

PROVISIONAL TDS

ER4002 Epoxy Resin

ER4002 is a two-part high performance encapsulation resin which has excellent electrical and high temperature performance. The resin is suitable for the encapsulation of delicate electronic and electrical components.

- High dielectric strength
- Excellent thermal conductivity
- Wide operation temperature range -40 to +150°C
- Ideal for applications with varying temperature

Approvals **RoHS-2 Compliant (2011/65/EU):** **Yes**

Typical Properties

Liquid Properties:

Base Material	Epoxy
Part A Viscosity (mPa s @ 23°C)	10000
Part B Viscosity (mPa s @ 23°C)	200
Mixed System Viscosity (mPa s @ 23°C)	3500
Mixed System Viscosity (mPa s @ 60°C)	500
Mix Ratio (Weight)	100:13
Mix Ratio (Volume)	4.43:1
Usable Life (23°C)	60 mins
Gel Time (23°C)	6 hours
Cure Time	80°C 1 hour +120°C 1 hour
Colour Part A - Resin	Black
Colour Part B - Hardener	Clear Liquid
Storage Conditions	Dry Conditions: Above 15°C, Below 35°C
Shelf Life	24 Months (bulk) 12 months (resin pack)

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Electrolube cannot be held responsible for the performance of its products within any application determined by the customer, who must satisfy themselves as to the suitability of the product.

Ashby Park, Coalfield Way,
Ashby de la Zouch,
Leicestershire LE65 1JR
T +44 (0)1530 419 600
F +44 (0)1530 416 640
BS EN ISO 9001:2008
Certificate No. FM 32082

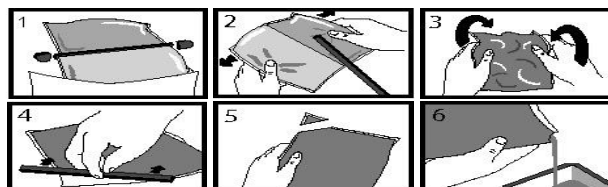
Cured System:

Thermal Conductivity (W/m.K)	1.2
Dielectric Strength (kV/mm)	20
Volume Resistivity (ohm-cm)	10 ¹⁵
Temperature Range (°C)	-40 to +150
Max Temperature Range (Short Term (°C)/30 mins)	+170
(Application and Geometry Dependent)	
Shore Hardness	D85
Colour (Mixed System)	Black
Flame Retardency	Yes

Mixing Procedures

Resin Packs

When in resin pack form, the resin and hardener are mixed by removing the clip and moving the contents around inside the pack until thoroughly mixed. To remove the clip, remove both end caps, grip each end of the pack and pull apart gently. By using the removed clip, take special care to push unmixed material from the corners of the pack. Mixing normally takes from two to four minutes depending on the skill of the operator and the size of the pack. Both the resin and hardener are evacuated prior to packing so the system is ready for use immediately after mixing. The corner may be cut from the pack so that it may be used as a simple dispenser.



Bulk Mixing

When mixing, care must be taken to avoid the introduction of excessive amounts of air. Automatic mixing equipment is available which will not only mix both the resin and hardener accurately in the correct ratio but do this without introducing air. Containers of Part A (Resin) and Part B (Hardener) should be kept sealed at all times when not in use to prevent the ingress of moisture. Bulk material must be thoroughly mixed before use. Incomplete mixing will result in erratic or partial curing.

General

Sedimentation of the resin has been minimised by careful attention to the formulation. However, any sediment which may have occurred over long periods of time must be dispersed before removing any material from the container. This dispersion can be carried out (if necessary) by stirring with a broad bladed spatula or gently rolling the can. Take care not to introduce excessive amounts of air during this operation or it may be necessary to re-evacuate the resin. Sedimentation will be accelerated by storage at high temperatures. Sedimentation found in resin packs forms no problem since the sediment is re-mixed when the pack is used.

Additional Information

- Cleaning:** It is far easier for machines & containers to be cleaned before the resin has been allowed to cure. Electrolube's RRS is suitable for cleaning machines and containers and cured resin may be slowly softened and removed by soaking in our RRS.
- Curing:** Do not heat cure large volumes immediately. Allow these to gel at room temperature and post-cure at high temperature if required (refer to liquid properties for details). Small volumes (250ml) may be heat cured immediately.
- Storage:** When storing under very cold conditions, the hardener may crystallise. If this occurs, simply warm (40°C) the container gently until all crystals have re-melted.
- Health & Safety:** Always refer to the Health & Safety data sheet before use. These can be downloaded from www.electrolube.com

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