



TECHNICAL DATA SHEET

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DOLPHON[®] CR-1098

COIL COATING EPOXY RESIN

PRODUCT DESCRIPTION

Dolphon CR-1098 is a one package, flexible epoxy dipping compound designed to replace wrapping tape in the construction of field coils, toroids, transformers and other electrical components. Build up of this unique compound can be controlled by varying preheat temperature and/or immersion time, and the finished coating has maximum flexibility, toughness and cut through resistance.

FEATURES & BENEFITS

- Non-flammable
- Tough & flexible with high cut-thru resistance
- Excellent water, acid, alkali and chemical resistance
- Good adhesion
- Quick application and cure cycle
- Thermosetting

TYPICAL PROPERTIES

Physical

Color/Appearance	Red
Viscosity, Brookfield @ 77°F (25°C), ASTM D 2196, cps	7,000 – 13,000
Cure Time @ 325°F (163°C), minutes	15 - 30

Mechanical

Hardness, Shore A, ASTM D 2240	60 - 70
Tensile Strength, ASTM D 638, psi	2,500
Elongation, ASTM D 638, %	400

Electrical

Dielectric Strength, ASTM D115, volts/mil 20 – 30 mil films	350
Power Factor @ 25°C, ASTM D-150 @ 60 Hz @ 1000 Hz @ 1000 KHz	0.084 0.123 0.1
Volume Resistivity @ 50°C, ASTM D 257 megohm-cm	3 x 10³

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Chemical Resistance

Water	Excellent
Acid (10% Sulfuric Acid)	Excellent
Alkali (1% Sodium Hydroxide)	Excellent
Salt Water	Excellent

APPLICATION GUIDELINES

Preparation of Unit for CR-1098

1. Degrease unit to insure removal of all dirt and grease.
2. Preheat unit to 300°F to remove all moisture and cure holding tapes.

Mixing

CR-1098 is a one-package compound and must be slowly stirred prior to use to insure a homogeneous mixture.

Use

Dolphon CR-1098 is ideal for conveyor applications and produces consistent results on all units. For even uniform coverage, units should be removed from the dip tank at a constant rate. Listed below is a typical cycle:

1. Preheat unit to 300°F
2. Slowly dip into CR-1098
3. Immerse for 5-10 seconds
4. Remove at even rate of speed (4" per minute)
5. Immediately place in oven and cure with one of the following cycles

Note: by varying this cycle, the required amount of build up can be obtained as follows:

1. To obtain less buildup
 - a. Lower coil temperature, or
 - b. Shorten soak time in resin
2. To obtain heavier buildup,
 - a. Increase soak time in resin

Cure: 30 minutes @ 325°F, 1 hour @ 300°F

STORAGE AND SHELF LIFE

Shelf life (bulk) is six months from date of shipment from our plant, when stored in closed containers at 70°F/21°C or below.

1. Store in cool, dry place at 70°F/21°C or below, dip tanks must be kept cool with cooling coils or refrigeration.
2. Protect from direct sunlight and sources of heat
3. Keep away from heat, sparks and open flame.

AUTHORIZED DISTRIBUTOR

SAFETY AND ENVIRONMENT

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