

STAR Technology

FORMULATING • INNOVATIVE • SOLUTIONS

ER3311

One Part Secondary Insulating Epoxy

DESCRIPTION

ER3311 is a one part heat cure, electrical insulating epoxy designed for the impregnation of coils, transformers and other electrical items. ER3311 is extremely flexible upon cure and has excellent core noise and wire vibration reduction characteristics. ER3311 can be used as a potting resin, in dip and bake system or as a vacuum impregnating resin. ER3311 has excellent shelf stability; refrigerated storage will increase shelf life.

ER3311 is currently available in 1 gallon pails, 5 gallon pails, 55 gallon drums and 330 gallon totes.

Data contained herein are believed to be reliable. Fit-for-use testing should be conducted by each user.

BENEFITS

100% solids

High Build

TYPICAL PROPERTIES

	<u>TEST METHOD</u>	<u>VALUE</u>
Cure Time [150° C] (hours):		4
Gel Time [150° C] (minutes):		35
Film Build (mils):		5-10
Shore D Hardness:	ASTM D2240	40 - 50
Flash Point (° F):		> 200
Solids (%):		100
Dielectric Strength [20 mil] (V/mil):		850
Specific Gravity (g/cc):	ASTM D1475	1.59
Viscosity (cps)	ASTM D2393	
23°C:		22000
Color:		Black
Shelf Life (months):		6-12

To the best of our knowledge, the information contained herein is accurate. However, STAR TECHNOLOGY, Inc., does not assume any liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of the suitability of any material is the sole responsibility of the user. The information contained herein is considered typical properties and is not intended to be used as specifications for our products. This information is offered solely to assist purchaser in selecting the appropriate products for purchaser's own testing. All materials may present unknown hazards and should be used with caution. Although certain hazards are described herein and in the material safety data sheet, we cannot guarantee that these are the only hazards that exist. Repeated and prolonged exposure to epoxy resins can cause sensitization or other allergic responses.

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APPLICATION PROCEDURES

Vacuum method

Place transformer into an empty vacuum chamber and vacuum for 10 minutes to ensure transformer is completely dry. Fill vacuum chamber with pre-vacuumed ER3311, 2 inches over the laminations and vacuum for 10 minutes. Break the vacuum and allow the transformer to drain for 10 minutes. Cure the transformer for at least 4 hours at 150° C.

Dip Method

Place transformer into a 150° C oven for 2 – 3 hours to ensure the transformer is completely dry. Allow the transformer to cool to 50° C (do not place transformer that is heated warmer than 50° C into resin – heating the resin will result in a shortened shelf life). Place the cooled transformer into the ER3311, 2 inches over the laminations for 10 minutes or until all bubbling stops. Allow the transformer to drain for 10 minutes. Cure the transformer for at least 4 hours at 150° C.

Potting

Fill resin to desired level and cure part for 4 hours at 150°C.

PRECAUTIONS

For industrial use only. Keep away from children. Refer to the Material Safety Data Sheets (MSDS forms) pertaining to this product before using. Avoid contact with skin or eyes. In the event of an eye splash or contact, immediately flush with cold water for 15 minutes and contact a physician. If skin contact occurs, wash with mild soap and water. The wearing of safety glasses with side shields and impervious gloves is recommended.

RESIN AND HARDENER WARNING STATEMENT

May cause allergic skin reaction. Avoid all contact with skin, eyes, and clothing. Wash thoroughly after handling.