

## PX700K-1

A general-purpose flame retardant potting and encapsulating compound

### Application

- High Voltage Transformer
- Circuit board
- High voltage capacitors
- Devices
- Security

### Key Properties

- Good thermal conductivity
- High electrical insulating characteristics
- High adhesion
- Low shrinkage
- UL94 V-0 @ 1.5mm
- Excellent chemical & water resistance
- Does not contain halogens or heavy metals

### Description

- Basic Two-component epoxy system
- Resin RX700K-1
- Hardener HX700K

Physical Data (approx. – values)	Resin	Hardener	Composite
Colour	Black	Amber	Black
Specific Gravity	1.78	1.01	1.66
Viscosity (mPas) @ 25°C	50000-80000	350	5000-9000

Cure Schedule (150ml)	Working Life	Gel Time	Light Handling	Full Cure
Temperature	(minutes)	(minutes)	(hours)	(hours)
RT	120	150-220	24	168
60°C	20	30-40	2	4
80°C	10	40	1	2

\*RT is defined as 20-25°C

The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects. For maximum properties a post cure may be required – Contact our technical service department for advice.

### Processing

Mix ratio by weight 9.36: 1  
Mix ratio by volume 5.29: 1

Typical Properties	Result	Unit
Peak Exotherm (150g @ 25°C)	40	°C
Shrinkage (Volume)	0.3	%
Thermal conductivity	1.00	W/mK
Thermal expansion	40-50	
Operating temperature range	-40 to +150	°C (application & geometry dependent)
Dielectric strength	18	kV/mm
Volume Resistivity	10 x 10 <sup>12</sup>	ohm.cm
Hardness	70-80	Shore D
Flame Retardancy	@ 1.5mm	UL94 V-0
Tensile strength	7.6	MPa
Tensile Modulus	121	MPa
Compressive strength	90	MPa
Deflection temperature	50	°C
Co-efficient of expansion	40 - 50	ppm/°C
Loss Tangent	0.060	50 Hz
Permittivity	4.8	50 Hz
Comparative tracking index	>850	V (Method IEC 60112)
Water absorption (30 days @ 20°C)	0.4	%
Elongation at break	10	%
Oxygen index	38	
Flexural strength	15.1	MPa
Flexural Modulus	155	MPa
Tg	80-100	°C

Approvals	
RoHS compliant	Yes
UL94 V-0	UL file number E76072
REACH (SVHC concentration)	Refer to SDS

## Packaging

PX700K-1 is available in Bulk, Twinpacks, kits and sets

## Availability

Available through distribution and [www.resins-online.com](http://www.resins-online.com) [sales@robnor.co.uk](mailto:sales@robnor.co.uk)

## Twinpacks Part Numbers

PX700K-1/BK/050	PX700K-1/BK/500
PX700K-1/BK/100	PX700K-1/BK/1000
PX700K-1/BK/250	

Twinpacks are pre-weighed resin and hardener components contained in a tough flexible film, separated by a removable clip and rail. Once the clip and rail is removed the resin and hardener is thoroughly mixed within the bag and is immediately ready for use. Mixing will normally take ~ 2 minutes due to the viscosity; but pay special attention to the corners. Twinpacks are ideal for small to medium production runs, prototyping and on-site or field use. The twinpack weight/volume may also be tailored to a specific size on request.

For further details please visit [www.robnor-resinlab.com](http://www.robnor-resinlab.com)

## Bulk Materials Part Numbers

RX700K-1/BK/5KG	HX700K/NC/5KG
RX700K-1/BK/10KG	
RX700K-1/BK/25KG	

Both resin and hardener are supplied in 5kg, 25kg and 200ltr drums and fully evacuated and ready for use.

Care should be taken to ensure when mixing the resins air is not entrained in the mixture. If this is unavoidable the mixed resin and hardener should be re-evacuated before dispensing. The bulk resin and hardener materials can be dispensed from suitable dispensing machinery, details provided by Fluid Research on request.

## Kits and Sets Part Numbers

PX700K-1/BK/5KGKIT	PX700K-1/BK/20KGSET
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Kits and Sets are provided in separate containers to the correct ratio.

In Kit form, pour the contents of the smaller container into the larger container and use it as a mixing vessel.

Stir well using an appropriate mixer until homogeneous.

Note: Incomplete mixing will be characterised by erratic or partially incomplete cure even after extended time periods.

## Cleaning

All equipment contaminated with mixed material should be cleaned before the material has hardened. TS130 is a suitable non-flammable cleaning agent, although other solvents may be found suitable. TS130 will also remove cured material provided it can soak for several hours.

## Shelf-life and Storage

12 months at 25 °C Specialty packaging may be less.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). Products in this state will not usually cure to normal and expected properties. In extreme cases it may appear solid and cured. Fluctuating temperatures (within 5 to 50 °C) aggravate this phenomenon. Heating the individual component to 50 to 60 °C while stirring can usually restore products to original state. Storage at 25 +/- 10 °C is optimum for most products

Some epoxy systems are prone to settling due to high filler content and should be inverted every two to three weeks to reduce the accumulation of the fillers on the bottom of the containers.

Inventory should be rotated on a FIFO (first in, first out) basis.

## Health and Safety

Please refer to RX/HX700K-1 Health and Safety data or our Technical Service Department for individual/specific advice.

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The results and information above does not constitute a specification and is given in good faith and without warranty. The information is derived from test/or extrapolations believed to be reliable and is quoted for guidance only. The product is offered for evaluation on the understanding the customer satisfies himself that the product is suitable for the intended application by proper evaluation and testing.

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