HUNTSMAN

Enriching lives through innovation

Advanced Materials

Araldite® DBF	**100**	**pbw**
Aradur® HY 842	**40**	**pbw**

Low viscosity, unfilled epoxy casting resin system, curing at room temperature.
High filler addition possibility.

Application	Encapsulating or potting of low voltage and electronic components.
Processing methods	Casting, vacuum casting.
Key Properties	Good heat resistance. Good resistance to atmospheric and chemical degradation.

Product Data (Guideline Values)

Araldite® DBF

Liquid epoxy resin modified by the addition of a plasticizer.

Viscosity at 25°C	ISO 2555	mPa*s	1350 – 2000*
Specific Gravity at 25°C	ISO 2811	g/cm³	1.15
Appearance	Visual		Clear liquid*
Epoxy content	ISO 3001	Eq/kg	4.20 – 4.35*

Aradur® HY 842

Low-viscosity polyamidoamine.

Viscosity at 25°C	ISO 3219	mPa*s	400 – 700*
Specific gravity at 20°C	ISSO 2811	g/cm³	0.95
Appearance	Visual		Clear liquid*

*Specified range

Processing Data (Guideline Values)

Mix Ratio

		Parts by weight	Parts by volume
Araldite DBF	Resin	100	100
HY 842	Hardener	40	48

Gel Time, Viscosity and Curing

Mix Viscosity at 25°C	Araldite DBF / HY 842	Rheomat	mPa*s	1400
Mix Viscosity at 40°C				550
Pot life at 25°C	Araldite DBF / HY 842	Time to reach 5000 mPa*s	min	129
		Time to reach 15000 mPa*s	min	202
Pot life at 40°C	Araldite DBF / HY 842	Time to reach 5000 mPa*s	min	83
		Time to reach 15000 mPa*s	min	112
Gel time at 40°C	Araldite DBF / HY 842	Gelnorm	min	134
Gel time at 60°C		Gelnorm	min	47
Minimum Curing Cycle		24 - 48 hours at RT or 4 h at RT + 4 h at 60°C		

Processing and Storage (Guideline Values)

Mixing

Measure (by weight or volume) the Araldite resin and the hardener. Add the hardener to the Araldite resin; making sure that the required amount of hardener is transferred to the resin. Stir thoroughly until mixing is complete.
Air entrainment during mixing results in pores in the cured resin. Mixing under vacuum or in a metering-mixing machine is the most effective way to prevent air entrainment. Alternatively the static resin – hardener mixture may be deaerated in a vacuum chamber – allowing at least 200 % ullage for the foam to expand.

Curing

The chemical reaction initiated by mixing resin and hardener results in the generation of exothermic heat. The peak temperatures attained are determined by the starting temperature and the size and shape of the casting. Unfilled resin systems are suitable only for manufacturing castings weighing up to about 500 grams. Mineral filler should be added to dissipate heat and damp the exothermic reaction when producing large castings.

There is very little exothermic reaction when producing very small castings or thin layers as the heat generated is rapidly dissipated. Cure is consequently delayed and the surfaces of castings may remain tacky. In such cases an infrared heater or oven at 40 °C – 60 °C should be used to effect full cure.

When casting thick sections special care is needed to avoid excessive exothermic temperature rise.
Short high-temperature curing schedules should not be used unless preliminary trials with castings manufactured to the specific design, and in the specified moulds, produce no unacceptable exothermic effects.

To determine whether cross-linking has been carried to completion and the final properties are optimal, it is necessary to carry out relevant measurements on the actual object or to measure the glass transition temperature. Different gel and cure cycles in the customer's manufacturing process could lead to a different degree of cross-linking and thus a different glass transition temperature.

Storage Conditions

Store the components in a dry place according to the storage conditions stated on the label in tightly sealed original containers. Under these conditions, the shelf life will correspond to the expiry date stated on the label. After this date, the product may be processed only after reanalysis. Partly emptied containers should be tightly closed immediately after use.
For information on waste disposal and hazardous products of decomposition in the event of a fire, refer to the Material Safety Data Sheets (MSDS) for these particular products.

Mechanical and Physical Properties (Guideline Values)

Determined on standard test specimen at 23°C. Cured for 6 hours at RT + 6 hours at 60°C.

Color of casting			Yellow - brown
Density	ISO 1183	g/cm^3	1.1
Glass transition temperature (DSC)	ISO 11357-2	°C	37
Flexural strength	ISO 178	MPa	19.5
Flexural modulus	ISO 178	MPa	320
Hardness	ISO 868	Shore D	64
Tensile strength	ISO 527	MPa	17.6
Elongation at break	ISO 527	%	31
Tensile modulus	ISO 527	MPa	372
Impact strength	ISO 179	kJ/m^2	44
Water absorption	ISO 62		
10 day at 23°C 30 min at 100°C		% by wt.	1.04 0.54

Electrical Properties (Guideline Values)

Determined on standard test specimen at 23°C. Cured for 6 hours at RT + 6 hours at 60°C.

Dielectric strength (2 mm specimen)	IEC 60243-1	kV/mm	24
Dielectric loss factor (tan δ, 50Hz, 25°C)	IEC 60250	%	5.2
Dielectric constant (εr, 50Hz, 25°C)	IEC 60250		4.8
Volume resistivity (ρ, 25°C)	IEC 60093	Ω cm	9×10^{13}
Tracking resistance	IEC 112/79	CTI	> 600 - 0.4
Electrolytic corrosion	IEC 60426	grade	A-1

Legal Notice

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