3M[™] Scotchcast[™] Liquid Resins Troubleshooting

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This troubleshooting chart has been developed to assist 3M customer in identifying and solving some possible problems that can occur when using 3M TM Scotchcast TM Liquid Resins. Should you need further assistance, contact your local 3M Sales Representative or area electrical distributor.	s	Problem Problem											101100 101100 101100 101100 1000 100000 100000 10000 10000 10000 1000000		
Cause and Solution	Uncurred	Restruction	oplastic sil	ne or Disc	Resince Soor Little	LE OL SUD	theston and and and and and and and and and an	50 Sunace	on Castin	All of D	at Soft of Sof	Suffard	ubles ne cast		
Contamination Moisture/Keep covered Dirt/Clean parts and keep them covered Excess mold release/Use sparingly Oxidized surfaces/Remove oxide Incompatible insulation or components/ Change insulation															
Rough mold surface/Polish mold															
Undercuts in mold/Remove undercuts Insufficient mold release/Use more mold release Inadequate mold release/Use different mold release Permanent-type release worn away/ Resurface mold Mold not broken in/Use mold															
Insufficient vacuum/Adjust vacuum Resin viscosity too high/Select resin with lower viscosity or warm resin to reduce viscosity Component design/Check design for undercuts															
Difficult-to-bond-to surface (e.g., plastics)/ Evaluate Scotchcast primers; "rough up" surface Nonstick surface (PTFE, etc.)/ Change materials															
Incorrect mix ratio/Check equipment and procedures, must be within \pm 2% Insufficient mixing/Having proportioned parts A and B correctly, mix thoroughly															
Resin not fully cured/Check oven temperature. Is resin at cure temperature at onset of timed cure cycle?															
Wrong resin choice/May need more flexible system or a filled system															
Poor component or mold design/ Change design															
Cure temperature too high/ Lower temperature Temperature reached as a result of exotherm/Check exotherm. Use smaller mass of resin															
Excessive shrinkage/Filled resins exhibit less shrinkage and should be considered if this problem persists															

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