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**Technical Data Sheet**  
**Optocast 3663-20k**  
**Thermal Cure Epoxy**  
Revision Date: 04/2002

## Introduction

Optocast 3663-20k is a single component thermally curable epoxy system designed specifically for use in opto/micro electronic assembly. It has a medium viscosity, good flow and wicking properties and superior water/humidity/solvent resistance.

### Uncured Properties

Appearance	Hazy amber liquid
Viscosity, cps, @25C	18,000-22,000(Sp#3; 10rpm; RVT)
% Solids	100
Shelf Life	3 months @RT; 1 year in refrigerator at <10°C
Specific Gravity	1.10-1.20
Flash Point	>200C
Vapor Pressure @20C	<0.25(Butyl Acetate=1.0)
Odor	None

### Suggested Cure Schedule

80-100C	30minutes
100-120C	20minutes
130-150C	10minutes

Optocast 3663-20k will be initiated upon exposure to temperatures above 80°C. Mass size, time and temperature will affect cure speed and adhesion; therefore experimentation will be necessary to reveal the best combination for a particular application.

### Cured Properties

Appearance	Clear Polymer
Hardness, Shore D	82-84
Tg	120°C
Temperature Range, C	-40-150
CTE, ppm/C	45-50
Elongation at break, %	~5.0

### Shipping and Storage

Optocast 3663-20k can be shipped at room temperature. Store at <10°C upon receiving for longer shelf life.

Good housekeeping rules are always important. Provide ample ventilation in all areas of handling, mixing and use. Avoid prolonged breathing of possible fumes. Minimize skin contact. Use of goggles, rubber gloves, and protective creams is recommended. Always wash exposed areas immediately using warm water and soap followed by rinsing with clear water. If material comes in contact with eyes, flush with clear water for fifteen minutes and consult a physician immediately. All data in the bulletin are based on our own research and the research of others. They are believed to be accurate. However, no guarantee of accuracy is made. Product description is sold without warranty except conformity to specification and on condition that the purchasers shall determine suitability for their particular purpose.

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