



## Mixing Instructions

1. Clear impregnating compounds **771** and **781** – Need not be stirred prior to use. The others should be pre-mixed in the original container before using.
2. Preheat coil, transformer or unit for 1-2 hours @120°C -140°C. Allow to cool to approximately 50°C.
3. Any surfaces such as terminal leads or mounting brackets where bonding is impractical, should be coated with a suitable epoxy release agent.
4. Pour compound into unit or tank. If dipping application, units should be drained prior to curing.

## Cure Schedule

Dipped Units    6-8 hours @95°C - lowest shrinkage  
                           3-5 hours @105°C  
                           2-3 hours @120°C - for highest durometer

\* Post cure 2 hours @150°C for optimum high temperature properties.

Cast Units        8-10 hours @95°C plus 1-2 hours @105°C - 115°C -lowest shrinkage

## Blended Properties – Shore D Hardness

	<u>RATIO</u>				
	<u>100%</u>	<u>75/25</u>	<u>50/50</u>	<u>25/75</u>	<u>100%</u>
771/781	88	82	75-80	70	40
772/782	88	80-85	80-85	65-70	55-60

## Storage Requirements

One component epoxies are pre-catalyzed and have a limited shelf-life. Storage at elevated temperatures will result in a shortened shelf-life and premature gelation. Store material in a cool place.

**Date** 08/2006

### **IMPORTANT:**

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### **HEALTH CAUTION:**

Avoid breathing possible fumes, mists and vapors which can cause severe respiratory damage. Use of NIOSH approved breathing apparatus is required for more than minimal exposure. Always work in areas with adequate ventilation to allow dissipation of polyamine and other chemical fumes, and where applicable, solvent fumes. Use of goggles, protective garments, rubber gloves, protective cream is required. If material gets into eyes, flush thoroughly with clean water for twenty (20) minutes; then seek medical treatment. Avoid skin contact. Material can cause contact dermatitis. Always wash exposed areas immediately, using warm water and soap, followed by rinsing with clean water. Observe all safety precautions. It is important when using solvent based materials or solvents to keep away from open flame or ignition source.

**PLEASE REFER TO MATERIAL SAFETY DATA SHEET FOR FURTHER FIRST AID INFORMATION. FOR CHEMICAL EMERGENCY, CALL CHEMTREC (DAY OR NIGHT) 800 424-9300.**