

# PX439N/NC

A thermally conductive flame retardant potting and encapsulating compound

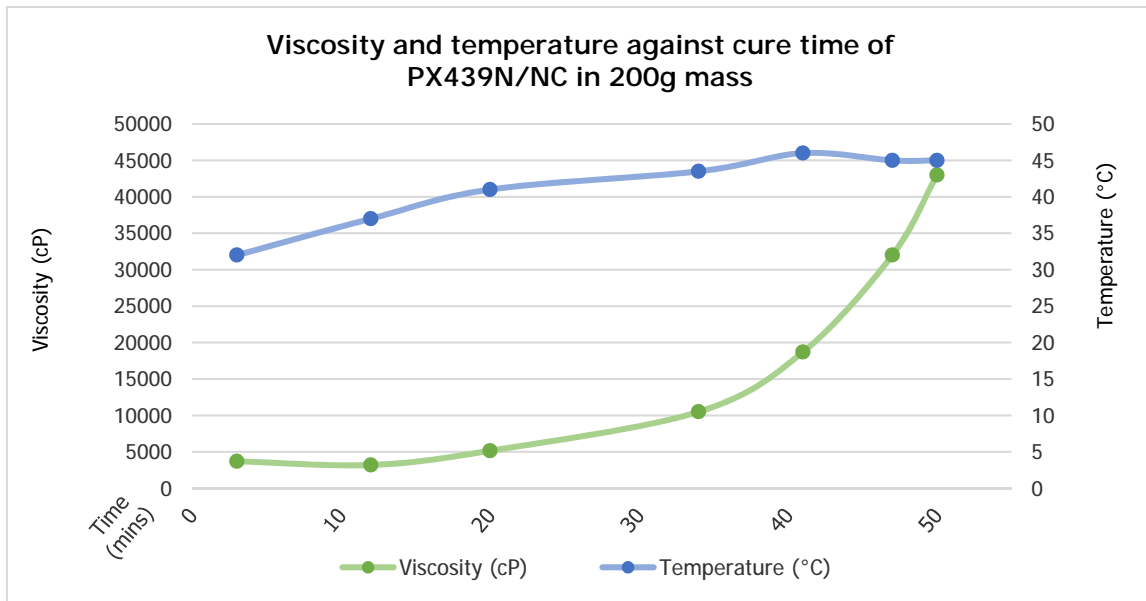
## Application Key Properties

- |   |  |
|---|--|
| <ul style="list-style-type: none"> <li>• Transformers</li> <li>• PCB</li> <li>• Control Modules</li> <li>• General potting and encapsulation</li> </ul> | <ul style="list-style-type: none"> <li>• Low shrinkage</li> <li>• High adhesion</li> <li>• Good chemical and water resistance</li> </ul> |
|---|--|

## Description

- Basic Two-component epoxy system
- Resin RX439N/NC (Natural colour White)
- Hardener HX439N/NC

Physical Data (approx. – values)	Resin	Hardener	Mixed
Colour	NC (Natural colour White)	Clear	White
Specific Gravity	2.05	0.94	1.90
Viscosity (mPas) @ 25°C	40000	110	7500
70°C	1200	30	1000



Cure Schedule (50ml)	Working Life	Gel Time	Light Handling	Full Cure
Temperature	(minutes)	(minutes)	(hours)	(hours)
RT	120	240	24	48
60°C	20	-	4	8
70°C	15	-	3	6
80°C	-	-	2	4

\*RT is defined as 20-25°C  
The above are typical values and will vary depending on the cured mass and application. Hotter temperatures may be used for faster cure but will result in higher post cure shrinkage and higher cure exotherm. Experimentation and testing is suggested to avoid side effects. For maximum properties a post cure may be required – Contact our technical service department for advice.

## Processing

Mix ratio by weight      13.31:1  
Mix ratio by volume      6.12:1

Approvals	
RoHS compliant	Yes
UL94 V-0	No
REACH (SVHC concentration)	0%

Typical Properties	Result	Unit
Peak Exotherm (150ml @ RT)	40	°C
Usable Life (50ml @ 70°C)	15	Minutes
Shrinkage (Volume)	0.3	%
Thermal conductivity	1.20	W/mK
Thermal expansion	35-45	
Operating temperature range	-55 to +150	°C (application & geometry dependent)
Dielectric strength	18	kV/mm
Volume Resistivity	1 x 10 <sup>12</sup>	ohm.cm
Surface Resistivity	1 x 10 <sup>13</sup>	ohm
Hardness	85	Shore D
Tensile strength	65	MPa
Compressive strength	80	MPa
Deflection Temperature	100	°C
Co-efficient of expansion	35 - 45	ppm/°C
Loss Tangent	0.045	@ 50 Hz
Permittivity	4.99	@ 50 Hz
Comparative tracking index	>850	V (Method IEC 60112)
Water absorption (30 days @ RT)	0.5	%
Elongation at break	1-3	%
Flexural strength	65	MPa
Tg	105-110	°C

### Packaging

PX439N is available in Bulk, Twinpacks, kits and sets

### Availability

Available through distribution, [www.resins-online.com](http://www.resins-online.com) and [sales@robnor.co.uk](mailto:sales@robnor.co.uk)

Twinpacks	
PX439N/NC/100	PX439N/NC/1000
PX439N/NC/250	

Twinpacks are pre-weighed resin and hardener components contained in a tough flexible film, separated by a removable clip and rail. Once the clip and rail is removed the resin and hardener is thoroughly mixed within the bag and is immediately ready for use. Mixing will normally take ~ 3 minutes due to the viscosity; but pay special attention to the corners. Twinpacks are ideal for small to medium production runs, prototyping and on-site or field use. The twinpack weight/volume may also be tailored to a specific size on request. For further details please visit [www.robnor-resinlab.com](http://www.robnor-resinlab.com)

Bulk Materials	
RX439N/NC/5KG	HX439N/NC/5KG
RX439N/NC/25KG	

Both resin and hardener are supplied fully evacuated and ready for use. Care should be taken to ensure when mixing the resins air is not entrained in the mixture. If this is unavoidable the mixed resin and hardener should be re-evacuated before dispensing. The bulk resin and hardener materials can be dispensed from suitable dispensing machinery, details provided by Fluid Research on request.

Kits and Sets	
PX439N/NC/10KGKIT	

Kits and Sets are provided in separate containers to the correct ratio. In Kit form, pour the contents of the smaller container into the larger container and use it as a mixing vessel. Stir well using an appropriate mixer until homogeneous.

Note: Incomplete mixing will be characterised by erratic or partially incomplete cure even after extended time periods.

## Cleaning

All equipment contaminated with mixed material should be cleaned before the material has hardened. TS130 is a suitable non-flammable cleaning agent, although other solvents may be found suitable. TS130 will also remove cured material provided it can soak for several hours.

## Shelf-life and Storage

24 months at 25 °C Specialty packaging may be less.

Many epoxy resin systems are prone to crystallization as epoxy resin is a super-cooled fluid. This condition may give the product a gritty or grainy appearance (or hazy in clear products). Products in this state will not usually cure to normal and expected properties. In extreme cases it may appear solid and cured. Fluctuating temperatures (within 5 to 50°C) aggravate this phenomenon. Heating the individual component to 50 to 60°C while stirring can usually restore products to original state. Storage at 25 +/- 10°C is optimum for most products

Some epoxy systems are prone to settling due to high filler content and should be inverted every two to three weeks to reduce the accumulation of the fillers on the bottom of the containers.

Inventory should be rotated on a FIFO (first in, first out) basis.

## Health and Safety

Please refer to RX/HX439N Health and Safety data or our Technical Service Department for individual/specific advice.

## Copyright & Warranty - Robnor Resinlab Limited

The results and information above does not constitute a specification and is given in good faith and without warranty. The information is derived from test/or extrapolations believed to be reliable and is quoted for guidance only. The product is offered for evaluation on the understanding the customer satisfies himself that the product is suitable for the intended application by proper evaluation and testing.

## Contact Details

Robnor Resinlab Limited	Tel:	+44 (0) 1793 823741
31 Athena Avenue	Fax:	+44 (0) 1793 827033
Elgin Industrial Estate	Email:	<a href="mailto:support@robnor.co.uk">support@robnor.co.uk</a>
Swindon	Web:	<a href="http://www.robnor-resinlab.com">www.robnor-resinlab.com</a>
SN2 8EJ	Buy Online:	<a href="http://www.resins-online.com">www.resins-online.com</a> (UK only)
United Kingdom		