



WORK INSTRUCTION

Potting Chart

REVISION: 03

PROCEDURE NO.: WI-8.2.4.25

DATE EFFECTIVE: 05/29/20

Common Name	Part Number	Used With	Ratio/Usage
Stycast	Sea-103-103 (Catalyst)	SEA-103-104	1 to 4
Epoxy	SEA-103-117	A & B	1 to 1
Cement	SEA-101-101	Water	As Required
RTV (116-Self Level)	SEA-102-102	N/A	For HD Heaters
RTV (106)	SEA-102-105	N/A	For Castings
Silicone Conformal Coating (Clear)	SEA-104-101	N/A	As Required
Silicone SF99 Coating (Clear)	SEA-104-102	N/A	As Required
Huntsman Epoxy	SEA-103-118	SEA-103-119	1 to 1
Epoxy Lite	SEA-103-122	A & B	5 to 2
Polyester Resin (Toolcast 757 Resin)	SEA-109-101	SEA-109-102	12 to 1 (by volume)
RTV (108) 150 (Clear)	SEA-102-101	N/A	As Required
Epoxy	SEA-103-109 (EI-Cast)	Hardener 601	100 to 16



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REVISION HISTORY

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/25/09	All	Initial release
01	04/15/14	All	Added Epoxy Lite
02	10/30/14	All	Added Polyester Resin (SEA-109-101) and RTV 108 (SEA-102-101), changed Part Number SEA-103-112 to SEA-103-118, changed Part Number SEA-103-113 to SEA-103-119
03	05/29/20	All	Added Epoxy SEA-103-109 (EI-Cast) with 601 Hardener Redesigned Table and Document Layout

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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