

# COLTECH R 3610

**TECHNICAL DATA SHEET**  
Date: 15.05.2019 – Version 19

## Transparent Epoxy Insulating Resin

### Product description

COLTECH R 3610 is a transparent, two component, solvent free, low viscosity, UV stable, rigid Epoxy electroinsulating Resin. It provides excellent durability, chemical resistance properties with minimum shrinkage.

Cures by reaction (cross linking) of the two components at room temperature.

### Advantages

- Solvent free
- Rigid
- Crystal clear (Water white)
- UV stable, Non-Yellowing
- Cold curing
- Good adhesion to cables, plastics and metal
- Excellent hydrolytic stability
- Low exothermic reaction temperature
- Cold curing, Minimum shrinkage
- High impact strength
- Chemical and hydrocarbon resistant

### Uses

The COLTECH R 3610 is a transparent, rigid, Epoxy electronicsulating resin for:

- Production of LED lighting for exterior applications
- Multi purpose, transparent potting applications

### Consumption

1,1 kg / liter

### Colors

The COLTECH R 3610 is supplied Transparent

### Technical Data \*

PROPERTY	RESULTS	TEST METHOD
Composition	Epoxy Resin + Hardener. Solvent free.	
Mixing Ratio	A : B = 4 : 1 by weight	
Hardness (Shore D Scale)	70	ASTM D 2240
Solids Content	100 %	CALCULATED
Temperature strength	60°C (Fully cured)	IN HOUSE LAB
Low Temperature Brittleness	-20° C (Fully cured)	IN HOUSE LAB
Pot Life	15 min	Conditions:20°C,50%RH
Tack Free Time	3-5 hours	
Initial Curing Time	24 hours	
Final Curing time	7 days	

### Chemical Properties

Water	+	Hydrochloric acid 5%	+
Potassium hydroxide 5%	+	Domestic Detergents	+
Sodium hydroxide 5%	+	DMSO, NMP	-
Salt water 20%	+	Xylene	±
{+ stable, - unstable, ± stable for a short period.}			

## Application

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### Surface Preparation

Before adhering make sure that all surfaces to be used are free of any trace of moisture (Maximum surface moisture content should not exceed 4%). Also make sure that the surface is not contaminated with oils, grease, dust, lubricants, release agents and other impurities that could prevent the adhesion.

### Manual Mixing & Application

Stir COLTECH R 3610 Component A well before using. Stir COLTECH R 3610 Component B well before using.

COLTECH R 3610 Component A and Component B should be mixed by low speed mechanical stirrer, according to the indicated mixing ratio in this technical data sheet, for about 1-3 min if applied manually. When mixing, care must be taken to avoid the introduction of excessive amounts of air. After mixing of the Components A+B, transfer the mixture in a second clean container and mix again for 15-20 sec. Following to that we recommend to use a Vacuum Chamber (@-1bar for 60-120 sec) to remove any air bubbles from the mixture prior to use.

**ATTENTION:** The mixing of the components has to be performed very thoroughly, especially on the walls and bottom of the pail until the mixture becomes fully homogeneous and streak free. Please ensure consumption within the Pot Life. Containers of Part A (Resin) and Part B (Hardener) should be kept hermetically sealed at all times when not in use to prevent the ingress of moisture. Never use if the viscosity of the adhesive/resin is starting to rise as this is a sign that the end of the Pot Life is reached and the resin should not be used any more.

**WARNING:** Incomplete mixing or use of the wrong mix ratio will result in erratic or partial curing. Containers of Part A (Resin) and Part B (Hardener) should be kept sealed at all times when not in use to prevent the ingress of moisture. If moisture ingress, the resin mixture will create foam while curing. Containers of Part A (Resin) and Part B (Hardener) should be kept stored at a Temperature between 10-30°C. When storing under very cold conditions, the hardener may crystallise. If this occurs, simply warm (40°C) the container gently until all crystals have re-melted.

Apply COLTECH R 3610 resin by manual pouring or dispensing equipment to the object to be potted.

**RECOMMENDATION:** Before use or change in surface to be adhered make an adhesion test to make sure that adhesion is optional.

**RECOMMENDATION:** Use Postcuring in an heating apparatus (@50-60°C for 2-24h) to accelerate curing and lower final curing time.

## Plural Component Machine Mixing & Dispensing

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Automatic mixing equipment is available which will not only mix both the resin and hardener accurately in the correct ratio but do this without introducing air. Set the automatic, plural component machine for both parts (Component A and Component B) at a temperature higher than 18°C. Make sure that the Component A is constantly under low speed (50-100 RPM) agitation.

### Packaging

Pails should be stored in dry and cool rooms for up to 9 months. Protect the material against moisture and direct sunlight. Storage temperature: 5<sup>o</sup>-30°C. Products should remain in their original, unopened containers, bearing the manufacturers name, product designation, batch number and application precaution labels.

After opening of the pails,

### Safety measures

Please study the Material Safety Data Sheet. **PROFESSIONAL USE ONLY**

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Our technical advice for use, whether verbal, written or in tests, is given in good faith and reflect the current level of knowledge and experience with our products. When using our products, a detailed object-related and qualified inspection is required in each individual case in order to determine whether the product and/or application technology in question meets the specific requirements and purposes. We are liable only for our products being free from faults; correct application of our products therefore falls entirely within your scope of liability and responsibility. We will, of course, provide products of consistent quality within the scope of our General Conditions of Sale and Delivery. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. Values in this technical data sheet are given as examples and may not be regarded as specifications. For product specifications contact our R+D department. The new edition of the technical data sheet supersedes the previous technical information and renders it invalid. It is therefore necessary that you always have to hand the current code of practice.