

# STAR Technology

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## ER7478

### High Build Impregnating Resin

#### DESCRIPTION

ER7478 is a single part heat cure epoxy designed for high build dip applications for transformers and armatures as well as a vacuum impregnation resin. ER7478 has a high build upon cure and has excellent noise reduction characteristics. Use brush, dip tank or automatic wet winding equipment for application. ER7478 has shelf life of 3 to 4 months; refrigerated storage will increase shelf life. ER7478 is currently available in 1 gallon pails, 5 gallon pails, 55 gallon drums and 330 gallon totes.

#### BENEFITS

100% solids  
DOT Non-hazardous  
High Build  
Highly Thixotropic

#### TYPICAL PROPERTIES

| TYPICAL PROPERTIES                 | TEST METHOD | VALUE   |
|------------------------------------|-------------|---------|
| Cure Time [150° C] (hours):        |             | 4-6     |
| Gel Time [150° C] (minutes):       |             | 10-12   |
| Film Build on Steel (mils):        |             | 2-3     |
| Helical Coil Bond Strength         |             |         |
| 25° C (N):                         | ASTM D2519  | 150.1   |
| 120° C (N):                        | ASTM D2519  | 18.32   |
| Glass Transition Temperature (°C): |             | 90      |
| Solids (%):                        |             | 100     |
| Specific Gravity (g/cc):           | ASTM D1475  | 1.12    |
| Viscosity (cps):                   | ASTM D2393  | 5500    |
| Color:                             |             | Natural |
| Shelf Life (months):               |             | 6       |

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: Preheat motor to 250° to 300°F for 3 hours. Place motor in empty vacuum chamber and apply dry vacuum of 1 to 5 millimeters of Hg for 1 hour. Insure that the part to be impregnated is 110° to 130°F, if part is below 110° F, repeat above steps to ensure part is at least 110°F. If part is above 130° F, allow time for cooling, do not introduce resin with a part warmer than 130° F.

Introduce the resin into the process tank and allow the resin to cover the part by 3 to 4 inches over the windings. Vacuum the part with 1 to 5 millimeters of Hg for 30 minutes. Pressurize the process tank to a pressure between 90 psi to 100 psi and keep motor under pressure for 1 hour.

Transfer the resin into the storage tank. After all the resin has been transferred, release the pressure on the process tank. Lift the motor and allow excess resin to drip from the part. Add motor to a preheated 310° F oven and bake motor for 4 to 6 hours based on motor size.

#### 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.

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