

ER2218 Epoxy Resin

ER2218 is a low viscosity, flame retardant, two part potting and encapsulating compound. The product has been specifically designed for compatibility with reflow applications, therefore remaining stable for short term, high temperature excursions.

- Exceptionally low viscosity; ideal for applications with complex geometries or limited spacing
- Combines flame retardancy with ease of application; efficient potting processes
- Excellent thermal stability; can withstand short term excursions at high temperatures
- Does not contain abrasive fillers; low wear on dispensing machinery

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| Approvals | RoHS-2 Compliant (2011/65/EU): UL Approval: | Yes Meets UL94 V-0 |
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Typical Properties

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| Liquid Properties: | Base Material | Epoxy |
| | Density Part A - Resin (g/ml) | 1.22 |
| | Density Part B - Hardener (g/ml) | 0.96 |
| | Part A Viscosity (mPa s @ 20-23°C) | 800 |
| | Part B Viscosity (mPa s @ 20-23°C) | 400 |
| | Mixed System Viscosity (mPa s @ 20-23°C) | 500 |
| | Mix Ratio (Weight) | 3.58:1 |
| | Mix Ratio (Volume) | 2.82:1 |
| | Usable Life (20°C) | 40 minutes |
| | Gel Time (23°C) | 50 minutes |
| | Cure Time (23°C) | 24 hours |
| | Cure Time (60 °C) | 4 hours |
| | Cure Time (100 °C) | 30 minutes |
| | Colour Part A – Resin | Black |
| | Colour Part B – Hardener | Amber |
| | Storage Conditions | Dry Conditions: Above 15°C, Below 30°C |
| | Shelf Life | 24 Months (bulk) 18 months (resin pack) |
| | Exotherm | < 90°C |
| | (Measured on 100ml sample; cylinder of diameter 49.4mm @ 23°C) | |
| | Shrinkage | < 1% |

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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.

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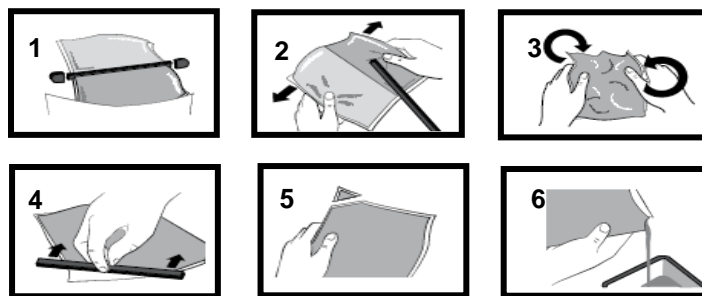
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| Cured System: | Thermal conductivity (W/m.K) | 0.35 |
| | Cured Density (g/ml) | 1.16 |
| | Temperature Range (°C) | -50 to +150 |
| | Max Temperature Range (Short Term (°C)/5 Mins) (Application and Geometry Dependent) | + 246 |
| | Dielectric Strength (kV/mm) | 10 |
| | Volume Resistivity (ohm-cm) | 10 ¹⁴ |
| | CTI (ASTM D3638-12) | 574V |
| | Shore Hardness | D55/A90 |
| | Colour (Mixed System) | Black |
| | Flame Retardancy | Yes |
| | Coefficient of thermal expansion (ppm/°C) | 80-100 |
| | Water Absorption (9.7mm thick disk, 51mm diameter) 10 days @ 20°C / 1 hour @ 100°C | < 1.5% / < 0.5% |

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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