Fill clean, moisture and oil free cavities. Pack to desired density (28 – 30 pounds per cubic foot).

Curing: Standard cure procedure for DAPCO 3050 is two hours at 280°F (138°C).

Optional cure for DAPCO 3050 is four hours at 250°F (121°C).

For low shrinkage and low exotherm, cure two hours at 250°F (121°C) plus one hour at 275°F (135°C).

For highest heat distortion, post-cure two or more hours at 325°F (163°C)

Note: Cure rates for DAPCO 3050 are relative to volume. Heat source also has an influence on cure rate. Heated molds are more effective than air circulating ovens.

Surface Preparation

The substrates must be free from contaminants, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly.

Product Storage

Store at or below 40°F (4°C)

Keep containers tightly sealed.

Shelf Life: 12 months from date of shipment at 40°F (4°C), 2 months at ambient temperature

PRODUCT HANDLING AND SAFETY

Cytec Engineered Materials recommends wearing clean, impervious gloves when working with epoxy adhesives to reduce skin contact and to avoid contamination of the product.

Materials Safety Data Sheets (MSDS) and product labels are available upon request and can be obtained from any Cytec Engineered Materials Office.

DISPOSAL OF SCRAP MATERIAL

Disposal of scrap material should be in accordance with local, state, and federal regulations.

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