

Key Features

RE33/HE33 (CLF) is a flexible polyether polyol clear casting system that is used for the encapsulation of electrical components. This product is flexible but can be extracted from the encapsulated component when required.

Physical and Mechanical Properties

	<u>PART A</u>	<u>PART B</u>	
	RE33	HE33	HE33 CLF
	Part A (Resin)	Part B (Hardener)	Part B (Hardener)
Mix Ratio (Weight)	100 p.b.w.	8 p.b.w	10.3 p.b.w
Viscosity cps @ 25°C	700 - 1300	<250	300-1000
Density @ 25°C	1.00 (±0.02)	1.20 (± 0.02)	1.20 (± 0.02)
Appearance	Clear viscous liquid	Clear, Light yellow liquid, (no crystals)	Clear to slightly cloudy, yellow liquid (no crystals)
Potlife @ 25°C (300g)		±20 minutes	±15 minutes
Demould Time @ 25°C (300g)		±45 minutes	±30 minutes
Shore A hardness		±38	33-40
Dielectric strength (ASTM D149) Voltage @ 30Hz		16.5 KV/mm	16.5 KV/mm

Processing

Thorough mixing of the components is essential before dispensing into the mould.

To obtain the correct pot life and Shore hardness the product is typically cast with both components at 25°C into a mould at ambient temperatures (20 - 25°C).

Pot life and demould time will decrease as:
 resin/mould temperatures are increased (70-90°C) and
 the mass of the total casting is increased.

Winter conditions:

The Part B may form crystals when stored at low ambient temperatures (below 15 - 20°C). In this case, the product must be heated to 60 - 70°C for the crystals to melt and then cooled down to 25°C before use. When Part B has been melted, it should be used as soon as possible. Do not heat Part B in excess of 70°C or store at 60° - 70°C for prolonged periods of time.

Storage and stability

RE33 Polyol is hygroscopic and must be stored in well-sealed containers at ambient temperatures of between 20-25°C, away from direct sunlight. Containers must be sealed after use.

HE33 (CLF) is a diisocyanate and will react with moisture generating carbon dioxide. HE33 (CLF) has a shelf life of 6 months. Containers must therefore be tightly resealed after use to minimize moisture absorption. Using a “Gas-Blanket” is recommended.

Safety & Handling

RE33/HE33 (CLF) must be handled with care. Keep away from foodstuffs and handle with appropriate protective clothing. Inhalation of fumes must be strictly avoided, and protective mask should be worn in a well-ventilated area. The safety procedures applicable to handling urethane raw materials must be read, understood and strictly adhered to.

Packaging

RE33	HE33	HE33 CLF
1 KG	0.08 KG	0.103 KG
5 KG	0.4 KG	0.515 KG
25 KG	2 KG	2.575 KG

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