



“Our strength is in our formulations”

TECHNICAL BULLETIN:

CLR 1837 / XHD 1409

DESCRIPTION: A TWO COMPONENT, HEAT CURE, TOUGH EPOXY CASTING COMPOUND. THE PRODUCT WAS SPECIFICALLY DEVELOPED FOR CASTING INSULATORS, INSTRUMENT AND POWER TRANSFORMERS. THE CURED MATERIAL EXHIBITS EXCELLENT THERMAL STABILITY.

SALES SPECIFICATION:

CLR 1837

XHD 1409

COLOR
VISCOSITY (NOTE 1)
SPECIFIC GRAVITY
SHELF LIFE

RED
90,000 cps @70°C
1.90+/-0.05 gm/cm³
12 MONTHS

DARK AMBER
4,000 cps @ 22°C
0.99+/-0.2 gm/cm³ @ 22°C
12 MONTHS

HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 1)
MIXED VISCOSITY

100:11.5
40,000 cps @ 60°C
12,000 cps @ 70°C
10-15 minutes @ 70°C
30-40 minutes @ 70°C

POT LIFE (600 gms)
GEL TIME (600gms.)

CURE SCHEDULE: (NOTE 3)

RECOMMENDED CURE SCHEDULE

2 hours @ 80°C
+ 3 hours @ 150°C

CURED PROPERTIES: (not intended for preparation of specifications)

COLOUR
DENSITY / SPECIFIC GRAVITY
SHORE HARDNESS
HDT (ASTM D 648)
THERMAL EXPANSION COEFFICIENT (IN/IN⁰C X 10⁻⁶)

RED
1.8 gm/cm³
87D
>150°C
25

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NOTES:

- 1) If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.
- 2) The mix ratio must be within $\pm 2\%$ of the stated value and thorough mixing is required to avoid degraded properties.
- 3) Other cure schedules may yield satisfactory results however; these should be determined by the customer for his given application.
- 4) Unless otherwise specified, all measurements are taken at 22⁰C.
- 5) These products may trigger allergic reactions in some individuals. Prevent contact with skin; wash with plenty of soap and water if contact occurs and **Read the Material Safety Data Sheet** before using the materials. **Do Not Breathe Vapours** provide good ventilation and exercise good housekeeping at the work area.
- 6) If indicated, the values under “**Electrical Characteristics**” may be based on supplier data for products with similar compositions. They are provided only as a guide and the recipient must test each material to determine its suitability for the intended application.
- 7) If stated, the “**Guide to Operating Temperature**” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of a product for a particular operating temperature is application dependent and **may change according to the demands placed upon it in service.**

IMPORTANT

THE INFORMATION IN THIS BULLETIN IS BASED ON DATA OBTAINED BY OUR OWN RESEARCH AND IS CONSIDERED ACCURATE. ALL INFORMATION SUPPLIED BY CROSSLINK TECHNOLOGY INC., IS FURNISHED UPON THE EXPRESS CONDITION THAT THE PERSON RECEIVING THE PRODUCT SHALL MAKE THEIR OWN ASSESMENTS TO DETERMINE ITS SUITABILITY FOR THEIR PARTICULAR PURPOSE. NO WARRANTY IS EXPRESSED OR IMPLIED REGARDING SUCH INFORMATION, OR THE RESULTS TO BE OBTAINED FROM THE USE THEREOF; THAT ANY PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE; OR THAT THE USE OF SUCH OTHER INFORMATION OR PRODUCT WILL NOT INFRINGE ANY PATENT.

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