

ER1452 Epoxy Resin

ER1452 is a fast curing epoxy resin with thixotropic properties. The cured product is tough and exhibits good adhesion to a variety of substrates.

- High viscosity; reduced flow to avoid resin migration and capillary action during processing
- Excellent adhesion to a wide variety of substrates; good thermal cycling characteristics
- Simple mix ratio and fast cure time; aids efficient production processes
- Good electrical properties and low water absorption

| Approvals | RoHS Compliant (2015/863/EU): UL Approval: | Yes No |
|--------------------|---|--|
| Liquid Properties: | Base Material | Epoxy |
| | Density Part A - Resin (g/ml) | 1.16 |
| | Density Part B - Hardener (g/ml) | 0.99 |
| | Mix Ratio (Weight) | 1.21:1 |
| | Mix Ratio (Volume) | 1.03:1 |
| | Mixed System Viscosity | Semi-thixotropic |
| | Gel Time (25°C) | 15-20 minutes |
| | Cure Time (25 °C) | 12 hours |
| | Cure Time (80 °C) | 2 hours |
| | Colour Part A - Resin | Semi-transparent liquid |
| | Colour Part B - Hardener | Amber to dark liquid |
| | Storage Conditions | Dry Conditions: Above 15°C, Below 35°C |
| | Shelf Life | 24 Months (Bulk) |
| Cured System: | Cured Density (g/ml) | 1.08 |
| | Temperature Range (°C) | -50 to +130 |
| | Max Temperature Range (Short Term (°C)/30 Mins) (Application and Geometry Dependent) | +150 |
| | Dielectric Strength (kV/mm) | 12 |
| | Volume Resistivity (ohm-cm) | 10 ¹⁴ |
| | Shore Hardness | D50 |
| | Colour (Mixed System) | Semi-Transparent Amber |
| | Loss Tangent @ 50 Hz | 0.01 |
| | Permittivity @ 50 Hz | 4.0 |
| | Water Absorption (9.7mm thick disk, 51mm diameter) 10 days @ 20°C / 1 hour @ 100°C | 0.5% / 1.0% |

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All information is given in good faith but without warranty. Properties are given as a guide only and should not be taken as a specification.

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

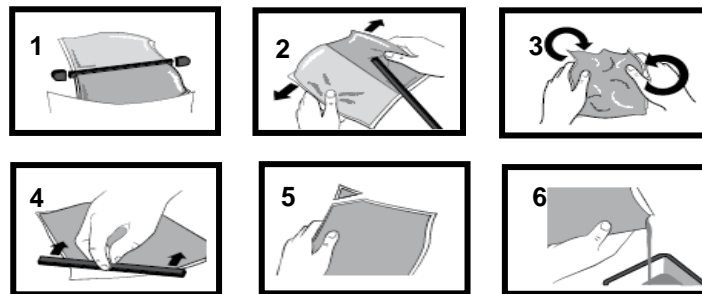
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BS EN ISO 9001:2008
 Certificate No. FM 32082

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 three 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. There is also a YouTube video ([Epoxy Mixing Instructions](#)) available on the Electrolube channel to show the mixing process.



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 or use of the wrong mix ratio will result in erratic or partial curing.

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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