



- TECHNICAL DATA SHEET -

**DOLPHON XL-2112@
POLYESTER RESIN**

DESCRIPTION

DOLPHON XL-2112@ is a one-package, very low VOC polyester resin specifically formulated for dipping impregnation either in open tanks or in vacuum chambers. Hereafter the main features of this resin:



- UL approved (File OBOR2.E317427 and OBJS2.E317429)
- Excellent wetting properties
- Good bond strength
- Very low weight loss on cure
- Very low odour
- Relatively fast cure cycles
- Medium-low viscosity

TYPICAL APPLICATION

Stators	Traction Coils	Transformers
Rotors	Inductances	Other devices

CHARACTERISTICS

Physical properties	
Density, @ 25°C	1.150±30 g/l
Viscosity, Brookfield @ 25°C	1700-2000 cps
Gel Time, 100°C	30-50'
Weight loss (10 g of liquid resin, cured 1 h. at 150°C)	< 3,5%
Thermal conductivity	0,25-0,30 W/mK

Mechanical properties		
Bond strength - Helical Coil method, IEC61033 method B (Test performed with MW 35 magnet wire - double impregnation - coils baked 1 h. at 150°C)	Temperature	N at break
	25°C	>130
	80°C	>82
	155°C	>45

Electrical properties	
Dielectric Strength on a 25 microns thickness film, ASTM D-115	>3100 Volts
Volume Resistivity, IEC 60464 part 2	>10 ¹⁵ Ω·cm
Volume Resistivity after 7 days of water immersion, IEC 60464 part 2	>10 ¹² Ω·cm
Surface Resistance, IEC 60464 part 2	>10 ¹⁵ Ω
Dielectric constant at 25°C, ASTM D-150	3,2
CTI according to IEC 60112	600 M



Thermal class according to UL 1446	
Magnet Wire	Twisted Pairs
MW 16-C	220°C
MW 35-C	200°C

Chemical resistance		
Water absorption, ASTM D 570	90' at 100°C < 1.5% 24 h at 25°C < 1%	
Resistance to vapors of solvent, IEC 60464 part 2	Xylene Methanol Hexane	Resistant Resistant Resistant
Resistance to chemicals, 7 days of immersion, ISO175	Hydrochloric acid 10 %	< 2.5 %
	Sulfuric acid 30%	< 1.5 %
	Green gasoline	< 1.5 %
	Oil Transformer	< 0.5 %
	Detergent solution	< 1.5 %

APPLICATION GUIDELINES

DOLPHON XL-2112@ can be applied both under vacuum and in open dip tanks at atmospheric pressure. For application in open dip tanks or with conveyor systems the following cycle is suggested:

1. Preheat the units at 50-60°C (maximum);
2. Dip into the resin for 30-60';
3. Drain for 1 h. minimum;
4. Bake 2 ½ hours at 150°C, or 2 h. at 160°C or 75' at 170°C (time must be taken after units reach the baking temperature).

For the VPI application the cycle must be set for each plant, please consult with us.

STORAGE AND STABILITY

DOLPHON XL-2112@ is sensitive to UV rays. When not in use, the impregnation tanks must be protected from the light by means of a (non-transparent) lid. Exposition to sunlight can cause a partial gelification of the tank surface.

Dolphon XL-2112@ is supplied pre-catalyzed. The shelf-life is 12 months at room temperature (max 30°C). Store the resin in a cool place, protect from direct sunlight and keep away from heat sources.

DOLPHON XL-2112@ reacts with bare copper, copper alloys and natural rubbers; it is therefore not advisable using these materials in the impregnating plant construction.

HANDLING PRECAUTION

Our products don't require particular precautions excepting for those normally taken when chemicals are used. For more details, see the MSDS.

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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