

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022
262-253-5900 FAX 262-253-5919

DESCRIPTION:

Resinlab[®] *EP1295RC Black* is a medium viscosity, halogen free flame retardant epoxy casting resin system. *EP1295RC Black* was formulated to a 1A:1B by volume mix ratio for use in meter/mix and dispense equipment. As of the revision date, it is compliant to REACH and RoHS.

EP1295RC Black provides very good resistance to water, salt spray, inorganic acids and bases and most organic solvents. It cures quickly at room temperature to a tough, semi-rigid polymer. It has good wetting and adhesion to most surfaces and is free flowing to penetrate voids and release trapped air. It works well in very large mass potting and low stress applications.

EP1295RC Black will generally reach handle cure at room temperature within 16 to 24 hours depending upon mass and ambient temperature. Full cure usually achieved within 72 hours. Cure time can be accelerated by the application of heat after product has gelled. Times and temperatures from 3 hours at 65 °C to 1 hour at 100 °C are typical for most castings (less than 100 grams).

This formula contains soft, low-abrasion fillers which can separate over time, although they have good resistance to hard settling.

TYPICAL PROPERTIES:

All properties given are at 25 °C unless otherwise noted.

Property:	Value:	Test Method or Source:
Color	Black	Visual
Mix Ratio	Part A to Part B	Calculated
Mix Ratio by weight	1.04 to 1	
Mix Ratio by volume	1 to 1	
Cure Schedule	16-24 hrs @ 25 °C for handle cure 1 hr @ 100 °C 3 hrs @ 65 °C 72 hrs @ 25 °C	
Viscosity - Part A	14,200 cP	TA HR20 Rheometer 25mm parallel plate @
Viscosity - Part B	11,000 cP	1/s DCV6100723
Viscosity - Mixed	11,600 cP	
Specific Gravity - Part A	1.51	Calculated
Specific Gravity - Part B	1.44	
Specific Gravity - Mixed	1.47	
Pot Life defined as the time it takes for initial mixed viscosity to double	38 minutes	TA HR20 Rheometer parallel plate 25mm @ 1/s DCV6100723
Gel Time 100cc Sample	4 – 5 hours	455300005339/Gardco Gel Timer
Peak Exotherm	30 °C after 29 minutes	455300005593 by Type K thermocouple
Hardness	58 Shore D	455300006287/ASTM D2240

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Property:	Value:	Test Method or Source:
Glass Transition Temperature/Tg	3 °C	453560822409 by DSC
Water Absorption	0.15 %	24 hr immersion 457561824543/ASTM D570
Tensile Properties:		4535601224470/ASTM D638
Strength	990 psi	
Elongation	28 %	
Modulus	5,060 psi	
Lap Shear Strength		
0.010" Bond Line, Al to Al	1,200 psi	
Compressive Properties:		4535601224467/ASTM D695
Yield Strength	7,200 psi	
Modulus	19,000 psi	
Flame Resistance	Passes with V-0 Rating @ 6.0 mm	45376013225560/UL94V
Tested at ResinLab, not UL Certified		
Thermal Conductivity by Transient Plane Heat Source (TPS)	0.58 W/m.K	Thermtest TPS Hot Disk ISO 22007-2 45376013225604
Electrical Resistivity:		455300006612/ASTM D257
Volume	1.08 x 10 ¹⁵ ohm-cm	
Surface	2.26 x 10 ¹⁴ ohm/sq	
Dielectric Constant & Dissipation Factor:		455300006513/ASTM D150
@ 100 Hz	6.1, 0.1	
@ 100 kHz	4.7, 0.1	
AC Dielectric Strength	25 kV/mm	DCV6101609; ASTM D149 Method A, immersed in ASTM D3487 Type II Oil Specimen thickness was ~1-3 mm
Coefficient of Thermal Expansion by TMA:		455300005340/ASTM E831 TMA, 5 °C/min
below Tg	56 ppm/°C	
above Tg	169 ppm/°C	
Operating Temperature Range	-55 to 150 °C**	
Relative Thermal Index (RTI)	90 °C	UL746B, Table 7.1 Generic Value Based on Composition

* Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results.

** Operating Temperature Range is based on average design requirements and is not intended as a guarantee of suitability for all applications operating at that temperature.

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INSTRUCTIONS:

1. Bring to room temperature prior to use.
2. Cartridge format: Mixer should be attached keeping the cartridge vertical and any air pocket purged this way. After the mixer contains material, the mixer tip can be dropped to dispense pre-bleed amount. Attach a new static mixer with each cartridge, then pre-bleed the first 3 inches of dispensed material or until a uniform color is obtained. Maintain adequate velocity during dispensing to ensure complete mixing.
3. Bulk format: stir until homogeneous weigh and mix parts A and B accurately and thoroughly, scraping sides of container often. A power mixer is suggested such as a 500-1000 rpm device with a mix paddle sufficient to turn material and disperse any filler. Do not pour from mixing container, transfer to a new container as residual unmixed material may cause a tacky spot on the surface of the casting. Maintain adequate velocity during dispensing to ensure complete mixing.
4. Allow to cure undisturbed until product is fully gelled or tack-free to the touch.
5. Clean up uncured resin with suitable organic solvent such as MEK or acetone.

SHELF LIFE AND STORAGE:

6 months DOP at 25 °C in cartridges.

Store cartridges horizontally.

Invert cartridges every two weeks.

12 months at 25 °C in bulk packaging.

Specialty packaging may be less.

This system is prone to settling due to high filler content. Inventory should be rotated on a FIFO (first in, first out) basis.

Bulk containers should be inverted every two to three weeks to reduce the accumulation of the fillers on the bottom of the containers.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). Products in this state will not usually cure to normal and expected properties. In extreme cases it may appear solid and cured. Fluctuating temperatures (within 5 to 50 °C) aggravate this phenomenon. Heating the individual component to 50 to 60 °C while stirring can usually restore products to original state. Storage at 25 +/- 10 °C is optimum for most products.