

## ER2224 Epoxy Resin

ER2224 is a two-part filled epoxy encapsulation resin which has primarily been developed for encapsulation of electrical components. With its high thermal conductivity and excellent temperature stability, the product is ideal for dissipating heat in LED applications.

- High thermal conductivity; ideal for heat dissipation within LED applications
- Good environmental protection; offers good resistance to solvents and chemicals
- Wide operating temperature range; good high temperature stability
- Very low water absorption; good protection in high humidity conditions

<b>Approvals</b>	<b>RoHS Compliant (2015/863/EU):</b>	<b>Yes</b>
	<b>UL Approval:</b>	<b>No</b>

### Typical Properties

Liquid Properties:	Base Material	Epoxy
	Density Part A - Resin (g/ml)	2.32
	Density Part B - Hardener (g/ml)	0.95
	Part A Viscosity (mPa s @ 23°C)	130000
	Part B Viscosity (mPa s @ 23°C)	25
	Mixed System Viscosity (mPa s @ 23°C)	20000
	Mix Ratio (Weight)	14.6 : 1
	Mix Ratio (Volume)	5.85 : 1
	Usable Life (20°C)	45 mins
	Gel Time (23°C)	150 mins
	Cure Time (23°C)	24 hours
	Cure Time (60°C)	4 hours
	Cure Time (100°C)	1 hour
	Colour Part A - Resin	Off White
	Colour Part B - Hardener	Light yellow
	Storage Conditions	Dry Conditions: Above 15°C, Below 35°C
	Shelf Life	12 months
	Exotherm	<30°C
	(Measured on 100ml sample in a cylinder of diameter 49.4mm @ 23°C)	
	Shrinkage	<1%

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All information is given in good faith but without warranty. Properties are given as a guide only and should not be taken as a specification.

Electrolube cannot be held responsible for the performance of its products within any application determined by the customer, who must satisfy themselves as to the suitability of the product.

Ashby Park, Coalfield Way,  
Ashby de la Zouch,  
Leicestershire LE65 1JR

T +44 (0)1530 419 600

F +44 (0)1530 416 640

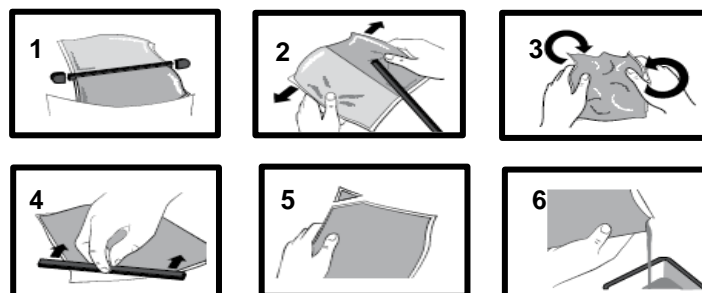
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Cured System:	Thermal Conductivity (W/m.K)	1.00
	Cured Density (g/ml)	2.13
	Temperature Range (°C)	-40 to +150
	Max Temperature Range (Short Term (°C)/30 mins) (Application and Geometry Dependent)	170°C
	Shore Hardness @ 25°C	D75
	Colour (Mixed System)	Off white
	Dielectric Strength (kV/mm)	10
	Volume Resistivity (ohm-cm)	10 <sup>15</sup>
	Flame Retardancy	No
	Water Absorption (10 days @ 20°C)	<0.1%
	Water Absorption (1 hour @ 100°C)	<0.2%

## **Mixing Procedures**

### **Resin Packs**

When in Resin pack form, the resin and hardener are mixed by removing the clip and moving the contents around inside the pack until thoroughly mixed. To remove the clip, remove both end caps, grip each end of the pack and pull apart gently. By using the removed clip, take special care to push unmixed material from the corners of the pack. Mixing normally takes from three to four minutes depending on the skill of the operator and the size of the pack. Both the resin and hardener are evacuated prior to packing so the system is ready for use immediately after mixing. The corner may be cut from the pack so that it may be used as a simple dispenser. There is also a YouTube video ([Epoxy Mixing Instructions](#)) available on the Electrolube channel to show the mixing process.



### **Bulk Mixing**

When mixing, care must be taken to avoid the introduction of excessive amounts of air. Automatic mixing equipment is available which will not only mix both the resin and hardener accurately in the correct ratio but do this without introducing air. Containers of Part A (Resin) and Part B (Hardener) should be kept sealed at all times when not in use to prevent the ingress of moisture. Bulk material must be thoroughly mixed before use. Incomplete mixing or use of the wrong mix ratio will result in erratic or partial curing.

### **General**

Sedimentation of the resin has been minimised by careful attention to the formulation. However, any sediment which may have occurred over long periods of time must be dispersed before removing any material from the container. This dispersion can be carried out (if necessary) by stirring with a broad bladed spatula or gently rolling the can. Take care not to introduce excessive amounts of air during this operation or it may be necessary to re-evacuate the resin. Sedimentation will be accelerated by storage at high temperatures. Sedimentation found in resin packs forms no problem since the sediment is re-mixed when the pack is used.

### **Additional Information**

- Cleaning:** It is far easier for machines & containers to be cleaned before the resin has been allowed to cure. Electrolube's RRS is suitable for cleaning machines and containers and cured resin may be slowly softened and removed by soaking in our RRS.
- Curing:** Do not heat cure large volumes immediately. Allow these to gel at room temperature and post-cure at high temperature if required (refer to liquid properties for details). Small volumes (250ml) may be heat cured immediately.
- Storage:** When storing under very cold conditions, the hardener may crystallise. If this occurs, simply warm (40°C) the container gently until all crystals have re-melted.
- Health & Safety:** Always refer to the Health & Safety data sheet before use. These can be downloaded from [www.electrolube.com](http://www.electrolube.com)

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