



- TECHNICAL DATA SHEET -

DOLPHON CR 1034

EPOXY RESIN PASTE

DESCRIPTION

DOLPHON CR-1034 is a two part, filled, red epoxy paste specially formulated for application by spatula, that cures at room temperature.

DOLPHON CR-1034 has the following outstanding features:

- Curing at room temperature.
- Hard coating, very resistant to chemicals.
- Thixotropic consistency.
- Low moisture absorption.
- Very good electrical properties.

CHARACTERISTICS

Physical properties	
Specific gravity at 25°C	1520±30 g/l
Consistency of resin + Reactor	Thixotropic
Tensile Strength, p.s.i. (ASTM D-368 - 60T)	7.900
Thermal conductivity (cal./sec./cm ² /°C/cm.)	9x10 ⁻⁴
Water absorption (ASTM D-570 -59at) after 24 h immersion into water	0,4%
Moisture vapor transmission at 38°C and 95% R.H. (gr./ft ² /24h./in./thickness)	0,3
Coefficient of Linear Thermal Expansion, in./in./°C (ASTM D-696-44)	5,6X10 ⁻⁵
Flexural strength, p.s.i. (ASTM D-790-59 T)	13.000
Compressive strength, p.s.i. (ASTM D. 695-54)	19.000

Electrical properties	
Dielectric Strength 1/8" section	390 Volts/ 0,025 mm.
Surface resistivity (ohms)	5,0x10 ¹²
Volume resistivity (ohm-cm)	6,5x10 ¹³
Dielectric constant, 60 cycles	3,60
Dielectric constant, 10 ⁶ cycles	3,45
Dissipation factor, 60 cycles	0,0040
Dissipation factor, 10 ⁶ cycles	0,0200

APPLICATION GUIDELINE

DOLPHON CR-1034 must be applied by means of a spatula. The slots and coils should be coated with an homogeneous layer of some millimeters.

For cleaning the laminations it is suggested to use a cloth soaked with xilene.

For obtaining a smooth and bright coating it is suggested to use a finger, protected by a rubber glove, wetting it with xilene or with another solvent for helping it to flow. DOLPHON CR 1034 after mixing with its reactor has a pot-life of 50 minutes about, so we suggest to prepare only the minimum necessary amount.



Preparation of the unit

- 1) Before encapsulation with DOLPHON CR-1034, the units should be impregnated with an HI-THERM varnish.
- 2) All metal parts should be clean and free of oil to insure good adhesion.

Mixing

Mixing of the resin and the reactor should be made carefully and slowly to avoid air incorporation. Stir thoroughly to insure a homogeneous mixture, scraping bottom and sides of the container. The recommended reactor, with the suggested mixing ratio, is the following:

Reactor	Parts of reactor per 100 parts of resin in weight	Temperature classification	Pot life at 20°C (100 grams)
RE-2000	5	B	60-90'

Cure

Reactor	Gelling time	Complete cure
RE-2000	3 - 4 hours at 20°C	24 hours at 20°C

After the initial gelling, the curing time can be accelerated by transferring the unit into the oven for 2 hours at 60-65°C.

STORAGE AND STABILITY

DOLPHON CR-1034 has shelf-life of 36 months when stored in its original closed containers at room temperature (max. 30°C).

HANDLING PRECAUTION

Use in well-ventilated area, wearing protective clothes. In case of contact with eyes and skin, wash immediately with water and soap. For more details, see the SDS.

Warning: All the information and application instructions concerning this product are based on technical specifications that we consider reliable, and are provided by way of example, according to our application experience. They do not establish any guarantee but only represent a starting point subject to alterations, according to the application and the kind of material to be treated. Before the product's use the user must determine the suitability for the intended use undertaking all risks and responsibility for whatever may happen in connection with the application. The producer and/or seller will not be considered responsible for any accident, loss or damage (immediate or consequent) originating from the use and/or the inability to use the concerned product. Albesiano Sisa Vernici srl reserves the right to change or modify at any time and without any notice the technical specifications of the product described in this data sheet.

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