

Electrical casting resin

Description

RAKU-PUR 21-2360-1 casting resin is polyurethane based, solvent-free, pourable two-component system. It consists of a filled resin (component A) and an MDI hardener (component B).

It is characterized by:

- Low mixture viscosity.
- High thermal endurance.
- High thermal conductivity.
- Low water absorption and good hydrolysis resistance.
- Free of halogen flame retardants.
- Flammability UL 94 V0 1,5 mm File 111148.
- The use of non-abrasive fillers allows for use of standard two component mixing and dispensing machines.
- RoHS compliant.

Application

The system is particularly suitable for the encapsulation of electrical and electronic parts e.g. electronic circuits, transformer, inverter.

Processing

Before use, component A should be well stirred, since the filler is can be prone to sedimentation. In case of manual processing, one should ensure careful mixing after introducing the hardener while preventing the inclusion of air.

Raw material data

	Unit	RAKU-PUR [®] 21-2360-1 A	RAKU-PUR [®] 21-2360-1 B
Viscosity at 20 °C	mPa*s	9,000	190
Spec. gravity at 20 °C	g/ml	1.72	1.23
Color		Black	Brown

Processing data

	Unit	Value
Mixing ratio, by weight A : B	PbW	100 : 15
Mixing ratio, by volume A : B	PbV	100 : 21
Mixture viscosity at 20 °C	mPa*s	2,800
Processing temperature	°C	at least 18
Pot life at 20 °C	Min.	38

Processing under vacuum

The casting resin is ready to be applied under vacuum. The necessary process parameters must be determined in cooperation with the plant manufacturer.

Hardening conditions

After the end of the working life, the curing process results first of all in gelling and then in solidification of the casting resin. Finally, a dimensionally stable body is formed, the mechanical strength of which allows it to be removed from the mould.

The curing process is only completed if no longer curing time due to lead to a step of e.g. the mechanical properties, or an increase in the glass transition temperature.

Curing takes place at mould temperatures of 20 - 60 °C. Post curing above the glass transition temperature is necessary to achieve the final material properties.

Mechanical properties

Spec. gravity	RPV-4	g/ml	1,68
Hardness	RPV-10	Shore D	71
Tensile strength	DIN EN ISO 527-2	MPa	8
Elongation	DIN EN ISO 527-2	%	63
High Current Arc Ignition (HAI)	UL 746 A	Stage / mm	PLC 0 / 1.5 mm
Hot-Wire Ignition (HWI)	UL 746 A	Stage / mm	PLC 0 / 1.5 mm
Glow-Wire Flammability (GWFI)	IEC 60695-2-12	°C / mm	960 / 1.5 mm
Glow-Wire Ignition (GWIT)	IEC 60695-2-13	°C / mm	825 / 1.5 mm
Flammability	UL 94	Level / mm	V0 / 1.5 mm

at 20°C

Thermal mechanical properties

Thermal linear coefficient (30 – 80°C)	ISO 11359	10 ⁻⁶ /K	74 - 112
Glass transition temperature (DSC)	ISO 11357	°C	10
Thermal conductivity	ASTM D 5930	W/(m*K)	1,09
Operating temperature	-	°C	-40 to +130

Electrical properties

Dielectric strength	IEC 60243.1	kV/mm	29
Dielectric constant at 20 °C and 50 Hz	IEC 60250		6,0
Dielectric loss factor at 20 °C and 50 Hz	IEC 60250		0.09
Volume resistivity	IEC 60093	Ω*cm	5.0*10 ¹²

Storage

Original packaging can be stored at temperature between (18 °C - 25 °C) for six months. Both components are moisture-sensitive and should therefore be kept tightly closed.

Standard packaging

	Component A	Component B
Drum	300 kg	250 kg
Pail / Can	30 kg	30 kg

Occupational Health and safety at work

Good workplace ventilation is to be ensured during processing. At the same time, the hygiene regulations set up by occupational insurance association regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the relevant safety data sheets.