

TECHNIREZ R1025 is a pre-filled, solvent free, epoxy casting resin specifically designed for use with H1026 and H2407 hardeners that will cure at ambient temperature, to produce a hard resilient casting that exhibits excellent mechanical and electrical properties.

R1025 was formulated for use in the electrical industry for the encapsulation of instrument transformers, lighting transformers, small power transformers, and for the casting of electrical switch gear components.

**MIX RATIO**

20 parts H1026 hardener to 100 parts resin by weight  
 10 parts H2407 hardener to 100 parts resin by weight

1 part H1026 hardener to 3 parts resin by volume  
 1 part H2407 hardener to 6 parts resin by volume

UNCURED PROPERTIES			
	R1025	H1026 slow	H2407 medium
Physical State	Beige or Black liquid**	Amber liquid	Green liquid
Viscosity mPas@25°C	20,000-25,000	800-1000	150-200
Specific Gravity g/ml@25°C	1.65-1.70	0.96-0.98	0.98-1.00
Flash Point	155°C	195°C	100°C

\*\* Technirez Filled Casting Resin is available in beige or black, please specify when ordering

CURE CHARACTERISTICS		
	H1026	H2407
Pot Life - 100g @25°C (in air)	60-90 minutes	40-50 minutes
Cure Time 100g @25°C	24-36 hours	16-24 hours
@50°C	8-12 hours	5-8 hours
@70°C	4-6 hours	2-3 hours
Mix viscosity mPas@25°C	4000-5000	5000-6000

CURED PROPERTIES		
	H1026	H2407
Tensile Strength	28 MPa	38 MPa
Compressive Strength	65 MPa	110 MPa
Flexural Strength	18 MPa	60 MPa
Flexural Modulus	2000 MPa	7000 MPa
Heat Distortion Temperature	45°C	55°C
Coefficient of Expansion mm/mm °C x 10 <sup>-6</sup>	55	55
Moisture Absorption 10 days @ 20°C % weight gain	0.6	0.32

ELECTRICAL PROPERTIES*		
	H1026	H2407
Volume Resistivity (OHMS/cm @ 25°C)	1x10 <sup>15</sup>	2x10 <sup>15</sup>
Minimum Dielectric Strength Hz (KV/mm @ 50Hz @ 25°C)	16-18	16-18
Dielectric Constant (50Hz @ 25°C)	4.1	3.2
Power Factor Tan (50Hz @ 25°C)	0.019	0.011
@ 60°C	0.177	0.010

\* Typical values- not to be construed as specification

### APPLICATION

The resin and hardener must be accurately measured and thoroughly mixed before application to disperse any filler that may have separated during transportation – 4 to 5 minutes. This can be achieved by using a low speed drill.

Care should be taken to avoid excessive air entrapment and to ensure that no unmixed resin or hardener is left on the sides, or the bottom, of the container, as this can lead to soft spots in the casting.

*With ambient temperature at 25°C, a full kit of resin and hardener mixture must be poured into place within 10 minutes.*

PACK SIZES				
Order Code		Order Code		PACK
Resin		Hardener		
RC1025	5 kg	HC1026	1 kg	6 kg
RD1025	25 kg	HD1026	5 kg	30 kg
		HD2407	5kg	
		HE1026	20 kg	
		HE2407	25 kg	

### STORAGE

TECHNIREZ R1025 resin and H1026 and H2047 hardeners will keep for 2 years if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

### HEALTH AND SAFETY

TECHNIREZ R1025 resin and H1026 and H2047 hardeners have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
  - If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.
  - If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
  - If swallowed:
- Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.
- Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 17/08/06

