TECHNICAL DATA SHEET

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DOLPHON® CC-1099

POLYESTER ROLL-THROUGH RESIN

PRODUCT DESCRIPTION

CC-1099 is a solventless polyester resin designed to offer fast cures and low build.

FEATURES & BENEFITS	
• Good bond strength at elevated temperatures. • Gives good penetration of fine wire sizes with conventional roll-through technologies.	• Non-bubbling. • Low build eliminates post cleaning.

TYPICAL APPLICATIONS		
• Alternator rotors • Alternator stators	• Generators • Armatures	• Electric motor stators

TYPICAL PROPERTIES - Physical

Color/Appearance	**Clear/Amber**
Film Build, ASTM D-115, mils/side,	**.5 - 1.0**
Gel Time @ 212°F (with 1% CA-2011), minutes	**10 - 15**
Weight (pounds/gallon)	**8.6 – 9.3**
Viscosity, @80°F, Brookfield Viscometer, Model RVT, #1 Spindle @ 10 RPM, cps	**35 - 85**
Viscosity, @ 80°F, #2 Zahn Cup, seconds	**22 - 27**

APPLICATION GUIDELINES

CC-1099 is applied through a roll-through process. Following is a suggested roll-through cycle for armatures weighing approximately five pounds.

Preparation of Unit

1. Preheat parts to 220^0F*.
2. Roll in catalyzed resin for one (1) revolution.
3. Drain two (2) minutes.
4. Bake for 30 minutes at 300^0F.*

*Temperatures were recorded on the laminations. (Winding temperatures should be 20-30^0 higher.)

Adding the Catalyst

CC-1099 must be catalyzed to achieve a cure. CA-2011 is the recommended catalyst. CA-2011 is a liquid, and one percent (1%) by weight is added to obtain a cure. Small quantities of the resin-catalyst mixture, generally a quantity sufficient for one day's run, should be made up.

CAUTION: To prevent rapid polymerization and potential fire hazard, be sure that the resin is at room temperature before you add the catalyst.

EQUIPMENT RECOMMENDATIONS AND PRECAUTIONS

To prevent overheating or gelation of CC-1099, tanks should be equipped with cooling coils to control resin temperature during roll-through process. CC-1099 will react with copper, copper alloys and natural rubber. Therefore, do not use these materials in the tank or recirculating system. Tanks should be constructed of black iron or stainless steel and flexible fittings should be made of synthetic rubber or plastic.

STORAGE AND SHELF LIFE

Shelf life of both the resin and reactor is 6 months from date of shipment from our plant, when stored at room temperature (70° / 21°C) or below.

1. Store in cool, dry place at 70°F/21°C or below.
2. Protect from direct sunlight and sources of heat
3. Keep away from heat, sparks and open flame.

SAFETY AND ENVIRONMENT

Avoid contact with skin and eyes. See Material Safety Data Sheet

AUTHORIZED DISTRIBUTOR

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