

# Arathane<sup>®</sup> Polyurethane Casting System

Arathane <sup>®</sup> CW 5620	Polyol		100	pbw
Arathane <sup>®</sup> HY 5611-1	Isocyanate		22	pbw

**Polyurethane, halogen free, casting and impregnating system for processing and curing at room temperature. Soft multipurpose polyurethane system for pressure sensitive devices. Available in various colors.**

## Application

Transformers, filters, capacitors etc.

## Processing methods

Casting / Impregnating.  
Manually or with automatic mixing and dosing equipment.

## Key Properties

Halogen free system.  
Excellent flow properties.  
Good thermal conductivity.  
Non abrasive casting system.  
Good thermal shock resistance.  
Flammability: UL 94 V-0 (6 mm).

## Product Data (Guideline Values)

### Arathane® CW 5620

Polyol, containing mineral filler

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Viscosity at 25°C	Brookfield	mPa*s	2500
Specific Gravity at 25°C	ISO 1675	g/cm <sup>3</sup>	1.42
Flash point	ISO 1523	°C	> 150
As supplied form	Colored liquid.		

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### Arathane® HY 5611-1

Isocyanate

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Viscosity at 25°C	ISO 2555	mPa*s	210
Specific Gravity at 25°C	ISO 1675	g/cm <sup>3</sup>	1.23
Flash point	ISO 1523	°C	> 200
As supplied form	Brown liquid.		

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## Processing Data (Guideline Values)

### Mix Ratio

		Parts by weight	Parts by volume
CW 5620	Polyol	100	100
HY 5611-1	Isocyanate	22	25

### Gel Time, Viscosity and Curing

Mix Viscosity at 25°C	CW 5620 / HY 5611-1	Rheomat	mPa*s	1700
Gel time at 25°C	CW 5620 / HY 5611-1	Gelnorm	min	60
Pot life (Time to reach 5000 mPa*s)	CW 5620 / HY 5611-1	Rheomat	min	20
Minimum Curing Cycle	24 hours at RT or 6 hours at 80°C			

## Processing and Storage (Guideline Values)

### Preparation

CW 5620 contains fillers, which tend to settle over time. It is therefore recommended to carefully homogenize the complete contents of the container before use.

In the storage vessels of the production equipment, the pre-filled products should be stirred up from time to time to avoid sedimentation and irregular metering.

### Mixing

Brief degassing of the mix under 2 – 10 mbar vacuum improves the mixture homogeneity and enhances the dielectric properties of the castings. Mixing of the components can be done at room temperature, heating of the polyol is not required.

### Curing

To determine whether crosslinking has been carried to completion and the final properties are optimal, it is necessary to carry out relevant measurements on the actual object or to measure the glass transition temperature. Different gel and cure cycles in the customer's manufacturing process could lead to a different degree of crosslinking and thus a different glass transition temperature.

### Storage Conditions

Store the components in a dry place at RT, in tightly sealed original containers. Under these conditions, the shelf life will correspond to the expiry date stated on the label. After this date, the product may be processed only after reanalysis. Partly emptied containers should be tightly closed immediately after use.

HY 5611-1 must be protected from moisture. Storage tanks should be blanketed with dry air or nitrogen. Storage at temperatures above 50°C is not recommended, since this can lead to the formation of insoluble solids and also the viscosity build-up increases on extended storage. Storage at low temperature is not recommended because it may lead to some crystallisation. Crystallised material must be melted out immediately by short time heating. For information on waste disposal and hazardous products of decomposition in the event of a fire, refer to the Material Safety Data Sheets (MSDS) for these particular products.

## Mechanical and Physical Properties (Guideline Values)

Determined on standard test specimen at 23°C. Cured for 24h/RT + 6h/80°C

Glass transition temperature	ISO 6721	°C	30
Shear modulus	ISO 6721	MPa	200
Max. service temperature	IEC 60085		Class B
Relative temperature index	IEC 60216	RTI	tbd
Tensile modulus	ISO 527	MPa	30
Tensile strength	ISO 527	MPa	8
Elongation at break	ISO 527	%	65
Thermal linear coefficient	ISO 11359-2		
Alpha 1		ppm/K	65
Alpha 2			160
Thermal conductivity	ISO 8894-1	W/mK	0.5
Hardness	DIN 53505	Shore A / D	90 / 50
Flammability	UL 94		V-0 (6 mm)
Water absorption	ISO 62/80		
1 day at 23°C		% by wt.	0.15
10 days at 23°C			0.5
30 min at 100°C			0.33

## Electrical Properties (Guideline Values)

Determined on standard test specimen at 23°C. Cured for 24h/RT + 6h/80°C

Dielectric strength (2 mm specimen)	IEC 60243-1	kV/mm	25
Dielectric loss factor (tan $\delta$ , 50Hz, 25°C)	IEC 60250	%	11
Dielectric constant ( $\epsilon_r$ , 50Hz, 25°C)	IEC 60250		6
Volume resistivity ( $\rho$ , 25°C)	IEC 60093	$\Omega$ cm	$10^{13}$
Electrolytic corrosion	IEC 60426	grade	A/1
Tracking resistance	IEC 112/79	CTI	> 600

# Industrial hygiene

Mandatory and recommended industrial hygiene procedures should be followed whenever our products are being handled and processed. For additional information please consult the corresponding Safety Data Sheets and the brochure "Hygienic precautions for handling plastics products".

## Handling Precautions

Safety precautions at workplace:

protective clothing  
gloves  
arm protectors  
goggles/safety glasses  
respirator/dust mask

Yes.  
Essential.  
Recommended when skin contact likely.  
Yes.  
Recommended.

Skin protection:  
before starting work  
after washing

Apply barrier cream to exposed skin.  
Apply barrier or nourishing cream.

Cleaning of contaminated skin

Dab off with absorbent paper, wash with warm water and alkali-free soap, then dry with disposable towels. Do not use solvents.

Clean shop requirements

Cover workbenches, etc. with light coloured paper. Use disposable beakers, etc.

Disposal of spillage

Soak up with sawdust or cotton waste and

Ventilation:  
of workshop  
of workplace

deposit in plastic-lined bin.

Renew air 3 to 5 times an hour.  
Exhaust fans. Operatives should avoid inhaling vapors.

## First Aid

Contamination of the **eyes** by resin, hardener or casting mix should be treated immediately by flushing with clean, running water for 10 to 15 minutes. A doctor should then be consulted.

Material smeared or splashed on the **skin** should be dabbed off, and the contaminated area then washed and treated with a cleansing cream (see above). A doctor should be consulted in the event of severe irritation or burns. Contaminated clothing should be changed immediately.

Anyone taken ill after **inhaling** vapours should be moved out of doors immediately. In all cases of doubt call for medical assistance.

## Note

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All recommendations for use of our products, whether given by us in writing, verbally, or to be implied from results of tests carried out by us are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefore. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.