



- TECHNICAL DATA SHEET -

**DOLPHON POLYESTER RESIN XL-2102 OPT
CLASS H**

DESCRIPTION

DOLPHON XL-2102 OPT is a high-reactive, one-package, 100% solids polyester resin, specifically formulated for the trickle and roll-through impregnation of armatures, rotors and stators. Here are some outstanding features of this resin:

- It does not contain formaldehyde, styrene, vinyltoluene;
- Very low weight loss on cure;
- Very low odor;
- Excellent wetting properties;
- Good bond strength;
- Fast curing cycles;
- UL approved resin for Thermal Class H (file E 51047).

CHARACTERISTICS

Physical properties

Specific gravity at 25°C	1.150±50 gr./lt
Viscosity Ford Cup n.4 at 25°C	100-150"
Flash Point (PMCC)	> 130°C
Gel Time at 100°C	8-20'
Weight loss (gr.15 of resin, from 100 to 140°C for 20')	< 1,3%

Mechanical properties

Bond Strength: Helical Coil method ASTM D-2519	Temperature	Kg. to break
(Test performed on MW35 magnet wire - coils baked 1 h. at 150°C)	25°C	18

Electrical properties

Dielectric Strength ASTM D-115	> 3200 Volts/mm. 0,025
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Heat resistance

DOLPHON XL-2102/OPT has a heat life of 20.000 hours at 180°C determined by ageing test performed following the ASTM D-3251 method (twisted pairs) using polyester amide-imide magnet wire.



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APPLICATION

- ROLL-THROUGH (approximate suggestions)
 1. Roll the rotor in the resin at room temperature.
 2. Bring rapidly the rotors to a temperature of 140°C to gel the resin, by means of induction heating.
 3. Bake for 30' about at 140-150°C.

- TRICKLE (approximate suggestions)
 1. Preheat armatures (or stators) to 115-120°C about (real temperature measured on the unit).
 2. Trickle the resin on the unit, keeping it in slow rotation.
 3. Bake for 20-30' about at 150-160°C.

STORAGE AND STABILITY

The shelf-life of XL-2102/OPT is more than 18 months at room temperature (max 30°C). Store the resin in a cool place, protect from direct sunlight and keep away from heat sources.

WARNING: DOLPHON XL-2102/OPT fears the light and is sensible to U.V. rays. When the product is not used the dipping tanks must be protected from light with covers. The exposition to the light, even for a few hours, may cause a partial gelling on the resin surface.

Warning: All the information and application instructions concerning this product are based on technical specifications that we consider reliable, and are provided by way of example, according to our application experience. They do not establish any guarantee but only represent a starting point subject to alterations, according to the application and the kind of material to be treated. Before the product's use the utilizer must determine the suitability for the intended use undertaking all risks and responsibility for whatever may happen in connection with the application. The producer and/or seller will not be considered responsible for any accident, loss or damage (immediate or consequent) originating from the use and/or the inability to use the concerned product. Albesiano Sisa Vernici srl reserves the right to change or modify at any time and without any notice the technical specifications of the product described in this data sheet.

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