

Starting Formulation

SF 7003

Rapid Curing Potting Compound

EPON™ Resin 828 / HELOXY™ Modifier 62 / EPIKURE™ Curing Agent 3271

Introduction This thermal shock resistant, epoxy compound is designed for potting preheated assemblies. It cures to handling strength in 2 to 3 minute cycles. Maximum properties, including 150 °C heat resistance, are achieved following a post cure of 60 minutes at 125 °C.

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Resin Portion				
	EPON Resin 828	Westlake Epoxy	83	8.60
	HELOXY Modifier 62	Westlake Epoxy	17	1.87
	DC-200 Fluid, 100 centistroke grade	Dow-Corning Corp.	0.007	0.0001
	Novacite 325 Silica	Malvern Minerals	130	5.89
	1/16-inch Milled Glass with epoxy compatible finish	Owens-Corning Fiberglass	<u>4</u>	<u>0.19</u>
			234.007	16.551
Converter Portion				
	EPIKURE Curing Agent 3271	Westlake Epoxy	11.4	1.33
	Aromatic Amine Eutectic ¹		<u>7.6</u>	<u>0.81</u>
			19.0	2.14

¹ A 60/40 blend of para, para'-diaminodiphenylmethane and metaphenylenediamine.

Compounding Procedure Resin Portion – Blend EPON Resin 828, HELOXY Modifier 62, and DC-200 air release agent to a homogeneous liquid under moderate speed agitation. Add the Novacite filler and milled glass and disperse thoroughly under high shear agitation.

Converter Portion – Preheat the aromatic amine eutectic to between 50 and 60 °C and agitate in the original container to redissolve any crystallized portion and restore the mixture to a homogeneous state. Combine with EPIKURE 3271 Curing Agent, blending under moderate speed agitation to a uniform composition. Store in tightly sealed metal or polyolefin plastic containers.

Potting Procedure Preheat the resin portion to 55 °C or higher for convenient pumping and handling. Proportion and mix the resin and converter in mechanical metering and dispensing equipment. The resin/converter ratio is 12.3:1 by weight and 7.7:1 by volume.

Preheat the mold cavity to 125 °C and fill with the mixed compound. Maintain the temperature for 2 to 3 minutes, then grind off any overfill. Post cure the units for 60

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minutes at 125°C to develop maximum thermal and physical strength properties.

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.westlakeepoxy.com

General Information

These are starting formulations and are not proven in the user's particular application but are simply meant to demonstrate the efficacy of the products and to assist in the development of the user's own formulation. It is the user's responsibility to fully-test and qualify the formulation, along with the ingredients, methods, applications or equipment identified herein ("Information"), by the user's knowledgeable formulator or scientist, and to determine the appropriate use conditions and legal restrictions, prior to use of any Information.

Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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Contact Information

For product prices, availability, or order placement, please contact customer service:

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