ER4002
Epoxy Resin

ER4002 is a two-part high performance encapsulation resin which has excellent electrical and high temperature performance. The resin is suitable for the encapsulation of delicate electronic and electrical components.

- High dielectric strength
- Excellent thermal conductivity
- Wide operation temperature range -40 to +150°C
- Ideal for applications with varying temperature

Approvals RoHS-2 Compliant (2011/65/EU): Yes

Typical Properties

Liquid Properties:

Base Material Epoxy
Part A Viscosity (mPa s @ 23°C) 10000
Part B Viscosity (mPa s @ 23°C) 200
Mixed System Viscosity (mPa s @ 23°C) 3500
Mixed System Viscosity (mPa s @ 60°C) 500
Mix Ratio (Weight) 100:13
Mix Ratio (Volume) 4.43:1
Usable Life (23°C) 60 mins
Gel Time (23°C) 6 hours
Cure Time 80°C 1 hour +120°C 1 hour
Colour Part A - Resin Black
Colour Part B - Hardener Clear Liquid
Storage Conditions Dry Conditions: Above 15°C, Below 35°C
Shelf Life 24 Months (bulk) 12 months (resin pack)
Cured System:

- Thermal Conductivity (W/m.K): 1.2
- Dielectric Strength (kV/mm): 20
- Volume Resistivity (ohm-cm): 10^15
- Temperature Range (°C): -40 to +150
- Max Temperature Range (Short Term °C/30 mins): +170
- Shore Hardness: D85
- Colour (Mixed System): Black
- Flame Retardancy: Yes

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 two 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.

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 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