

Technical Data Sheet

Secondary Insulation

Ripley™ E 468-2FC

Single-Component Epoxy Impregnating Resin

Ripley™ E 468-2FC

Product Description

Ripley™ E 468-2-FC is a single-component, heat-cured, 100% solids epoxy impregnating resin.

Areas of Application

The Ripley™ E 468 product line is the industry standard for impregnation of transformers of all sizes

Features and Benefits

- Flexible for excellent noise suppression
- No catalyst required
- High flash point
- UL recognized insulation systems up to Class 240

Application Methods

- Vacuum-Pressure Impregnation
- Vacuum Impregnation
- Dip-and-Bake

Transportation / Storage

Store below 25°C / 77°F in a dry controlled environment out of direct sunlight. This material should be suitable for use stored under these conditions in the original sealed containers for six (6) months from the date of shipment.

Usable life may be extended by refrigerated storage at 5°C / 41°F.

For best results, VPI storage tanks should have a replenishment rate of 10% or more per month and employ cooling systems to maintain the resin at 20°C / 68°F or below. ^[1]

Mix thoroughly before use

Health / Safety

Refer to the Material Safety Data Sheet.

See ELANTAS PDG Technical Bulletin *TI-100 Handling Precautions for Epoxy Resins* for additional information.

Typical Properties of Material as Supplied

Property	Conditions	Value	Units
Viscosity	25°C / 77°F	300 – 1000	cP
Weight per Gallon	25°C / 77°F	8.4 – 8.8	pounds
Sunshine Gel Time	135°C / 275°F	10 – 20	minutes
Flash Point	ASTM D93	> 94 > 201	°C °F
Volatile Organic Content	ASTM D6053-96	0.5 ^[2]	pounds / gallon

^[1] Precatalyzed resin systems such as Ripley™ E 468-2FC normally tend to body with extended storage and use. Tanks without chillers or with minimal turnover may require the occasional addition of fresh resin. See ELANTAS PDG Technical Bulletin *TI-4002 - VPI Epoxy Resin Maintenance* for additional information.

^[2] VOC test methods and limits vary widely by regulatory jurisdiction and product application. The value above was obtained by curing a thin film under specific laboratory conditions (2 grams - 1 hour - 150°C). Contact your ELANTAS PDG representative regarding alternate methods.

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Processing / Curing Schedule

See ELANTAS PDG Processing Guides for Vacuum Pressure Impregnating (VPI) Epoxy Resins - PG-104 (Wet Vacuum), PG-105 (Dry Vacuum) and PG-115 – Vacuum Impregnating (VI) Epoxy Resins for Transformers.

NOTE: While preheating may be used to set tapes, remove moisture and stress-relieve magnet wire, units should be allowed to cool to room temperature before immersion to minimize bodying of the resin.

Cure treated units for 4 hours at 135°C / 275°F – or – 3 hours at 150°C / 302°F

The cure schedules above are based on time after the unit reaches the specified temperature and are recommendations only. The user is responsible for determining the optimum cure conditions for his application.

Typical Mechanical Properties

Specimens cured 3 hours at 150°C / 302°F

Property	Test Method	Conditions	Value	Units
Shore D Hardness	ASTM D2240	25°C / 77°F	55	
Glass Transition Temp.	ASTM E831	TMA	38	°C
Coefficient of Thermal Expansion	ASTM E831	Below Tg Above Tg	150 250	ppm / °C ppm / °C

Typical Electrical Properties

Property	Test Method	Conditions	Value	Units
Dielectric Strength	ASTM D149	0.25 mils – 25°C / 77°F	6400	volts/mil
Dielectric Strength	ASTM D149	0.25 mils – 25°C / 77°F After 24 hours in water	5400	volts/mil
Dissipation Factor	ASTM D150	1 kHz – 25°C / 77°F	0.02	
Dielectric Constant	ASTM D150	1 kHz – 25°C / 77°F	3.0	
Volume Resistivity	ASTM D257	25°C / 77°F	5.1 x 10 ¹⁵	ohm-cm

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UL Recognized Insulation Systems (ELANTAS File E87039)

Thermal Class	System
Class 130	DASH 2: B-1, B-2, B-2Z, B-2Z-1, B-5, B-8, B-10, B-11, B-13, B-14, B-19, BR-1, BR-2, PDG 12, PDG 116
Class 155	DASH 2: F-1, F3, F4, F-4A, PDG 117
Class 180	DASH 2: H-1, H-2, H-3, H-4, H-5, H-8, HR-1, HR-2, HR-3, HR-4, PDG 14, PDG 180 High Voltage
Class 200	DASH 2: N-1, N-2, N-3, N-4, N-6, N-2HV, PDG 10, MEGA IV
Class 220	DASH 2: R-1, R-2, R-3, R-5, HV-1, HV-2, PDG 8, PDG 220-1, PDG 220 High Voltage, PDG 15
Class 240	DASH 2: S-1

The above properties are typical values and are not intended for specification use.

ELANTAS PDG, Inc. warrants the chemical composition of its products within stated tolerances, but does not guarantee that a product will be appropriate for any particular application. Any recommendation, performance of tests or suggestion is offered merely as a guide and is not a substitute for a thorough evaluation by the user. No representative of ELANTAS PDG, Inc. has the authority to offer a warranty that a product will perform satisfactorily in manufacturing a product and no such representation should be relied upon.