

**Technical Data Sheet**

**Electronic & Engineering Materials**

## **EpoxyLite<sup>®</sup> E 8112 Hi Temp**

**Two-Component Epoxy Potting Compound**

**ELANTAS PDG, Inc.**  
5200 North Second Street  
St. Louis, MO 63147  
USA  
Tel +1 314 621-5700  
Fax +1 314 436-1030  
info.elantas.pdg@altana.com  
www.elantas.com

## Epoxylite® E 8112 Hi Temp Epoxy

### Product Description

Epoxylite® E 8112 Hi Temp Epoxy is a heat-cured, two-component system consisting of a viscous liquid resin and a finely divided powder hardener. It is provided in pre-measured kits.

### Areas of Application

Potting and sealing of electrical and electronic components requiring resistance to high temperatures

### Features and Benefits

- Maintains excellent electrical and physical properties to at least 260°C / 500°F
- Withstands temperatures in excess of 316°C / 600°F for short periods
- Excellent adhesion to metals, ceramics and most plastics
- Resistant to acids, alkalis and solvents.

### Application Methods

- Bench casting
- Vacuum casting

### Transportation / Storage

Store below 25°C / 77°F in a dry controlled environment out of direct sunlight. This material should be suitable for use stored under these conditions in the original sealed containers for six (6) months from the date of shipment.

Failure to store the product as recommended above may lead to deterioration in product performance.

This product is sensitive to moisture and atmospheric humidity. Containers, once opened, should be used immediately or blanketed with dry nitrogen before resealing.

Mix individual components thoroughly before use.

### Health / Safety

Refer to the Material Safety Data Sheet.

### Typical Properties of Material as Supplied

Property	Conditions	Value		Units
		Epoxylite® E 8112 Hi Temp Resin	Epoxylite® C 8112 Hi Temp Hardener	
Form	25°C / 77°F	viscous liquid	powder	
Weight per Gallon	25°C / 77°F	11.3 - 11.7	15.7 - 16.1	pounds
Flash Point	ASTM D93	> 94 > 201	> 94 > 201	°C °F
Mix Ratio	Parts by weight	100	50	

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### Mixing / Application

Best results will be obtained by warming the Resin to 65 – 85°C / 150 – 185°F before addition of the Hardener. This will lower the viscosity and facilitate release of bubbles.

**Do not use less than the pre-packaged amounts as the powdered Hardener may vary in composition within the container.**

Mix the Hardener into the warm Resin with mechanical agitation until homogeneous (approximately three minutes). Pot life of the mixture is 8 - 12 hours at room temperature, less at elevated temperature.

Mixed material that is not used immediately must be stored in a container free of air or blanketed with nitrogen. Pot life can be extended with refrigeration (5°C / 41°F) to several days or with freezing (-40°C / -40°F) to several months.

Refrigerated or frozen containers should be thawed to 16°C / 60°F or higher before opening to avoid moisture condensation.

NOTE: Proper surface preparation is critical to obtaining optimum product performance. See ELANTAS PDG Technical Bulletin TI-3000 *Surface Preparation Recommendations*.

EpoxyLite® E 8112 Hi Temp Epoxy is highly adhesive. Surfaces that may come into accidental contact with it during processing should be pretreated with a suitable release agent.

### Curing Schedule

Cure as follows:

16 hours at 93°C / 200°F    – or –  
4 hours at 121°C / 250°F    – or –  
1 hour at 177°C / 350°F    – or –  
30 minutes at 204°C / 400°F

Higher temperatures cures will exhibit higher shrinkage and should be avoided if this is a critical concern.

A post-cure of one hour at 204°C / 400°F should be used when the highest possible heat resistance is required.

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### Typical Mechanical Properties

Property	Method	Conditions	Value	Units
Hardness		Shore D	90	
Glass Transition Temp.	TMA		230	°C
Coefficient of Thermal Expansion	TMA	Below Tg	45	ppm / °C
Linear Shrinkage	ASTM D2566	100°C cure	2	%
Weight Loss	ASTM D3377	168 h at 180°C / 356°F	< 1	%

### Typical Electrical Properties

Property	Method	Conditions	Value	Units
Dielectric Strength	ASTM D149	25°C / 77°F – 125 mils	560	volts/mil
Dielectric Constant	ASTM D150	1 kHz – 25°C / 77°F	4.1	
Dissipation Factor	ASTM D150	1 kHz – 25°C / 77°F	0.06	
Volume Resistivity	ASTM D257	25°C / 77°F	1 x 10 <sup>16</sup>	ohm-cm

The above properties are typical values and are not intended for specification use.

ELANTAS PDG, Inc. warrants the chemical composition of its products within stated tolerances, but does not guarantee that a product will be appropriate for any particular application. Any recommendation, performance of tests or suggestion is offered merely as a guide and is not a substitute for a thorough evaluation by the user. No representative of ELANTAS PDG, Inc. has the authority to offer a warranty that a product will perform satisfactorily in manufacturing a product and no such representation should be relied upon.