

## Grade: ARMC-631

**Manufacturer:** Aremco Products, Inc.  
**Description:** High performance epoxies for specialty bonding and potting applications to 400°F.

| PROPERTY                     | US VALUE                     |                               | METRIC VALUE    |                          |
|------------------------------|------------------------------|-------------------------------|-----------------|--------------------------|
| Mix Ratio by Weight          | <b>1:1</b>                   | resin:hardener                |                 |                          |
| Specific Gravity             | <b>1.24</b>                  | gms/cc                        |                 |                          |
| Mixed Viscosity              | <b>25,000</b>                | @ 25°C, cps                   |                 |                          |
| Pot Life                     | <b>4.0</b>                   | 100gm @ 25°C, hours           |                 |                          |
| Recommended Cure             | <b>2/200</b>                 | hours/°F                      | <b>2/93</b>     | hours/°C                 |
| Alternate Cure               | <b>24-48/RT</b>              | hours/°F                      | <b>24-48/RT</b> | hours/°C                 |
| Temperature Resistance       | <b>-85/400</b>               | °F                            | <b>-65/204</b>  | °C                       |
| CTE                          | <b>27</b>                    | in/in °F x 10 <sup>-6</sup>   | <b>49</b>       | Microns/m °C             |
| Thermal Conductivity         | <b>--</b>                    | BTU/(h.ft <sup>2</sup> °F/ft) | <b>--</b>       | W/(m <sup>2</sup> . K/m) |
| Tensile Strength             | <b>3000</b>                  | psi                           | <b>20.7</b>     | MPa                      |
| Flexural Strength            | <b>10200</b>                 | psi                           | <b>70.3</b>     | MPa                      |
| Volume Resistivity           | <b>1.2 x 10<sup>14</sup></b> | ohm-cm @ RT                   |                 |                          |
| Dielectric Strength          | <b>440</b>                   | volts/mil                     |                 | ac-kv/mm                 |
| Dielectric Constant at 1 MHz | <b>3.12</b>                  |                               |                 |                          |
| Dissipation Factor           | <b>.01</b>                   |                               |                 |                          |
| Chemical Resistance          | <b>Good</b>                  |                               |                 |                          |
| Color                        | <b>Clear Amber</b>           |                               |                 |                          |
| Hardness, Shore D            | <b>75</b>                    |                               |                 |                          |
| Cure Shrinkage               | <b>.002</b>                  | in/in                         |                 |                          |