

## ER1450 Epoxy Resin

ER1450 is a two-part, opaque white, low viscosity, fast curing epoxy resin. The cured product is tough and exhibits good adhesion to a variety of substrates.

- Good electrical properties; used for encapsulating radio frequency transmitter devices
- Low viscosity; ideal for applications with complex geometries and small spacing
- Good thermal cycling characteristics; offers stability in applications with temperature variables
- Fast curing system; suitable for high throughput applications

<b>Approvals</b>	<b>RoHS Compliant (2015/863/EU):</b>	<b>Yes</b>
	<b>UL Approval:</b>	<b>No</b>
Liquid Properties:	Base Material	Epoxy
	Density Part A - Resin (g/ml)	1.11
	Density Part B - Hardener (g/ml)	0.96
	Part A Viscosity (mPa s 23°C)	250
	Part B Viscosity (mPa s 23°C)	300
	Mix Ratio (Weight)	2.51:1
	Mix Ratio (Volume)	2.17:1
	Mixed System Viscosity (mPa s 23°C)	200
	Usable Life (20°C)	20 minutes
	Gel Time (25°C)	30 minutes
	Cure Time (25 °C)	12 hours
	Cure Time (50 °C)	2 hours
	Cure Time (80 °C)	30 minutes
	Colour Part A - Resin	White
	Colour Part B - Hardener	Amber
	Storage Conditions	Dry Conditions: Above 15°C, Below 35°C
	Shelf Life	12 Months (Resin packs – 18 months)
Cured System:	Cured Density (g/ml)	1.10
	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 <sup>14</sup>

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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.

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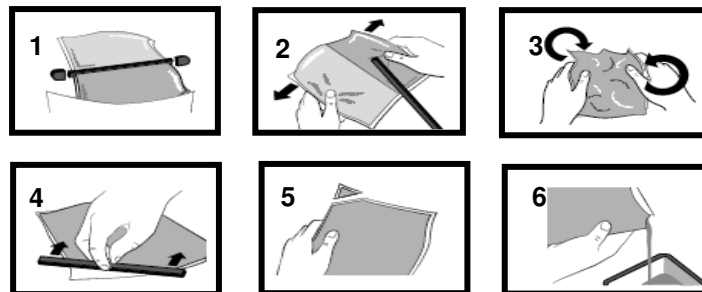
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Shore Hardness	D50
Colour (Mixed System)	White
Flame Retardancy	No
Coefficient of Expansion (ppm/°C)	75
Loss Tangent @ 10 kHz	0.08
Permittivity @ 10 kHz	4.7

## **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](http://www.electrolube.com)

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