TECHNICAL DATASHEET

ergo.® 7350
(ergo.® 7348 resin + ergo.® 7349 hardener)

Product - Description
The special property of this white, flowing two-component epoxy resin is its very slow curing behavior at room temperature, which makes it suitable for potting of big volumes and for coating of big areas. The cured product shows a hard and glossy white finish.

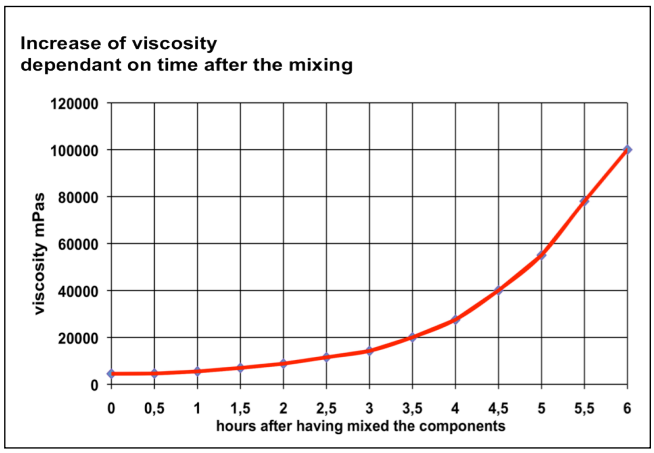
Advantages
- low odor
- slow-curing behavior
- cures to a dry and glossy film
- good flowing property, self-levelling
- may be used either as coating or as a potting compound
- free of solvents, 100% reactive material

Physical Properties - Liquid product

Chemical base:		Epoxy resin
Viscosity in accordance to DIN 54453		
(Cone-plate-system, cone C-50, shear rate of 100 s-1 , 25 °C)		
	Resin (ergo.® 7348):	20.000 - 25.000 mPas
	Hardener (ergo.® 7349):	80 - 120 mPas
	Mixture (ergo.® 7350):	4.000 - 5000 mPas
Density	Resin (ergo.® 7348):	1,30 g/cm³
	Hardener (ergo.® 7349):	1,05 g/cm³
Colour	Resin (ergo.® 7348):	white
	Hardener (ergo.® 7349):	light yellow to pale brown
	Mixture (ergo.® 7350):	white
Shelf life		24 month at RT

Curing

Curing system	2-component-product (ratio 5:1 (w:w))
Potlife of a 100 g mixture:	~ 2 hours at 23°C

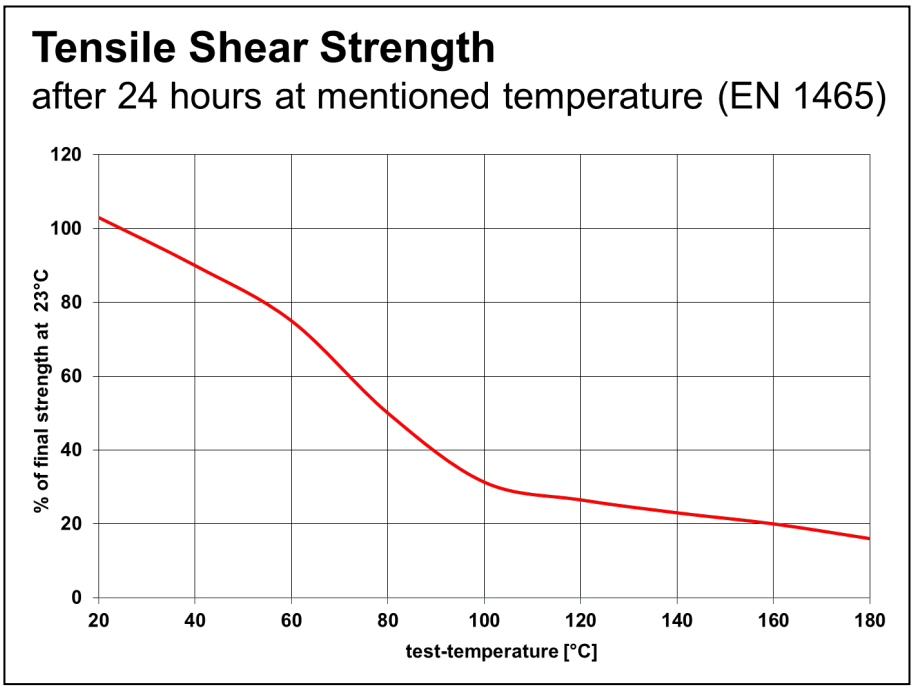


Final strength	7 days, 23°C / 16 hours, 40°C / 1 hour, 80°C

Physical Properties - Cured product
(After 7 days at room temperature)

Tensile shear strength, according to EN 1465:	
Aluminium	≥ 10 N/mm2
Steel	≥13 N/mm²
Polycarbonate	2 N/mm²
ABS	4 N/mm²
PVC, hard	1,5 N/mm²
PA 6.6	1,5 N/mm²
Shore D – hardness	80 – 85
Thermal range	- 40° C to + 180° C

Tensile shear strength on steel, depending on temperature
(Curing 7 days at 23°C / Storage: 24 hours at test-temperature)



Long-term properties at increased temperature
(Curing 7 days at 23°C / Storage: below mentioned time at +150°C)

Testing: after cooling down to room temperature (23°C):

100 hours @ +150°C	250 hours @ 150°C
142%*	142%*

*compare to the reference at 23°C

Electrical properties

Breakdown voltage	28.7 [KV/mm]
Creep resistance CTI	> 600 [V]

Others

The cured material fulfils the test-requirements according to ISO 10933-5 (Cytotoxicity) and acc. to ISO 10933-10 (skin irritation test)

Instruction of use

In order to receive a homogenous and reactive mixture, mix 5 parts by weight of resin ergo.® 7348 and 1 part by weight of hardener ergo.® 7349 very thoroughly. The shorter the time between mixing and using, the lower will be the viscosity Details are shown in the curve of reaction on page 2.
Apply the mixture on one surface and distribute it as a uniform film-layer. A notched trowel is a helpful and supporting tool. Join the parts and protect them with fixing elements (clamps for instance) against movement until the product is really cured. Heating will shorten the curing-time. If the product shall be used as potting compound, use it immediately, but at least within the first hour after mixing.

ergo.® 7348 has the ability to crystallize at temperatures below 20 °C. This is a product specific property and completely reversible. A possible crystallization of this adhesive does not indicate any quality issues.
To avoid the possible crystallization we recommend to store ergo.® 7430 not below 20 °C over a long period of time.
To secure proper workability and reverse a potential crystallization, before usage this product should be tempered for 24 hours at 40 °C.

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