



EPOXY RESIN, POTTING COMPOUND

ESF-M3L75-A

1. SCOPE

The material defined by this specification is a two-part 100% reactive epoxy resin.

2. APPLICATION

This specification was released originally for material used in conjunction with ESF-M96B67-A Silica Sand, as a potting compound for the TWC feedback engine control.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.1 To be run on each lot of material.

3.1.1 Viscosity, Brookfield RVF (ASTM D 2393, # 2 spindle at 10 rpm)

Resin	1500 – 2500 MPa.s
Hardener	1400 – 2600 MPa.s
Mixed	1400 – 2400 MPa.s

3.1.2 Specific Gravity (ASTM D 792)

105-107

3.1.3 Gel Time at 120 °C, min (ASTM D 2471, 25 mm cube sample)

15 – 25

3.1.4 Hardness, Durometer A (ASTM D 2240, 15 s dwell)

40 – 50

To be run for initial approval and as required by Quality Control.

3.2 To be run for initial approval and as required by Quality Control.

3.2.1 Water Absorption, max (ASTM D 570, 24 h)

1%

3.2.2 Weight Loss, max (168 h at 120 °C)

0.5%

3.2.3 Dielectric Strength, min (ASTM D 149)

100 kV/cm

Date	Action	Revisions
2003 06 30	Revised	Para 3.0 inserted; Para 3.3, 3.4, 3.5, 3.6, 3.7, 4 deleted
1991 10 28	DF00E00107002080	Inactivated ESF-M3L75-B, Updated A L.P. Rumao
1979 04 12	CF4H-RD 57221331	Released (Was XF-M3L27)

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5. GENERAL INFORMATION

The information below is provided for clarification and assistance in meeting the requirements of this specification.

5.1 SHELF LIFE

6 months when stored at or below 25 °C.

5.2 SALT SPRAY (ASTM B 117)

No effect after 1000 h

5.3 DIELECTRIC CONSTANT (ASTM D 150 at 1 MHz)

4.5

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