

HI-POLY 629 A/B Epoxy Dip Coating

Product Information Sheet

For reference only, not for specification use

DESCRIPTION:

A two-part thixotropic Epoxy Dip Coating for a variety of applications. It is supplied in neutral color. Colorant to be added by users to suited their requirement.

USES:

Designed to coat or dip coat on ornaments and electronic parts, . It serves as a protective coating and produces a glossy surface.

ADVANTAGES:

- Excellent bonding with glossy surface
- High hardness with flexibility
- Chemical and water resistant.

PACKAGING:

Packaged in kits as pre-proportioned batches for error-free job site mixing and application.

SURFACE PREPARATION:

In general, the surface to be resurfaced or bonded must be clean, sound, dry and above 10°C to assure an optimum bonding. All surface contaminants must first be thoroughly removed by chemical and/or mechanical means.

PHYSICAL PROPERTIES:

Mixing ratio (by weight.): A : B = 100 : 30

	Part A	Part B	Test Method
Color	Off White	Semi-translucent	Visual
Solids Content, %	100	100	ASTM D115
Flash Point, °C	>100	>100	ASTM D3278
Specific Gravity	1.24	0.97	ASTM D792
Viscosity (cps)	58,000	31,800	ASTM D2393
Shelf life @ 25°C (Starting from Invoice Date)	1 year		-

* All measurements taken @25°C unless otherwise noted.

CURED PHYSICAL PROPERTIES	HI-POLY 629	Test Method
Color	Colorant to be added by user	Visual
Coefficient of Linear Thermal Expansion, °C ⁻¹ (25°C to 100°C) (70°C to 200°C)	65 x 10 ⁻⁶ 190 x 10 ⁻⁶	ASTM D3386
Glass Transition (Tg), °C	60	ASTM D3386
Specific Gravity	1.17	ASTM D792
Hardness, Shore D	80	ASTM D2240
CURED ELECTRICAL PROPERTIES	HI-POLY 629	Test Method
Dielectric Constant @25°C, 1 KHz	4.7	ASTM D150
Volume Resistivity @500V, Ohm-cm	2.1 x 10 ¹³	ASTM D257
Surface Resistivity @500V, Ohm	1.5 x 10 ¹⁶	ASTM D257
Dissipation Factor @ 5 °C, 1 KHz	0.010	ASTM D150

* All measurements taken @25°C unless otherwise noted.

For Industrial Use Only

KEEP OUT OF THE REACH OF CHILDREN.

APPLICATION:

1. By appropriate dispensing tools, brush or dip coat.
2. Weight accurately; any variation in mix ratio will result in degraded properties
3. Use only in ventilated area
4. Use fume mask and gloves
5. Avoid skin contact (Part B is CORROSIVE!)
6. Part B is heat & moisture sensitive. Leaving the can open during long application will lead to yellowing of the coating and decrease in shelf life.
7. If sediment is found in Part A, mix well separately before mixing with Part B

Caution: Avoid large mass., severe exotherm may occur!!

8. Because of the high purity, crystallization may occur if the storage temperature is < 20 °C. Customer can heat the Part A in an oven, until the Part A appears complete fluid. This method will not affect the properties of the material. Completely cool down the material before mixing.

Suggested Temperature & Time

Weight	Oven Temperature	Time
1 kg	60 °C – 80 °C	1 – 2 hr
10 kg	60 °C – 80 °C	3 – 4 hr

CURING SCHEDULE:

Curing Time	HI-POLY 629A/B
Full Cure in Oven @ 80 °C	1-2 hr
Full Cure @ 25 °C	2 days

CLEAN UP:

Tools should be cleaned immediately after use with soap and water. Solvents such as Xylol or paint thinner can also be used. But care should be taken before using any flammable & hazardous solvents.

DISPOSAL:

Dispose in accordance with local regulations. Use licensed hazardous waste company.

Empty containers may contain product residue, including flammable or explosive vapor. Do not cut, puncture or weld on or near container. All label warnings must be observed until the container has been properly disposed of.

Storage:

- Part B is heat & moisture sensitive, store in a cool, dry place.
- Mixed materials cannot be stored for future use.
- Shelf life would be shortened if the container had ever been opened.
- Shelf Life (fulfilling above requirements): approximate 1 year

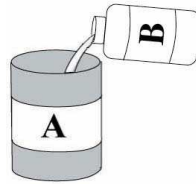
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Mixing & Storage of Epoxy

Mix the materials according to the mixing ratio (by weight)

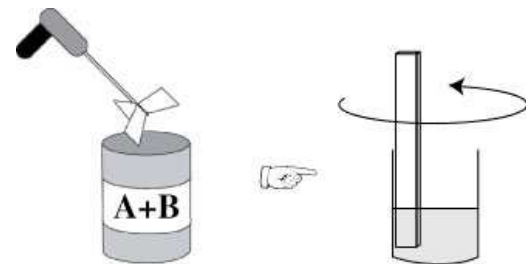
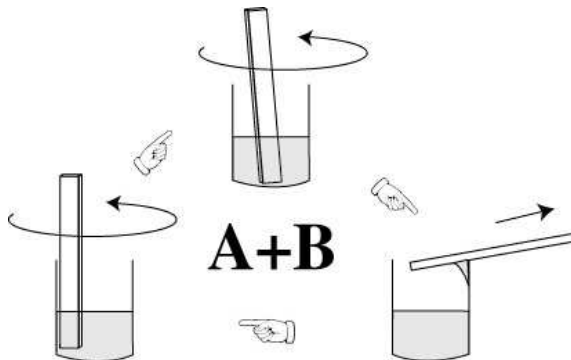
After mixing, curing process will be started.
Calculate the ideal mixing amount according to the designated pot life. ^{P.S.2.}



Empty Part B entirely into the can of Part A

Manual Mixing

Electrical Mixing



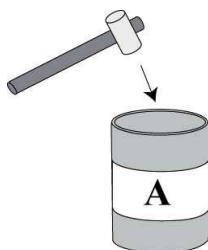
- * Perpendicularly stir with a paint paddle
- * Mix the material thoroughly, including the sediment and material sticking on inner of the can. Repeat thrice
- * Mixing for 2-3 minutes until completely blended

- * Stir with a Jiffy Mixer
- * Scrape the material sticking on the can's inner into the mixed component
- Repeat mixing

- P.S.:**
1. Avoiding produce bubbles during mixing. Bubbles can be reduced by vacuumizing.
 2. Pls. refer to the relevant technical data sheet for particular product's pot life.

Storage

- * Unmixed materials should be gastightly stored



Safety

- * Use only in ventilated area
- * Use fume mask and gloves
- * Wear goggles
- * Use within the pot life or the mixed component will produce severe exotherm

