

ER1138 Epoxy Resin

ER1138 is a multi-purpose, two part potting and encapsulation compound with excellent adhesion properties making it suitable for application in thin films.

- Excellent adhesion to a wide variety of substrates
- Ideal for adhesive applications where applied in thin films
- Good bond strength even in harsh conditions, including certain chemical environments
- Excellent electrical properties; can be used for encapsulation as well as bonding applications

Approvals	RoHS-2 Compliant (2011/65/EU):	Yes
	UL Approval:	No

Typical Properties

Liquid Properties:	Base Material	Epoxy
	Density Part A - Resin (g/ml)	1.16
	Density Part B - Hardener (g/ml)	0.97
	Part A Viscosity (mPa s @ 23°C)	11000
	Part B Viscosity (mPa s @ 23°C)	14000
	Mixed System Viscosity (mPa s @ 23°C)	12000
	Mix Ratio (Weight)	2:1
	Mix Ratio (Volume)	1.67:1
	Usable Life (20°C)	65 mins
	Gel Time (23°C)	~ 2 hours
	Cure Time (23°C)	24 hours
	Cure Time (60°C)	4 hours
	Cure Time (100°C)	1 hour
	Colour Part A - Resin	Clear
	Colour Part B - Hardener	Clear Amber
	Storage Conditions	Dry Conditions: Above 15°C, Below 30°C
	Shelf Life	24 Months (bulk) 18 months (resin pack)
	Exotherm	< 35°C
	(Measured on 100ml sample in a cylinder of diameter 49.4mm @ 23°C)	
	Shrinkage	< 0.5%

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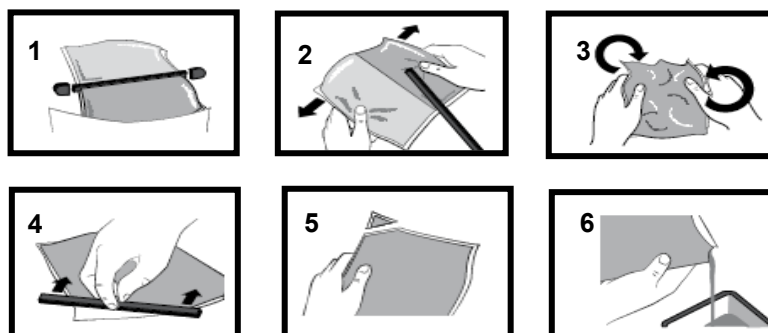
Ashby Park, Coalfield Way,
Ashby de la Zouch,
Leicestershire LE65 1JR
T +44 (0)1530 419 600
F +44 (0)1530 416 640
BS EN ISO 9001:2008
Certificate No. FM 32082

Cured System:	Thermal Conductivity (W/m.K)	0.20
	Cured Density (g/ml)	1.08
	Temperature Range (°C)	-40 to +120
	Max Temperature Range (Short Term (°C)/30 Mins) (Application and Geometry Dependent)	+140
	Dielectric Strength (kV/mm)	12
	Volume Resistivity (ohm-cm)	10 ¹⁴
	Shore Hardness	A95
	Colour (Mixed System)	Clear Amber
	Flame Retardancy	No
	Tensile Strength (MPa)	45-50
	Compressive Strength (MPa)	90
	Deflection Temperature (°C)	35
	Coefficient of Expansion (ppm/°C)	100
	Loss Tangent @ 50 Hz	0.01
	Permittivity @ 50 Hz	4.50
	Comparative Tracking Index	Not Measured
	Water Absorption (9.7mm thick disk, 51mm diameter) 10 days @ 20°C / 1 hour @ 100°C	< 0.5% / < 1%
	Elongation At Break	2.5%

Mixing Procedures

Resin Packs

When in Resin pack form, the resin and hardener are mixed by removing the clip and moving the contents around inside the pack until thoroughly mixed. To remove the clip, remove both end caps, grip each end of the pack and pull apart gently. By using the removed clip, take special care to push unmixed material from the corners of the pack. Mixing normally takes from two to four minutes depending on the skill of the operator and the size of the pack. Both the resin and hardener are evacuated prior to packing so the system is ready for use immediately after mixing. The corner may be cut from the pack so that it may be used as a simple dispenser.



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Bulk Mixing

When mixing, care must be taken to avoid the introduction of excessive amounts of air. Automatic mixing equipment is available which will not only mix both the resin and hardener accurately in the correct ratio but do this without introducing air. Containers of Part A (Resin) and Part B (Hardener) should be kept sealed at all times when not in use to prevent the ingress of moisture. Bulk material must be thoroughly mixed before use. Incomplete mixing will result in erratic or partial curing.

Additional Information

- Cleaning:** It is far easier for machines & containers to be cleaned before the resin has been allowed to cure. Electrolube's RRS is suitable for cleaning machines and containers and cured resin may be slowly softened and removed by soaking in our RRS.
- Storage:** When storing under very cold conditions, the hardener may crystallise. If this occurs, simply warm (40°C) the container gently until all crystals have re-melted.
- Health & Safety:** Always refer to the Health & Safety data sheet before use. These can be downloaded from www.electrolube.com

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