

### Description

ClearSet is a hard, transparent, fast-curing acrylic for cold mounting of metallographic specimens and printed circuit boards (PCB's). It provides excellent edge retention, clarity, and low shrinkage. It has optimal flow properties, allowing it to easily fill pores and cracks.

### Mixing Ratio (by VOLUME)

2:1 Powder to Liquid \*

### Pot Life

3 minutes

### Curing Time

Approximately 20 minutes \*

### Max. Curing Temperature

60 °C (140 °F)

### Durometer Hardness

90D

### Chemical Properties

Non-soluble in alcohol (cured)

Soluble in acetone (cured)

\* Optimum mixing ratio – may be modified for lower viscosity by increasing the volume of liquid; however, longer cure times will result.

### Eliminating Bubbles

Bubbles in the acrylic occur from agitation during mixing and outgassing that occurs as the temperature converts residue from liquid or solid into gas. Allied's pressure chambers work well to eliminate this occurrence, by preventing the formation of air bubbles during the curing process.

## WARNING!



**Refer to the SDS document for additional safety information.**

### Instructions:

- 1) To improve adhesion and product performance, degrease/clean the sample prior to mounting using acetone, isopropyl alcohol, or an ultrasonic cleaner. Air dry, or heat dry, to evaporate residual moisture.
- 2) Pour two (2) parts powder into a mixing cup and one (1) part liquid into another cup (do not use wax lined or paper cups).
- 3) Pour the POWDER into the LIQUID. Stir gently until the powder is fully saturated. If a thinner mixture is desired, more liquid can be added, but the cure time will increase.
- 4) Pour the mixture into the mounting cup over the sample and allow it to cure/harden.
- 5) If using a pressure chamber, place the mounting cup into the chamber, seal it, and fill with 25-30 psi. Let the sample fully cure under pressure.



Pressure Chamber