



# Technical Data Sheet

## NM Gjutharts 347

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Ers: 2014-05-15

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### General description

**NM Gjutharts 347** is a solvent-free elastic epoxy for potting components exposed to extreme temperature variations.

**NM Gjutharts 347** is available with two different curing agents, depending on the desired viscosity.

**NM Gjutharts 347** can also be colored white from the factory.

### Processing instructions

The mixture of the two components is very important. A poor mixing results in soft spots.

Mix thoroughly in a vessel, transfer the mixture into a clean vessel and mix again. Dosage should always be done with a scale with sufficient accuracy.

### Release agents

We recommend film forming release agents such as Marbocote 220.

Wax based release agents are generally not recommended. For this, tests are to be done first.

### Curing

**NM Gjutharts 347** cures at room temperature. The curing can be accelerated by curing at elevated temperature e.g. 5 hours at 50°C.

**NM Gjutharts 347** can be used in combination with our hardeners:

NM Härdare 175, low viscosity.

NM Härdare 348.

### Completion work

It is important to further treatment as laminating, filling, etc. is done when the surface is still tacky. A dry surface must be sanded to ensure adhesion for the next layer.

## Typical Properties

**Resin** NM Gjutharts 347

**Hardener** NM Härdare 175  
NM Härdare 348

### System NM Härdare 175

#### Mixing ratio

Resin – Hardener 100 – 88.6 by weight

Bas – Härdare 100 – 100 by volume

*Density:* 1052 kg/m<sup>3</sup>

*Viscosity 25°C:* 0.6 Pa·s

*Hardness:* approx. 80 shore A

*Potlife 100g 20°C:* 50 min

*Colour:* Transparent

*Normal packing:* 5.7 kg

### System NM Härdare 348

#### Mixing ratio

Bas – Härdare 100 – 132 by weight

*Density:* 1026 kg/m<sup>3</sup>

*Viscosity 25°C:* 1 Pa·s

*Hardness 20°C:* ca 80 shore A

*Potlife 100g 20°C:* 40 min

*Colour:* Transparent

*Normal packing:* 5.27 kg

*Cleaning solvent:* Acetone

## Disclaimer

This product's technical specifications are developed by experience in field and laboratory by us.

Fully cured will take place at seven days at +23°C and 50 % RF.

We reserve the right to change products as well as data. Current data sheets are available at our website and with us. We cannot assume responsibility for use in areas that we do not know. The user shall always evaluate products for their intended use and we guarantee only the material properties. For every product we offer reference objects separately.

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