



# Technical Data Sheet

## NM EI Epoxi 960

Utg: 1994-06-30

Ers: 2011-05-03

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### General Description

**NM EI Epoxy 960** is a two component low-viscosity epoxy resin for casting and impregnation.

The resin is coloured dark blue.

The air-release when casted is normally very good, but encapsulation of coils might need use of vacuum.

### Processing Instructions

The mixture of components is very important, poor mixing may result in soft spots.

Mix thoroughly in a container, transfer the mixture into a clean container and mix further. Dosage should always be made on a scale with sufficient accuracy, especially if smaller portions shall be used.

If mixing a full pack, pour the hardener into the larger bottle of resin. Recap the bottle and shake for some minutes.

**Observe!** Do not leave any resin-mixture in the plastic bottle. The exothermic heat might melt the bottle.

### Surface Preparation

Film forming release agent is recommended, for example Marbocote 220. Wax-based release agents are normally not recommended and test should be performed before use of these types.

### Curing Time

Cure the cast mixture for at least 24 hours at 23°C. Curing at elevated temperature, for example +40°C, will reduce the time to eight hours.

Casting volumes exceeding 150 ml should cure at lowered temperature to avoid shrinking stress caused by high exothermic heat.

### Completion Work

A dry surface must be sanded to ensure adhesion to the next layer.

## Typical Properties

|                                       |  |
|---------------------------------------|--|
| <b>Resin</b>                          | NM EI Epoxi 960                            |
| <b>Hardener</b>                       | NM Härdare 980                             |
| <b>Mixing ratio:</b>                  |  |
| Resin – Hardener                      | 100 – 42.8 by weight<br>100 – 51 by volume |
| <i>Density:</i>                       | 1088 kg/m <sup>3</sup>                     |
| <i>Viscosity:</i>                     | 0.25 Pa·s                                  |
| <i>Solid content:</i>                 | 100%                                       |
| <i>Potlife 100 g 20°C:</i>            | 60 minutes                                 |
| <i>Hardness:</i>                      | 80 Shore D                                 |
| <i>Compressive strength:</i>          | 120 MPa                                    |
| <i>Pressure modulus:</i>              | 3.7 GPa                                    |
| <i>Tensile strength:</i>              | 50 MPa                                     |
| <i>Thermal expansion coefficient:</i> | 60·10 <sup>-6</sup> cm/cm·°C               |
| <i>Volume resistivity:</i>            | 10 <sup>15</sup> Ω·cm                      |
| <i>Dielectric constant, 50 Hz:</i>    | 4  |
| <i>HDT:</i>                           | 50°C                                       |
| <i>Tg:</i>                            | 45°C                                       |
| <i>Colour:</i>                        | Dark blue                                  |
| <i>Package size:</i>                  | 0.75 kg                                    |
| <i>Cleaning solvent:</i>              | Acetone                                    |

*Tensile strength measured according to ISO 527.*

*Compressive strength measured according to ISO R604*

*T<sub>g</sub> measured according to DSC.*

## Disclaimer

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